UNINET

IColor PAPER

IColor *Standard* 2-Step 550/800 Textile Transfer Paper Instructions

Part # ICHTSTDA550 / ICHTSTDB550 (8.27" X 11.69") (210 x 297mm)
Part # ICHTSTDA550LEG / ICHTSTDB550LEG (8.27" x 14") (210 x 356mm)
Part # ICHTSTDA800 / ICHSTDB800 (12.5" X 19") (327 x 482mm)

Temperature	Time	Paper Setting	Pressure
310°F / 154°C	120 / 30 Seconds	iColor 500/600: Transparency IColor 550/540: Thick to 163g IColor 800: Thick to 163g/220g	5

The IColor Standard 2-Step 550/800 Transfer Paper was developed specifically for the IColor 550 and 800 transfer printers, but **can be used interchangeably** with all other IColor printers when a thinner transfer sheet is needed.

This transfer paper set will allow you to transfer prints from the IColor series of printers (including white and fluorescent color prints) onto a variety of garments, especially dark fabrics. 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. Rasterization and breathability integrated into your design, as well as using the garment color as a mask, will enhance the stretch limit and softness of your finished product.

IColor Standard 2-Step 550/800 Transfer Paper works at a higher temperature as compared to the IColor Premium paper (310°F / 154°C), so some care must be taken when pressing onto some types of synthetic material such as nylon or polyester. Spandex or Lycra material is not recommended at this temperature.

Save time, money, and space. No need to purchase a second heat press when using the IColor Standard 2-Step 550/800 Transfer Paper system. The first and second presses share the same temperature and pressure so you don't have to wait for the press to change temperature.

IColor Standard 2-Step 550/800 Transfer Paper is **a weed-free system**, ensuring little time is wasted picking and weeding your transfer prints, enabling you to produce detailed, high quality images while dramatically reducing your production time.

Finished garments will last up to 50 washes depending on how it's laundered. It is recommended to wash finished garments inside out in cold or warm water and low agitation. Avoid fabric softener. Tumble dry on low setting - For best results, hang to dry. If ironing is necessary, you must place a piece of kraft paper between the pressed image and the hot iron. Failure to do this will result in a melted transfer.

Designed to work with the IColor series of specialty printers, the IColor Standard 2-Step 550/800 Transfer Paper will also work with many popular color laser printers - please check with your printer manufacturer for compatibility. **White toner enabled printers are suggested for best results.**

IColor Standard 2-Step 550/800 Transfer Paper is used as a set, comprising of a 'Transparent Transfer Sheet' (Part # ICHTSTDA550/LEG/800) and an 'Adhesive Sheet' (Part # ICHTSTDB550/LEG/800).

INSTRUCTIONS FOR BEST RESULTS:

1. Place the transparent transfer sheet into the appropriate tray of the IColor printer.
   - ⚠ The coated, rough side is the print side.
   - IColor 500 / 600: Print side face up in Multipurpose Tray
   - IColor 550 / 540: Print side face up in Tray 1 (Do not use the Multipurpose Tray with this paper)
     - ⚠ Remember to set the guides properly in Tray 1 to A4 to avoid misfeeds.
   - IColor 800: Print side face down in Multipurpose Tray

To avoid printer jams, stack a few sheets in the tray at once so the printer pulls the paper cleanly.

⚠ NEVER run the adhesive sheet through your printer. This may result in fuser failure.

2. Printer Settings:
In the RIP software settings, choose the paper type according to the printer being used. Make sure you are working within the overprint queue in the ProRIP software or 'B' Configuration if using the TransferRIP software.

- IColor 500 / 600: Set media type to 'Transparency'; and media weight to 'Ultra Heavy 1'
- IColor 550 / 540: Set paper type to 'Thick to 163g'
- IColor 800: Set paper type to 'Thick to 163g' (Thick to 220g may be needed for extra heavy coverage)

TIP: Specific print modes and sizes for this paper are available when using the IColor ProRIP software.

⚠ The page size should match the size of the paper being used (A4, A4 LEG, Tabloid XL Jumbo).

⚠ Remember to set the job to **mirror print**, ensuring the correct orientation when transferred to the textile. White overprint should be set to at least 150%

3. Print the image.

4. Preheat the press to 310°F / 154°C and keep the press closed for at least **5 minutes** before proceeding to heat up the lower platen.

- **This step is extremely important** to ensure a good bond during the marrying process. Do not proceed until you feel the heat radiating from the bottom of the press platen, or you may experience incomplete transfers.

5. Place the printed image in the middle of the press with the printed side facing up.

- Place the adhesive sheet on top of the print, adhesive coated side down – the image and the adhesive should be face-to-face.
- **TIP:** Fold a small corner of the adhesive sheet over, prior to pressing (this will make it easier to peel apart after pressing).

6. Cover the two sheets with kraft paper or a Teflon sheet and press the two sheets together in the heat press at 310°F / 154°C for 120 seconds with medium pressure.

7. Open the press and immediately (while hot) - rub the sheets with a piece of textile for 5 seconds, then peel the adhesive sheet away from the transparent transfer sheet **diagonally** in one slow, low and fluid motion.

- This must be done with the sheets on the press to minimize heat loss. The use of heat resistant gloves will help keep the paper in place due to the temperature of the lower platen.
- **TIP:** In order to avoid a faulty peel, it is recommended to peel from the side of the image with the greatest toner density.
- **TIP:** For images with a lot of black print (especially when printing with the IColor 800W), it may be necessary to press for a longer period of time and increase the dwell time in order to achieve a clean adhesive pull

8. 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. **See Tech Tips** for reasons why this may have happened.
- Examine the transfer sheet to determine if the transfer is acceptable and proceed to Step 9. Discard the used adhesive sheet.

9. Trim off the edges of the transparent transfer sheet using a pair of scissors or a cutting board. This will ensure no excess adhesive sticks to the garment and eliminate the chance of a white box around your design.

10. Place or thread 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.

11. Cover the transfer sheet and garment with kraft paper or a Teflon sheet and press the garment using a heat press at 310°F / 154°C for 30 seconds with medium-high pressure for cotton textiles.

- If you are pressing onto 100% poly, press at 265°F / 129°C.
- If you are pressing onto 50/50 cotton/poly, press at 285°F / 140°C.
- You can perform **this step ONLY** as low as 250°F / 121°C if necessary to avoid dye migration on polyester fabrics.

12. Remove the garment from the heat press carefully and immediately lay flat. Allow it to cool for at least 5 minutes.

13. 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. Perform this step within 60 mins or less.

14. Re-Pressing (AKA post press or fixing press) the image into the garment is important for wash durability.
- Place the textile back on the heat press.
- Cover with kraft fixing paper on top of the image for a matte finish.
- Re-press the image for roughly 20 seconds at 310°F / 154°C.

⚠ Re-Pressing at a lower temperature (as low as 265°F / 129°C) can help retain some vibrancy. A hotter post press may dull out the pressed image.

15. Wait 15 seconds before removing the fixing or kraft paper to avoid any part of the transfer from sticking to the kraft 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 garment!
- 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.

TECH TIPS

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

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

• Type of garment: Cotton, Polyester, Spandex and Lycra material all respond differently to heat. All instructions are based on cotton garments.

• If your presses are not pulling cleanly, preheat the lower platen of the press in the closed position for several minutes to retain the necessary heat to perform this step.

• Toner Coverage: Halftones in image may cause undesired results. Toner coverage should not be less than 70% otherwise there may be issues with transferring the adhesive to the transfer sheet. The RIP will add the necessary amount of white to the image to avoid this situation. Those printing outside of the RIP software may encounter issues such as incomplete adhesive transfer.

• 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 (recommended). Clam shell and other types of swing away presses may also yield different results. Always place the transfer paper in the middle of your heat press. Some heat presses do not have uniform heat and pressure distribution, which can affect your final project.

Only use kraft paper made for heat press applications! The use of butcher paper, Teflon sheets or other kinds not specifically designed for heat transfer applications can cause the image to stick to the paper.

During **Step 6** of these instructions, it is important that the adhesive sheet is placed on top because:
- The source of heat is on top and heat is transferred directly to the adhesive sheet instead of passing through the transfer sheet
- When pulling the sheets 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 while hot.

During **Step 7**, 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 or rasterized images to perfect your process. Full coverage images take some skill to successful pull cleanly and may require a longer press time and/or higher temperature. Full coverage tabloid graphics are not recommended.

If, during **Step 8**, your images are not peeling cleanly, first ensure that you are printing the right amount of white over your image.

- If so, then preheat the bottom platen of your heat press to ensure it's hot enough. Cool lower platens are the main cause of inconsistent A/B pulls.
- If this still does not resolve the issue, consult the Humidity and Storage sections below.
- When pressing large areas of black (especially using the IColor 800W), it may be necessary to increase the press time from 120 sec to 200 sec because of heavier than normal toner coverage. Increasing the dwell time before pulling will also help with adhesion.

If, during **Step 11**, you are adjusting the heat press temperature to accommodate delicate material, note that you must increase the temperature to 310°F / 154°C for **Step 6**. The adhesive will not transfer over properly if set at a lower temperature. Using 2 heat presses would greatly increase your output.

For cotton / poly blend hoodies:

- Press to the garment at 250°F / 121°C for 20 seconds, cool immediately and roll the transfer sheet off very tightly.
- Repress for 15 seconds and cool immediately. A lower press temperature and immediate cooling are necessary to prevent dye migration.

If you are seeing stray adhesive sticking to your garment or substrate during the transfer **Step 11** of these instructions, try reducing the press pressure to 'medium-low' or '3'.

If some of your image isn't sticking to the garment properly during **Step 13**, start your pull from an area that has the most toner coverage. Example, **DO NOT** 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 white streaks or imperfections are appearing on your transfer sheet after pressing it to the adhesive, this could be caused by uneven closure of your heat press plates.

- If this occurs, place 5 sheets of standard copy paper on top of the A & B sheets before pressing. The copy paper will form a heat barrier, allowing the heat to build up more slowly and prevent any imperfections. Tape the 5 sheets together with heat resistance tape so that you can use them again without waste.
- If you are getting incomplete pulls or are seeing marbling during **Step 6** of these instructions, try printing with 250% - 300% white overprint.

Humidity Suggestions: If your transfers are incomplete (gaps or holes where the adhesive didn't transfer over), then your adhesive sheets may have been affected by humidity. Follow these steps to remove the humidity:

- Place the adhesive sheet(s) face up in the heat press while hot.
- Do not press them, just allow to sit for approximately 1 – 2 minutes. Then proceed as normal.

Adhesive sheet storage: To prevent humidity from affecting your adhesive sheets, store in a resealable bag. Adding a silica pack will help to absorb any moisture. Use of a de-humidifier will help reduce excess moisture.

Transfer sheet storage: If the sheets are sticking together due to static electricity, store in a resealable or anti-static bag. Adding a dryer sheet will help reduce the static. Fan out the sheets before loading into the printer to ensure proper feeding.

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 or ProRIP 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 washability or scuff-resistance when applying this transfer paper to such materials.

It is recommended to wash finished garments inside out in cold or warm water and low agitation. Avoid fabric softener, as it may prematurely degrade the transfer. Tumble dry on low setting - For best results, hang to dry. If ironing is necessary, you must place a piece of kraft paper between the pressed image and the hot iron. Failure to do this will result in a melted transfer.

To see video instructions for IColor Standard Transfer Paper, visit www.icolorprint.com/video

OPTIONALLY AVAILABLE

IColor SmartCUT Software

Easily print oversized images on letter/A4 sized printers with Uninet's optional IColor SmartCUT software. Use any oversized graphic, and the software will split it in half along the most logical path. You can choose to have it split along dark or light areas, depending on the color garment you will be pressing onto. With this software, you can make 3XL shirts that are not possible with even the most expensive of printing systems because you can gang up as many transfer sheets as you want. For use with IColor 2-Step *Standard* and *Select* Transfer Paper. Trial version available at https://www.icolorprint.com/support

ALSO AVAILABLE:

IColor 2-Step *Premium* and *Premium STRETCH* Transfer Paper for light and dark colored garments
IColor 2-Step *Select* Transfer Paper for light and dark colored garments
IColor 2-Step GLITTER Adhesive Transfer Paper (for use with IColor 2-Step *Standard* Transfer Paper)
IColor 1-Step LIGHT and SPEED TRANS LIGHT Transfer Paper for light colored garments
IColor 2-Step Presto! Transfer Paper for textiles and hard surfaces
IColor 2-Step Temporary Tattoo Transfer Paper
IColor 1-Step *CLASSIC*, *Premium*, WOOD AND LEATHER and CERAMIC Hard Surface Transfer Paper
IColor 1-Step *AquaClear* Transfer Paper
IColor Label Paper (Clear and White) – Letter and Tabloid size
IColor Window Cling Paper (Clear and White) - Banner and cut sheet options
IColor Banner Paper
IColor Magnetic Paper – Letter and Tabloid size

...and more! Contact your dealer for more information.

IColor Transfer Paper Comparison Charts

ICOLOR TEXTILE TRANSFER PAPER

ATTRIBUTE	PREMIUM	PREMIUM STRETCH	STANDARD	SELECT	PRESTO	LIGHT	SPEEDTRANS LIGHT
PROCESS	2 Step	2 Step	2 Step	2 Step	2 Step	1 Step	1 Step
DURABILTY (# of Washes @ 104 °F/40 °C)	Up to 100	Up to 100	50+	50+	50+	15+	15+
DARK TEXTILES	BEST	BEST	BETTER	BETTER	BETTER	FAIR	FAIR
LIGHT TEXTILES	BEST	BEST	BETTER	BETTER	BETTER	GOOD	GOOD
DELICATE TEXTILES	BEST	BEST	GOOD	GOOD	GOOD	NOT RECOMMENDED	NOT RECOMMENDED
STRETCHABILITY	BETTER	BEST	GOOD	BEST	GOOD	GOOD	GOOD
COLOR BRILLIANCE	BEST	BEST	BETTER	BETTER	BEST	GOOD	GOOD
FINISH	MATTE	MATTE	SEMI GLOSS	MATTE	SEMI GLOSS	SATIN	SATIN
PRESS TEMPERATURE (°F/°C)	250°F / 120°C	285°F / 140°C	310°F / 154°C	310°F / 154°C	285°F / 140°C	390°F / 200°C	375°F / 190°C
PRESS TIME	30 + 30 secs	45 + 10 secs	120 + 30 secs	120 + 25 secs	120 + 30 secs	15 secs	10 secs
SOFT HAND	BEST	BEST	GOOD	GOOD	GOOD	BETTER	BETTER
COST	$$$	$$$	$$	$$	$$	$	$

ICOLOR HARD SURFACE TRANSFER PAPER

ATTRIBUTE	PREMIUM	CLASSIC	CERAMICS	WOOD/LEATHER	PRESTO! HARD SURFACE	PRESTO! PAPER/WOOD	AQUACLEAR	TATTOO
PROCESS	1 Step	1 Step	1 Step	1 Step	1 Step	1 Step	1 Step	2 Step
DURABILTY (RESISTANT TO SCRATCHING/CHIPPING	BEST	BEST	BEST	BEST	BEST	BEST	GOOD	BETTER
COLOR BRILLIANCE	BETTER	BETTER	BETTER	BETTER	BEST	BEST	BETTER	BETTER
METALLIC FINISH	NO	NO	NO	NO	YES	YES	NO	NO
PRESS TEMPERATURE (°F/°C)	300°F / 150°C *	300°F / 150°C *	300°F / 150°C *	300°F / 150°C *	320°F / 160°C *	265°F / 130°C *	N/A	265°F / 130°C
PRESS TIME	60 SECS *	60 SECS *	180 SECS *	60 SECS *	180 SECS *	90 SECS *	N/A	40 SECS
ACRYLIC	YES	YES	YES	YES	YES	NO	YES	YES
METAL	YES	YES	NO	NO	YES	NO	YES	YES
CERAMIC	YES	YES	YES	NO	YES	NO	YES	YES
TILE	YES	YES	YES	NO	YES	NO	YES	YES
GLASS	YES	YES	YES	YES	YES	NO	YES	YES
CRYSTAL	YES	YES	YES	YES	YES	NO	YES	YES
PAPER/WOOD/CARDBOARD	YES	YES	NO	YES	YES	YES	NO	YES
LEATHER	YES	YES	NO	YES	NO	NO	NO	YES
CANDLES	NO	NO	NO	NO	NO	NO	YES	YES
FLESH	NO	NO	NO	NO	NO	NO	NO	YES
COST	$	$	$	$	$$	$$	$$	$$$

* Temperature and press time varies based on substrate