

Transfer Instruction for:  
**FOREVER Laser-Dark (No-Cut) A-Foil & B-Paper LowTemp**  
 2-Paper-System for LED-/ Laser-Printers with & without White Toner

21.05.2014

## 1. FILE FORMATS

Generally, all common file formats can be used to print with a white toner OKI printer on our transfer media. However, 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.

**Printable File Formats:**  
 .psd .cdr .eps .pdf  
 .png .indd .ai

## 2. 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.de)
- 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.

Example for a test sheet:



Printing with a worn Magenta image drum



Printing with intact image drums



### IMPORTANT FOR CMYK DESIGNS WITHOUT WHITE TONER

- Please note the Color Density (on the right) which is needed to produce and achieve optimal results.

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

## 3. PRINTER SETTINGS

**USE FOR TRANSPARENCY ONLY THE SIDE OR REAR BIN**

**OKI ES7411WT/  
OKI C711WT**



**OKI ES9420WT/  
OKI C920WT**



**OKI ES9541/  
OKI C941**



**OKI LED  
CMYK**



Print Mode:	Transparency	Transparency	Transparency	Transparency
Paper Feed:	Multi-Purpose-Tray	Multi-Purpose-Tray	Multi-Purpose-Tray	Multi-Purpose-Tray
Color Setting:				
Cyan	● 0	● 0	● +3	● 0
Magenta	● +2	● +2	● +3	● 0
Yellow	● +1	● +1	● 0	● 0
White	○ -3	○ -3	○ +3	○ 0
Black			● 0	● 0

The color settings should be adjusted to generate brilliant and vivid colors with FOREVER Transfer Media.

### **Important for ES7411WT/C711WT:**

*If you have worked in a different print mode than transparent foil, turn off your printer completely for at least 20 Minutes before printing on A- Foil.*

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#### 4. RASTERIZING OF PHOTOS & GRAPHICS FOR A SOFT TOUCH

- **Why do we recommend rasterization?**

Even photos or designs with a background can be transferred with Laser-Dark (No-Cut). In this case, we recommend to rasterize the design to achieve a soft touch on the fabric. With the help of our software „TransferRIP“, 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 is much better washable, than a print with larger/full-scale areas.

#### 5. TEXTILE SELECTION

- **Always select a less stretchy fabric when working with cotton fabrics (no spandex or lycra)...**

...to prevent cracking when pulling/stretching the fabric apart.

#### 6. TRANSFER PRESS

- **If existing, remove the teflon sheet of the upper and lower plate from 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 incomplete transfer of the B-Coating to the A-Foil, especially by large, full-scale designs or pictures. This might happen due to a wrong construction as well as in cases, where the closing device is worn out, loosened or defect.

- **Make sure that the press has reached the set temperature on the heat plate. Then, close your press for 30-60 seconds to pre-heat the lower plate. This step should be done before beginning to work or after long brakes.**

Reason: If you follow the above step, you can be sure that the lower plate definitely has the desired temperature. You can only reach consistent results with an adequately heated lower plate.

- **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- and B- media.

- **Always place the transfer media in the middle of your heat press.**

Reason: Some heat presses do not have uniform heat & pressure distribution on the edges. The further you go to the edges, the more likely processing errors will occur, due to the lack of pressure on/around these areas.

#### 7. SEPARATION OF 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- media to the B paper which is not desired.

- **Do not separate the A & B Media with a harsh movement.**

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.

#### 8. TRANSFERING 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.

#### 9. 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.

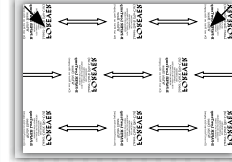
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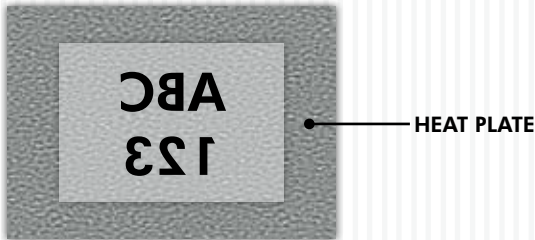
1. Print your design in mirror image mode onto the A-Foil.



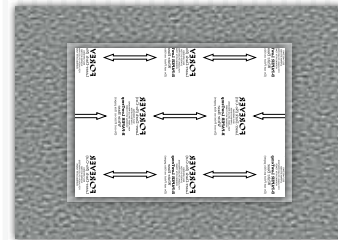
2. Please note, that the B-Paper LowTemp is slightly smaller than the A-Foil on purpose. This prevents your transfer press from getting dirty.



3. Place the A-Foil directly on the top of the lower plate (printed side showing up).











4. Place the B-Paper LowTemp (coated side showing down) on top of the A-Foil.



5. Put a sheet of paper over the B-Paper LowTemp, to avoid messing your heat plate.

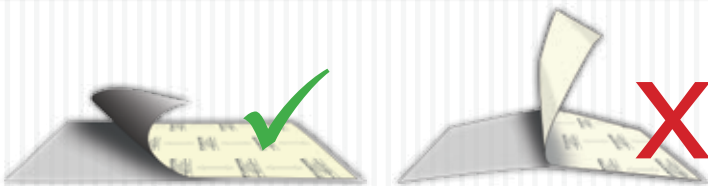


6. Press all together at **150°C (300°F)** for **90 sec.** with **3-4 bar** pressure. Increase the time to **120 sec.** by full-scale White Toner designs.

	 <b>150°C</b> <b>300°F</b>	 <b>90-120 sec.</b>	 <b>3-4 bar</b>
	 <b>130-150°C</b> <b>265-300°F</b>	 <b>90-120 sec.</b>	 <b>3-4 bar</b>

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

7. 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 AND FLUENT** motion.



8. Cut around your design to get rid of the coating frame caused by the bleeding of the B-Paper LowTemp.



9. Place the textile or another substrate on the lower plate of the heat press. Tape the corners of the A-Foil with heat resistant tape to fix the transfer.



10. Press with the following parameters:

Cotton:	<b>140 - 150°C (285-300°F)</b> for <b>30 sec.</b> , <b>5 bar</b>
Polyester:	<b>130-140°C (265-285°F)</b> for <b>30 sec.</b> , <b>5 bar</b>
Polypropylen:	<b>105°C (220°F)</b> for <b>30 sec.</b> , <b>5 bar</b>
Blend Fabric:	<b>140-150°C (285-300°F)</b> for <b>30 sec.</b> , <b>5 bar</b>
Paper/Carton:	<b>100°C (210°F)</b> for <b>15 sec.</b> , <b>1-2 bar</b>
Bookcover:	<b>110-120°C (230-250°F)</b> for <b>15 sec.</b> , <b>1-2 bar</b>

11. Remove the **A-Foil** after it is absolutely cold.

12. To ensure a matte finish and washability, it is absolutely **important** that you repress with a sheet of *Matte finish Economy* for:
- **Cotton:** 30 seconds at 180 - 200°C
  - **Polyester:** 10 seconds at 130 - 140°C