iColor® 1-Step CERAMIC Hard Surface Transfer Media Instructions

Part # ICHTHARDCER

The **iColor® 1-Step Ceramic Hard Surface Transfer Media** is an easy to use, substrate specific paper for use with ceramic, glass, crystal and acrylics. It features a thinner polymer that is easier to pull and does not leave a background on the substrate. **iColor® 1-Step Ceramic Hard Surface Transfer Media** does not require coated substrates like sublimation does. Press onto light and dark substrates, thanks to the adjustable white overprint layer when printing from the iColor TransferRIP software! The result is a vivid, long lasting image.

The **iColor® 1-Step Ceramic Hard Surface Transfer Media** was designed to serve as a substrate specific paper, but note that UniNet carries general use hard surface media, as well as other substrate specific media which may work better in specific situations with wood and leather.

Designed to work with the **iColor®** series of specialty printers, the **iColor® 1-Step Ceramic Hard Surface Transfer Media** will also work with many popular color laser printers – please check with your printer manufacturer to be certain. White toner enabled printers are suggested for best results.

Please follow the steps below for best results. Each substrate will have a slightly different technique. Refer to the applicable section as it pertains to your project.

1. Place transfer sheet into the multipurpose tray of the **iColor®** printer, white gloss coated side up.

2. In the **iColor® TransferRIP Software,** select the white toner profile and set your system to 'B' configuration. Be sure to select the page size of 'Letter' before importing your image. A white spot coverage (white overprint) of 300 - 400% with a 1 - 2 device pixel underfilling is suggested for best results.

3. Paper type should be 'Labels 2' and set the paper source to the 'Multi-purpose Tray'. 'Use screening from Printer' and select the 'Force Manual Tray' check box. For images with heavier toner coverage, it may be necessary to select 'Ultra Heavy' as the paper type. Remember to set the job to mirror print to ensure it looks correct when transferred to the front of the substrate. For clear acrylics, you can also transfer to the back of the substrate. In this case, do not mirror print and use a white underprint.

4. Print the image.

5. Set the temperature of the heat press to 300°F / 150°C for most applications. Refer to the matrix below for specifics.

6. When using a heat press: Place a piece of kraft paper on the lower plate. Align the substrate to the printed image and lay flat on the press, with the **iColor® 1-Step Ceramic Hard Surface Transfer Media** on top. You can tape the hard surface paper to the lower kraft paper for additional stability. Cover with a silicone pad (.5mm - 1mm is suggested for best results). For mug presses: Simply choose the appropriate sized sleeve, tape the transfer onto the mug with heat resistant tape (image facing the mug), insert the mug and press accordingly.

7. For most applications, press at 300°F / 150°C with medium high pressure. The duration of the press depends on the substrate used. Refer to the matrix below for specific press times and peeling method.

Surface	Time	Temp	Press Pressure	Peeling	Notes
Acrylic	60 Sec	300°F / 150°C	8 (Medium – High)	Cool	Place heavy object on top while on the press for 20 seconds to prevent warping if necessary. Remove, then peel once cool.
Glass / Crystal	60 Sec	300°F / 150°C	8 (Medium – High)	Cold	Wait for substrate to cool completely before peeling. Bake in convection oven at 360°F / 182°C for 20 mins. for increased durability.
Ceramic Mugs	180 Sec	300°F / 150°C	8 (Medium – High)	Cold	Wait 2 mins, then place substrate in cold water for 2 mins before peeling. Bake in convection oven at 360°F / 182°C for 20 mins. for increased durability. Handwash only.
Ceramic Tiles	180 Sec	300°F / 150°C	9 (High)	Cold	Wait for substrate to cool completely before peeling. Bake in convection oven at 360°F / 182°C for 20 mins. for increased durability.
Ceramic Tiles (Full Bleed)	300 Sec	300°F / 150°C	9 (High)	Cold	Wait for substrate to cool completely before peeling. Bake in convection oven at 360°F / 182°C for 20 mins. for increased durability.

If you make a mistake or are not happy with the finished result, use acetone to remove the transfer (before fixing in an oven). Not suggested for plastics or other materials that can be damaged.

TIPS

There are many variables that could produce different results. Specific steps may need to be altered based on:

• **Type and brand of Heat Press**: The temperature and duration varies slightly based on the heat press being used. All instructions are based on using a Hotronix Fusion press. Clam shell and swing away presses may also yield different results.

• **Type of substrate:** Some substrates may require more or less press time, depending on the material and the image being pressed.

• **Type of image**: Photos or full-color graphics may require a longer press time than vector images or text.

• **Toner Coverage**: Halftones in image may cause undesired results. Toner coverage should not be less than 50% otherwise there will be issues with transferring.

Halftones can be corrected by printing a white overprint or underprint using the **iColor® TransferRIP Software** to apply a white layer in one pass. This will help with toner coverage and proper adherence to the substrate.

The use of a silicon pad is necessary when using the Hard Surface Paper. All instructions are based on a .5mm pad, which is available from UniNet. Thicker pads (greater than 1mm) will require longer press times and higher temperatures. In these cases, the use of a thermometer can help to establish the best settings.

Use of kraft paper below and above your project is highly recommended. Only use kraft paper made for heat press applications! The use of butcher paper or other kinds not specifically designed for heat transfer applications can cause the image to stick to the paper.

If you are using tape to secure your image to the substrate, make sure the tape is not covering any part of the transfer, as that will lead to inconsistent results.

If a particular instruction is not working for you, try varying pressure, press time, higher or lower temp, longer or shorter dwell time. Larger graphics may require a longer press time.

To see video instructions for iColor® Ceramic Hard Surface Paper, visit www.icolorprint.com/video (Coming Soon)

Also available:

iColor® 1-Step CLASSIC and WOOD AND LEATHER Hard Surface Transfer Media
iColor® 1-Step LIGHT Transfer Media for light colored garments
iColor® 2-Step Standard Transfer Media for light and dark colored garments
iColor® 2-Step Premium and Premium STRETCH Transfer Media for light and dark colored garments
iColor® 2-Step Presto! Transfer Media for light and dark colored garments
iColor® 2-Step Temporary Tattoo Transfer Media
…and more! Contact your dealer for more information.

June 2017 Revision - A newer version of this manual may be available at www.icolorprint.com/support