**Forever Classic Hard Surface Transfer Paper**

1. **Set Print Mode:**
   - Uninet iColor Hard Surface

2. **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.

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.

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**Temperatures:**
- **300ºF/150ºC**

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

**iColor 500/600: Ultra Heavy**
- iColor 550/540: Coated Glossy
- iColor 560: Labels
- iColor 650: Ultra Heavy
- iColor 800: Coated Glossy

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

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

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