



iColor® 2-Step *Premium* *STRETCH* Transfer Media Instructions **Part # ICHTSTRETCH (A4) / ICHTSTRETCHTAB (A3)**

| Temperature | Time | Paper Setting | Pressure |
|---------------|------------|----------------------|----------|
| 285°F / 140°C | 45 Seconds | Heavy or Ultra Heavy | 8 |

The **iColor® 2-Step Premium Stretch Transfer Media** set will allow you to transfer prints from the **iColor®** series of printers (including fluorescent white and fluorescent color prints) onto a variety of garments, especially dark fabrics and allow for extra elasticity on stretchy fabrics. A common problem in the industry is the stretchable limit of certain transfer papers. This new stretch product will give you added confidence in the ruggedness of your design and finished product. Added rasterization or breathability in your design, as well as using the garment color as a mask, will also add to the stretch limits. The white adhesive applied as a result of the 2-step process enhances the color of your print, and increases the adhesion to your garment for maximum durability, opacity and vibrancy on your finished product.

Similar to the **iColor® 2-Step Premium Transfer Media**, the **iColor® 2-Step Premium Stretch Transfer Media** has added elastic in the adhesive to allow for stretching, while maintaining its original shape. Print and press onto cotton, as well as many types of synthetic material such as nylon, polyester and poly-cotton blends without the risk of scorching or melting the fabric. Save time, money, and space. No need to purchase a second heat press when using the **iColor® Premium Stretch Transfer Media** system. The first and second presses share the same temperature, pressure and press duration so you don't have to wait for the press to change temperature.

The **iColor® 2-Step Premium Stretch Transfer Media** is a weed-free system, ensuring your time is not wasted picking and weeding your transfer prints, enabling you to produce detailed, quality images while dramatically reducing your production time.

Wash-tested up to 100 washes at 104°F / 40°C, your images will remain durable, vibrant and stretchable!

Designed to work with the **iColor®** series of specialty printers, the **iColor® 2-Step Premium Stretch 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.

The **iColor® 2-Step Premium Stretch Transfer Media** is used as a set, comprising of a 'Transfer Sheet' and an 'Adhesive Sheet'. Please follow the steps below for best results:

1. Place transfer sheet into the multipurpose tray of the **iColor®** printer, brighter white, slicker side up (please note this is the coated side of the sheet). You may need to stack a few sheets in the tray at once so the printer pulls the media cleanly.

Note: NEVER run the adhesive sheet through your printer. This will result in fuser failure.

2. Set the paper source to the 'Multi-purpose Tray'. Paper type should be 'Heavy' and the page size should be either 'A4' or 'A3', depending on the stock used. Remember to set the job to mirror print to ensure it looks correct when transferred to the garment. Note: more toner coverage may mean a change in paper type settings. Choose 'Ultra Heavy' for larger, denser images.
3. Print the image.
4. Once image is printed, place the adhesive sheet on top of the print, white (adhesive coated) side down - the image and the adhesive should be face-to-face.
5. Run the two sheets together through a laminator on a medium-high heat setting prior to pressing - this will ensure all air bubbles are removed and all adhesive is transferred during the pressing process. Do not use a carrier sleeve, run the paper directly through. Pull the edges of the papers outward and keep them taut as you feed them into the laminator to prevent any air from getting in between the sheets.
6. Fold a small corner of the adhesive sheet over, prior to pressing - this will make it easier to peel apart after pressing.
7. Press the two sheets together using a heat press at 285°F / 140°C for 45 seconds with medium-high pressure.
8. Open the press and while hot - immediately peel the adhesive sheet away from the transfer sheet diagonally in one smooth, quick, continuous motion. This should be done with the sheets on the press to minimize heat loss. The use of heat resistant gloves may help this process.
9. Observe the used adhesive sheet – you will see the adhesive was removed only where toner was present on the transfer sheet. If you see any part of your design on the adhesive sheet, you did not get a clean pull. Examine your transfer sheet to determine if the transfer is acceptable. Discard the used adhesive sheet.
10. Trim the edges away from the transfer sheet - this will ensure no excess adhesive sticks to the garment and eliminate the chance of a white box around your design.
11. Place your garment on the press. Position the transfer sheet (print side down) onto the garment. It is suggested that you use heat resistant tape to secure the sheet to the garment. Otherwise, opening the press can cause the transfer sheet to lift prematurely. For more precise placement, lay the garment out on a table, position the transfer sheet appropriately and tape the corners before placement on the press.
12. Cover the transfer sheet and garment with kraft paper or a Teflon sheet and press the garment using a heat press at 285°F / 140°C for 10 seconds with medium-high pressure.
13. Remove the garment from the heat press carefully and immediately lay flat. Allow it to cool for at least 5 minutes.
14. Once the garment is completely cooled, carefully peel away the transfer sheet in one smooth, continuous rolling motion. Removal while still warm could lead to an incomplete or faulty transfer. It is suggested that you start your pull from an area that has the most toner coverage. The image will adhere to the garment. Do not wait too long for this step (under one hour).
15. Re-Pressing (fixing) the image into the garment is important for wash durability. It is best to re-press the image for roughly 20 seconds at 285°F / 140°C with kraft paper on top of the image for a matte finish. The Teflon sheet can also be used for a glossy finish with a reduced press time of 15 seconds.
16. Wait a few seconds before removing the kraft paper (or Teflon sheet). Pull slowly in one smooth, continuous motion. It is important to wait before pulling the paper off, otherwise it could pull the design off the shirt! While the garment is still on the press and still hot, lightly stretch the material to allow the toner to soak into the fabric to prevent cracking

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 image:** Photos or full-color graphics may require a longer press time than vector images or text.
- **Type of garment:** Cotton, Polyester, and Spandex material all respond differently to heat. All instructions are based on cotton garments.
- **Toner Coverage:** Halftones in image may cause undesired results. Toner coverage should not be less than 50% otherwise there will be issues with transferring the adhesive to the transfer sheet.

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 printing a very densely covered page, it is suggested you choose "heavy" for the paper type to avoid a paper jam at the fuser. If you do get a paper jam, shut off the printer, remove the fuser and clear the jam, then print some test pages on regular paper to clear the excess toner out of the fuser. Then reprint with "heavy" paper settings.

During Step 7 of these instructions, it is important that the adhesive sheet is placed on top because a) The heat platen is on top so heat is transferred directly to the adhesive sheet instead of passing through the transfer sheet and b) When pulling them apart, the sheet on top tends to curl. If that was your transfer sheet, it would then be difficult to place on your garment and could be ruined if the image touched itself.

During Step 8, note that the denser your image, the more difficult it will be to pull the A & B sheets apart. Start out with less dense, weeded images to perfect your process. Full coverage images take some skill to successfully pull cleanly and may require a longer press time. Full coverage tabloid (A3) graphics are not suggested.

If some of your image isn't pulling properly during Step 14 of these instructions, start your pull from an area that has the most toner coverage. For example, don't start your pull from a dot or a small independent portion of your graphic. The more toner coverage, the higher the probability that you won't lose part of your image when getting started.

If your transfer and adhesive sheets are crinkled or buckled after running through the laminator, pull the edges of the paper outward and keep them taut as you feed them into the laminator to prevent any air from getting in between the sheets.

When fixing drifit or spandex material, use medium press pressure or the paper and toner will be driven into the material too much, causing cracking.

Halftones can be corrected by printing white on top of color (either running the sheet through the printer a second pass, or using the **iColor® TransferRIP Software** to apply a white layer in one pass). This will help with toner coverage and proper adherence to the garment.

There are many types of coatings and finishes applied to textiles and synthetic fabrics, so make certain adhesion is satisfactory and test for wash ability or scuff-resistance when applying transfer media to such materials.

It is recommended to wash finished garments inside out in cold or warm water and low agitation. For best result, hang to dry.

If there's a background transfer, reduce the transfer time or pressure. If there are areas which are not completely clean, it is recommended to press again with light pressure and kraft paper to weed out the undesired areas with coating transfer.

To see video instructions for iColor® Premium Stretch Transfer Media, visit www.icolorprint.com/video (Coming soon)

Also available:

iColor® 1-Step **CLASSIC**, **Premium**, **WOOD AND LEATHER** and **CERAMIC** Hard Surface Transfer Media

iColor® 1-Step **LIGHT** Transfer Media for light colored garments

iColor® 2-Step **Premium** Transfer Media for light and dark colored garments

iColor® 2-Step **Standard** 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