



# Forever Classic Hard Surface Transfer Paper

**1**

**Set Print Mode:**  
Uninet iColor Hard Surface



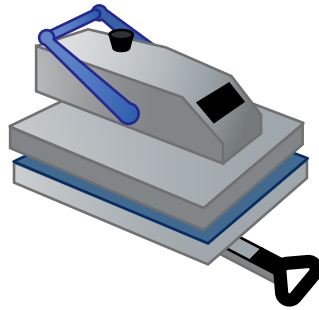
- Must be in Overprint
- Page size must match media being used. (Letter)
- White coverage: 250% - 280%

**Temperature:** 300°F/150°C

iColor 500/600: Ultra Heavy 1  
iColor 550/540: Coated Glossy  
iColor 560: Labels  
iColor 650: Ultra Heavy 3  
iColor 800: Coated Glossy

- Make sure design is mirrored
- Print side is coated side

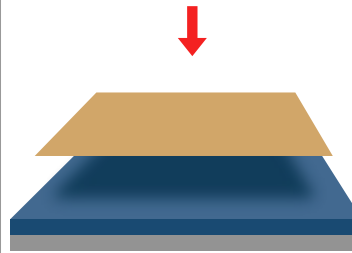
**2**



For clear acrylics, you can also transfer to the back of the substrate - Do not mirror print and configure for white underprinting.

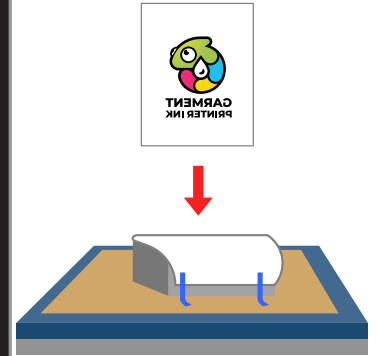
Preheat the closed press to 300°F / 150°C. Wait for the heat press to reach the desired temperature before moving forward.

**3**



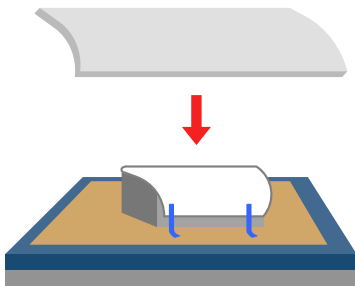
Place a piece of parchment or kraft paper on the bottom plate so you can easily remove the substrate when hot.

**4**



Align the substrate to the printed image & lay flat on press with transfer paper on top. You can apply tape on blank areas of the transfer paper to the lower kraft paper for additional stability.

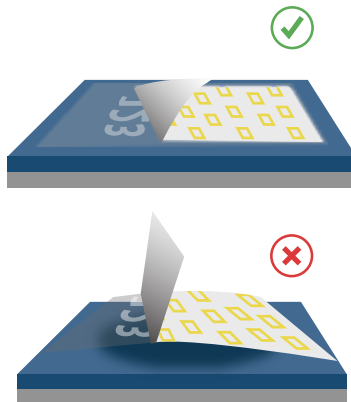
**5**



Cover the substrate and transfer paper with a silicone pad. A .5mm - 1mm pad is suggested for best results

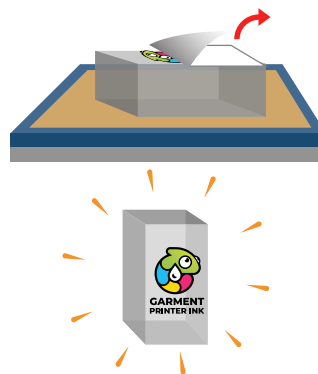
For most applications, press at 300°F / 150°C with medium high pressure.

**6**



Refer to the reference table on the back of this sheet for press time, pressure, temp, and peeling method for the according surfaces.

**7**

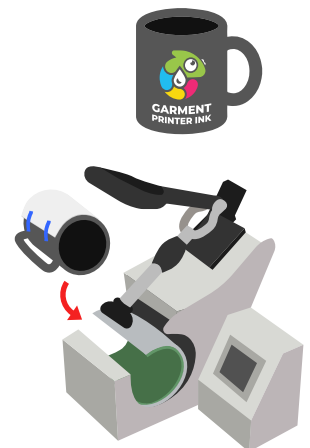


**For HOT PEELS:**  
Peel immediately after pressing

**For WARM PEELS:**  
Do not wait any longer than 30 sec to peel

**For COOL PEELS:**  
Wait approx. 1 minute before peeling.







**8**



**FOR MUG PRESSES:**

Choose appropriate sized sleeve, tape the transfer onto the mug with heat tape, insert mug, press accordingly.



 SURFACE	 TIME	 TEMP	 PRESSURE	 PEEL	 NOTES / METHOD
Acrylic	60-120 sec	300°F 150°C	8 (med-high)	Warm	Place heavy object on top while on press for 20sec to prevent warping
Aluminum Bottle	200 sec	300°F 150°C	8 (med-high)	Cool	Wait 1 min, then place substrate in warm water for 2 min before peel
Anodized Metal	90 sec	330°F 165°C	8 (med-high)	Cool	For any white or light colored uncoated metals & brass, silver, gold
DynaSub / UniSub Metal	180 sec	330°F 165°C	8 (med-high)	Cool	For any white or light colored poly coated metals including silver & gold
Stainless Steel Bottle	100 sec	360°F 182°C	8 (med-high)	Cool	Wait 1 min, then place substrate in warm water for 2 min before peel. Bake in oven 20min at 360°F/182°C
Glass / Crystal	60-180 sec	300°F 150°C	8 (med-high)	Warm	After peel, bake in convection oven at 360°F/182°C for 20min. Handwash
Ceramic (mugs & tile)	180 sec	300°F 150°C	8 (med-high)	Cold	Wait 1 min, then place substrate in warm water for 2 min before peel. Bake in oven 20min at 360°F/182°C
Metal & Steel	180 sec	300°F 150°C	8 (med-high)	Cold	Place substrate in cold water for 1-2min before peeling
MDF / Simulated Wood	60 sec	300°F 150°C	8 (med-high)	Hot	Ensure material can withstand heat press temp. Some cannot be used
Magnetic Sheeting	60 sec	300°F 150°C	9 (high)	Cool	---
Wood	60 sec	300°F 150°C	8 (med-high)	Hot	Make sure transfer paper is larger than substrate for uniform application. Peel immediately.

**IMPORTANT:** All values are for reference. Toner types vary. Optimal temperature and time should be found through experimentation.