

**1**

**Set Print Mode:**  
Uninet iColor 1-Step Light

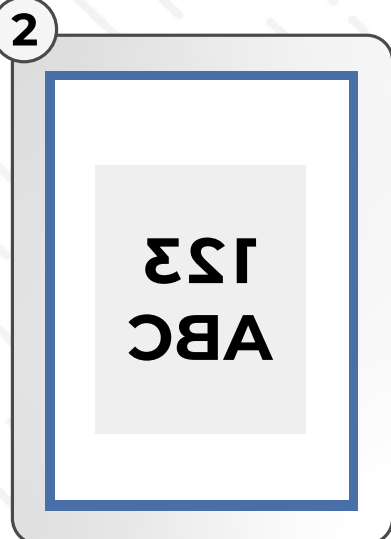
- Must be in Overprint
- Page size must match media being used. (A3, A4, A4 XL)

iColor 500/600: Plain  
iColor 550/540: Coated Glossy Thick  
iColor 560: Thick to 105  
iColor 650: User Type 2  
iColor 800: Thick to 163g

**White garments:**  
White Overprint 200% -  
**Medium garments:**  
White Overprint 300%

- iColor 550/540/560:  
Do not exceed 280% white overprint
- iColor 650: Needs to be 130% white overprint

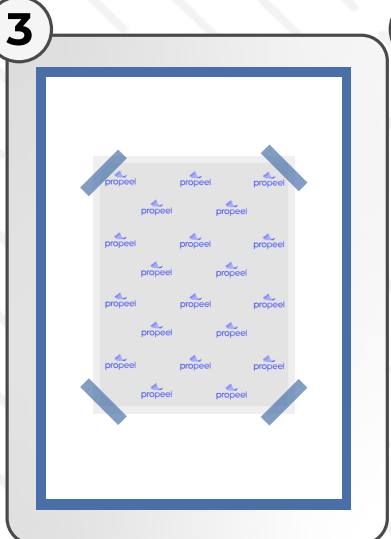
Make sure design is mirrored.



**Temperature:** 390°F/200°C

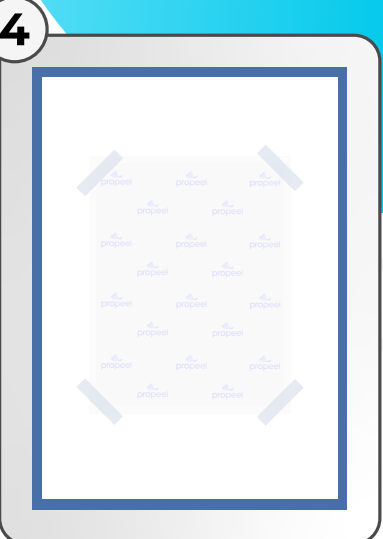
Close press while empty and allow bottom plate to heat for 3-4 minutes.

Wait for the heat press to reach the desired Temperature before moving forward.

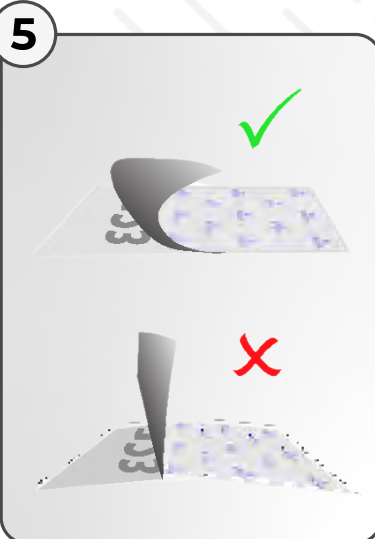


Place garment on the heat press and position the transfer print side down on the garment

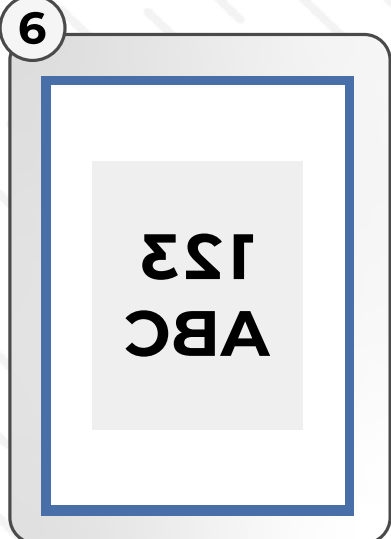
Secure with heat resistant tape



Cover with parchment or kraft paper. Press for 15 sec on medium pressure (5 Bar) at 390°F / 200°C




Open press, wait 10-15 seconds, then (while still on press) peel sheet away in a smooth, low, and slow motion.



\*Optional Finishing press to improve washability, feel, and a more matte finish

Place garment back on heat press. Cover image with a sheet of parchment, kraft, or teflon and press for 30 seconds.

**TABLE 1: TRANSFER TO TEXTILE**

	°F °C	⌚	↕
			
<b>COTTON</b>	390°F 200°C	30 Seconds	5 Bar
<b>POLYESTER</b>	350°F 177°C	30 Seconds	5 Bar

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

# TECH TIPS

**There are many variables that could produce different results.**

- **Type of image:** Photos/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 or other kinds not specifically designed for heat transfer applications can cause the image to stick!*

**This transfer paper is recommended for use with light or medium colored garments** because it is a 1 Step paper without the adhesive backing. As a result, the darker the substrate, the more your graphic will be washed out or muted.

**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 assist 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 when applying 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.

If there is a background around your transfer, reduce the transfer time or pressure. If there are areas which are not completely clean, it is recommended to post press again with light pressure and kraft paper to weed out the undesired areas.

## **iColor™ 650 Tips:**

- When printing the color black, change the color code of your black elements to 65% C, 65% M, 60% Y using the job color replacement tool in the ProRIP.
- When printing solid black images with no color, use the provided black cartridge and set your artwork to 100% K in the job color replacement.
- Optionally, use your IColor Clear toner kit for outstanding results when pressing onto a white or light colored textiles.