UniNet®

iColor®

PRINTING SOLUTIONS

iColor® 1-Step WOOD AND LEATHER Hard Surface Transfer Media Instructions
Part # ICHTHARDWL

The **iColor® 1-Step Wood and Leather Hard Surface Transfer Media** is an easy to use, substrate specific paper for use with leather, wood, acrylics, glass and crystal. The **iColor® 1-Step Wood and Leather Hard Surface Transfer Media** is designed to work best with substrates that have a porous surface in full color and features a thinner polymer that is easier to pull and does not leave a background on the substrate. This polymer protects the surface from scratches, while maintaining the original texture – ideal for awards and trophy applications. The **iColor® 1-Step Wood and Leather 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 or ProRIP software! The result is a vivid, long lasting image.

The **iColor® 1-Step Wood and Leather Hard Surface Transfer Media** was designed to serve as a substrate specific media, but note that UniNet carries general use hard surface media, as well as other substrate specific media work better in specific situations like ceramic and metal.

Designed to work with the **iColor®** series of specialty printers, the **iColor® 1-Step Wood and Leather 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 appropriate tray of the iColor® printer, print side up or down depending on your model (the white gloss coated side is the print side)

2. In the **iColor® TransferRIP or ProRIP Software,** configure for white overprinting. 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' (for images with heavier toner coverage, select an 'Ultra Heavy' setting) if printing from the iColor® 500/600 and 'Coated Glossy' if printing from the iColor® 550. Page size should be 'Letter'. Remember to set the job to mirror print to ensure it looks correct when transferred to the front of the substrate. TIP: For clear acrylics, you can also transfer to the back of the substrate - Do not mirror print and use a white underprint

4. Print the image.

5. 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) or the foam pad that shipped with the media. 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.

6. For most applications, press at 300°F / 150°C with medium high pressure. The duration of the press depends on the thickness, type and composition of the substrate used. Refer to the matrix below for suggested press times and peeling methods.

7. For hot peels, peel immediately after opening the press. For warm peels, do not wait longer than 30 seconds, otherwise the paper will begin to lift prematurely. Do not peel too early either, otherwise the polymer from the paper may not lift away.

Surface	Time	Temp	Press Pressure	Peeling	Notes
Acrylic	60 - 120 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 -180 Sec depending on thickness	300°F / 150°C	8 (Medium – High)	Warm	Warm peel. Bake in convection oven at 360°F / 182°C for 20 mins. Handwash.
Leather	60 Sec	300°F / 150°C	9 (High)	Hot	--
Wood (Uncoated)	50 Sec	300°F / 150°C	9 (High)	Hot	Make sure paper is larger than substrate for a more uniform application. Immediately pull once press is opened.
Wood (Coated/Laquered)	120 Sec	275°F / 135°C	9 (High)	Hot	Make sure paper is larger than substrate for a more uniform application. Immediately pull once press is opened. Not all coated surfaces will work, please test before production.

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 or ProRIP 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 or foam pad is necessary when using the Hard Surface Paper. All instructions are based on a .5mm silicon 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. It is suggested to use the foam pad that comes with the media for glass / crystal applications.

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.

For all applications (especially wood, where the polymer from the hard surface paper is transferred over), it is suggested that the size of your transfer paper is larger than your substrate for an easier pull and to avoid differences in the sheen.

For acrylics, the press duration is based on the thickness of the substrate.

For wood simulated products such as MDF or vinyl coated substrates, use iColor® Premium or Classic Hard Surface Media instead.

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® Wood and Leather Hard Surface Paper, visit www.icolorprint.com/video (Coming Soon)

Also available:

iColor® 1-Step LIGHT and SPEED TRANS LIGHT Transfer Media for light colored garments
iColor® 2-Step *Standard* Transfer Media for light and dark colored garments
iColor® 2-Step GLITTER Adhesive Transfer Media (for use with iColor® 2-Step *Standard* Transfer Media)
iColor® 2-Step *Premium* and *Premium STRETCH* Transfer Media for light and dark colored garments

iColor® 2-Step Presto! Transfer Media for textiles and hard surfaces

iColor® 1-Step CLASSIC, *Premium* and CERAMIC Hard Surface Transfer Media
iColor® 1-Step AquaClear Transfer Media
iColor® 2-Step Temporary Tattoo Transfer Media

…and more! Contact your dealer for more information.