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.