FOREVER
DIGITAL TRANSFER APPLICATIONS TECHNOLOGY
nothing's impossible

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Transfer Instructions for:
FOREVER Laser-Dark (No-Cut) LowTemp
for BLACK & DARK COLORED TEXTILES

2-PAPER-SYSTEM
For LED-Printers With & Without White Toner

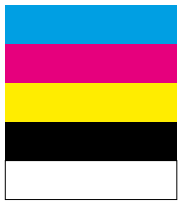
PRINTABLE FILE FORMATS:

.EPS .PSD .TIFF
.PDF .JPG .PNG

SUPPORTED FILE FORMATS

Generally, all common file formats can be used when printing with a White Toner OKI printer on to our transfer media. If you are not using **TransferRIP**, we recommend printing from CorelDraw. CorelDraw can import most of the popular file formats. For example, you can create and save your designs in any Adobe program or create and print directly from CorelDraw. Printing detailed designs from Photoshop requires more effort and is only possible with high-end graphic computers.

Example
Test Sheet



Printing with
INTACT
image drums

Printing with
a **WORN**
Magenta
image drum

BEFORE YOU PRINT

- Switch on your device.
- Go into the Calibration Menu, select **"Reg. Adjust"** and confirm to correct the color registration.
- Print a **test design**, preferably, with the primary colors Cyan, Magenta, Yellow, Black/White (if you do not have one at hand, please refer to our website at www.forever-ots.com)
- A **worn drum** may lead to poor toner coverage. When the message **"Image drum near end of life"** appears, we recommend that you observe the print quality of the respective color closely and to have a spare drum ready just in case.

IMPORTANT:
FOR CMYK DESIGNS WITHOUT WHITE TONER
Please note the Color Density (on the right) which is needed to achieve optimal results.

80%	90%	100%
80%	90%	100%
80%	90%	100%
80%	90%	100%

PRINTER SETTINGS:

USE THE **MULTI-PURPOSE TRAY** FOR FEEDING AND THE REAR OR SIDE TRAY FOR COLLECTING	OKI ES7411WT/ C711WT/PRO7411WT & OKI ES9420WT/ C920WT/PRO920WT	OKI PRO8432WT	OKI ES9541DN OKI C941DN	OKI LED CMYK	OKI PRO 6410 NEON COLOR
PRINT MODE	Transparency	**UserType 1**	Transparency	Transparency	Transparency
PAPER FEED	Multi-Purpose-Tray	Multi-Purpose-Tray	Multi-Purpose-Tray	Multi-Purpose-Tray	Multi-Purpose-Tray
COLOR SETTINGS:		COLOR PAPER SETTING: +2			
CYAN	0	0	Use only with FOREVER TransferRIP5C	0	0
MAGENTA	+2	+2		0	0
YELLOW	+1	+1		0	0
WHITE	-3	+3		-	0
BLACK	-	-		0	0

IMPORTANT: FOR ES7411WT / C711WT - If you have used a different print mode other than "transparent foil", turn off your printer completely for at least 20 Minutes before printing on A-Foil.

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RASTERIZING PHOTOS & GRAPHICS FOR A SOFT TOUCH

- *Why do we recommend rasterization?*
  Reason: Even photos or designs with a background can be transferred with Laser-Dark (No-Cut) LowTemp. In this case, we recommend to rasterize the design to achieve a soft touch on the fabric. With the help of our "**TransferRIP**" software, you can rasterize your design with a few clicks and benefit from many other features.
  A rasterized design on the fabric feels even softer than a screen print and has also extremely good wash-fastness. Since the surface is limited to the raster points, a rasterized print has much better washability than a print with larger or full-scale areas.

TEXTILE SELECTION

- *Always select a less stretchy fabric when working with cotton fabrics (no spandex or lycra).*
  Reason: This helps to prevent cracking when pulling or stretching the fabric apart.

TRANSFER PRESS

- *If excisting, remove the Teflon sheet from the upper and lower plates of your heat press.*
  Reason: Teflon absorbs too much heat and leads to faulty and inconsistent results.

- *Make sure that your silicone pad is faultless and is glued to the lower plate.*
  Reason: If the upper and the lower plate of the heat presses are not touching each other in a pure vertical movement, but also partially in a horizontal (slide) movement, this may lead to an incomplete transfer of the B-Coating to the A-Foil, especially by large, full-scale designs or pictures. This might happen due to a mechanical fault, where the closing device is worn out, loosened or defect.

- *Make sure that the press has reached the set temperature on the heat plate. Leave your Swing-Away press closed until the lower metal plate is hot to the touch.*
  Reason: Only with sufficient heat on both plates, can you get consistent results. We advise that you keep your Heat Press in the closed position when not in use. This keeps the Lower Plate hot and ready for your next application.

- *The bottom silicone pad of your heat press should not be too soft.*
  Reason: Extremely Soft silicone pads might lead to problems in the separation of A & B Media.

- *Always place the transfer media in the middle of your heat press.*
  Reason: Some heat presses do not have uniform heat and pressure distribution on the edges. The further you go to the edges, the more likely processing errors will occur, due to this lack of pressure on and around these areas.

SEPARATION OF THE A & B MEDIA

- *It is necessary to leave the A & B Media on the press during the separation.*
  Reason: Otherwise, cold air will flow under the media and will cause the transfer to cool down rapidly. If the media cools down too fast, parts of the design may transfer from your A-Foil to the B-Paper LowTemp which is not desired.

- *Do not separate the A & B Media too fast.*
  Reason: A too fast separation may lead to torn-out areas on round edges or other critical areas in your design.

- *Separate the A & B Media in a flat and constant motion.*
  Reason: The media remains flat on the press and the separation works perfectly.

- **Please note following information during the separation of print-outs from the OKI ES9541DN/C941DN:**
  The CMYK colors consists of polymer toner. This kind of toner stays longer hot than crushed toner which is used in the other OKI White Toner Printers. Therefore it is important to rub strongly with a piece of textile for 3-5 seconds all over the B-Paper to remove some residual heat, before starting the separation of A and B.

TRANSFER TO THE SUBSTRATE

- *Tape all four corners of the transfer (A-Foil) with a heat resistant tape.*
  Reason: While opening the press or removing the textile from your press, it may happen that the corners of the A-Foil lift up from the fabric. This leads to undesired hot-peeling and to incomplete and faulty edges.

AFTER THE PRESS PROCESS

- *Peel the A-Foil when absolutely cold.*
  Reason: If you remove the A-Foil while still warm, it will lead to an incomplete and faulty transfer.

WASHING: Up to 40°C (cold wash cycle). Do not use bleach. Do not tumble dry.

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1. PRINT

- Print your design in **Mirror Image Mode** onto the **Matt Side** of the **A-Foil.**

2. HEAT PRESS

- Place the **A-Foil** in the middle of the lower plate (Printed side **facing up**).
- Place the **B-Paper LowTemp** on top of the A-Foil (coated side **facing down**).
- Cover with a sheet of **Silicone or Baking Paper.**

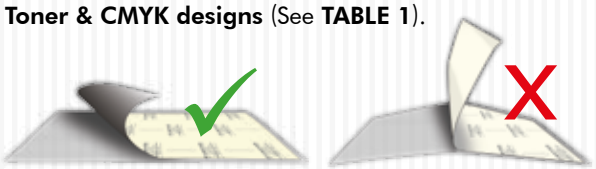
The **B-Paper LowTemp can be cut slightly smaller than the A-Foil.** This prevents your transfer press from becoming dirty.

NOTE: It is possible that on unprinted areas some kind of white spots are appearing after pressing it with the B-Paper. To avoid that, put 5 sheets of normal copy paper onto the B-Paper.

3. TRANSFER B-PAPER TO A-FOIL

- Press the A-Foil & B-Paper together at **150°C (300°F)** for **90 seconds** with **2-3 bar (29-43.5 psi) medium pressure**.

Increase the time to **120 seconds for full-scale White Toner & CMYK designs** (See **TABLE 1**).



- Separate the B-Paper LowTemp from the A-Foil without lifting them up from the lower plate of your heat press. Please work in a **SLOW, LOW & FLUID MOTION**.
- Cut around your design to remove the coating frame caused by the bleeding of the B-Paper LowTemp.

4. APPLICATION TO TEXTILES & OTHER SUBSTRATES

- Place the textile or another substrate on the lower plate of the heat press.
- **Fix the transfer** by taping the corners of the A-Foil with **Heat Resistant Tape**.
- Press using the parameters shown in **TABLE 2**.
- Remove the A-Foil after it is **completely cold**.

5. FIXING

- To ensure a **Matt Finish** and **Good Washability**, it is absolutely **important** that you repress with a sheet of *Matt Finish Economy* (See **TABLE 3**).

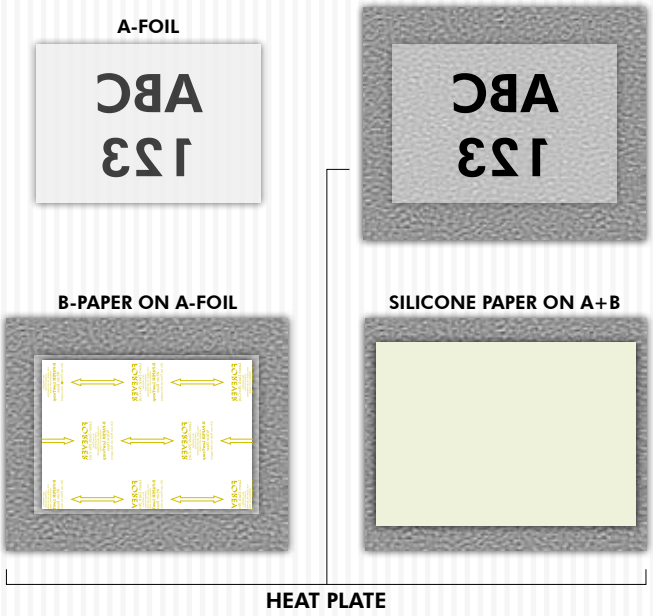


TABLE 1: B-PAPER TO A-FOIL

	°C °F		
OKI WHITE TONER	**150 - 160°C 300 - 320°F**	**90 - 120 sec.**	**2 - 3 Bar 29 - 43.5 PSI**
CMYK	**150 - 160°C 300 - 320°F**	**120 sec.**	**2 - 3 Bar 29 - 43.5 PSI**

IMPORTANT: Different CMYK printer manufacturers use different types of toner. The settings above are only reference values! Finding out the optimal temperature and time requires experimentation.

TABLE 2: TEXTILES & OTHER SUBSTRATES

	°C °F		
COTTON	150 - 160°C 300 - 320°F	30 sec.	2 - 3 Bar 29 - 43.5 PSI
POLYESTER	120 - 130°C 248 - 266°F	30 sec.	2 - 3 Bar 29 - 43.5 PSI
POLYPROPYLEN	105°C 220°F	30 sec.	2 - 3 Bar 29 - 43.5 PSI
BLEND FABRIC	140 - 150°C 285 - 305°F	30 sec.	2 - 3 Bar 29 - 43.5 PSI
PAPER/CARTON	100°C 210°F	15 sec.	1 - 2 Bar 14.5 - 29 PSI
BOOK COVERS	110 - 120°C 230 - 250°F	15 sec.	1 - 2 Bar 14.5 - 29 PSI

TABLE 3: MATT FINISHING + FIXING

COTTON (FULL-SCALE)	150 - 200°C 300 - 392°F	30 Sec.
COTTON (RASTER/VECTOR)	150 - 160°C 300 - 320°F	10 Sec.
POLYESTER	120 - 130°C 248 - 266°F	10 Sec.

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Transfer Instructions for:

FINISHING with Hot Stamping Foils & Transfer Flock

ONLY FOR LASER-DARK (NO-CUT) A-FOIL & OKI WHITE TONER PRINTERS

TRANSFER SETTINGS:

	°C / °F		
B-PAPER TO A-FOIL	**155°C / 310°F**	**90 sec.**	2 - 3 Bar / 29 - 43.5 psi / **medium pressure**
TRANSFER TO TEXTILE	**155°C / 310°F**	**5 - 10 sec.**	2 Bar / 29 psi / **low pressure**
HOT STAMPING FOIL	**155°C / 310°F**	**30 - 45 sec.**	5 Bar / 72.5 psi / **high pressure**
TRANSFER FLOCK	**200°C / 390°F**	**120 sec.**	5 Bar / 72.5 psi / **high pressure**

HSF FINISHING WITH HOT STAMPING FOILS:

PREPARATION OF THE TRANSFER:
- **Print** your design using **CMYK BLACK** (4-Color-Black*) & **Press** with B-Paper (See Table above).
- **Separate** the B-Paper from the A-Foil while HOT, in a **Slow, Low & Fluid Motion**.
- **Cut** around your transfer to remove the coating frame.

TRANSFER TO TEXTILE
- **Place** the transfer on your textile & **press** together (See Table above).
- **Wait** until the **textile has completely cooled down**, BEFORE removing the A-Foil!

APPLYING THE HOT STAMPING FOIL
- **Place** the desired sheet of Hot Stamping Foil on your design, cover it with a sheet of **Matt Finish Economy** & **press** together (See Table above).
- **Wait** until the Hot Stamping Foil has **completely cooled down**, BEFORE removing.
- Wash resistant up to 40°C (Cold Wash Cycle).

TIP: Use a textile to rub over the finished design to remove left-over HSF particles!
* 4-Color-Black consists of 100% Cyan, 100% Magenta, 100% Yellow and 100% White!

ATTENTION: We recommend Swing-Away and Pneumatic Presses! It is important to use heavy pressure for the best results!

FLOCK FINISHING WITH TRANSFER FLOCK:

PREPARATION OF THE TRANSFER:
- **Print** your design in the **same color as the Flock Sheet** & **press** with B-Paper (See Table above).
- **Separate** the B-Paper from the A-Foil while HOT, using a **Slow, Low & Fluid Motion**.
- **Cut** around your transfer to remove the coating frame.

TRANSFER TO TEXTILE
- **Place** the transfer on your textile & **press** together, preferably with 5 sheets of **copy paper** in between (See Table above).
- **Wait** until the **textile has completely cooled down**, BEFORE removing the A-Foil!

APPLYING THE TRANSFER FLOCK
- **Place** the desired sheet of Flock Sheet on your design and cover it with a sheet of **Matt Finish Economy** & **Press** together (See Table above).
- **Wait** until the Flock has **completely cooled down**, BEFORE removing.
- Wash resistant up to 30°C (Cold Wash Cycle).

IMPORTANT: White Flock is only recommended for **Hard Surfaces or Non-Washable Materials**.

WHITE
BLACK
SILVER GREY
ANTHRAZIT GREY
BORDEAUX
KELLY GREEN
CITRONE YELLOW
DARK YELLOW
ORANGE
PINK
CARMEN RED
ICE BLUE
TURQUOISE
ROYAL BLUE
NAVY BLUE

ATTENTION: It is important to use heavy pressure for best results! Please use fleece to cover your shirt to avoid yellowing!