Set Print Mode: 2 Step Select

- Must be in Overprint
- Page size must match media being used. (A3, A4, A4 XL)
- White coverage set to 225%

Temperature: 310°F/154°C

iColor 500/600: Transparency
iColor 550/540: Coated Glossy
iColor 560: Plain 1 to 74g
iColor 650: Ultra Heavy 2
iColor 800: Thick to 163g

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

1. Close press while empty and allow bottom plate to heat for 3-4 minutes.
   Open and place the printed A Sheet, toner side up onto the press.

2. Place B Sheet adhesive side down on top of the A sheet so that the entire print is covered. Fold corner of B sheet for an easier peel.

3. Cover with a sheet of parchment, kraft or teflon and press for 120 seconds. Be prepared to peel immediately after press.

4. Load your garment onto the heat press. Align your image on the garment and fix it in place using heat resistant tape.

5. Hold the A sheet flat on press and peel B sheet away in a smooth, low, and slow motion.

6. Use a scissor to cut around A sheet, removing any residue left during the marrying process.

7. Cover the transfer and garment with a sheet of parchment, kraft or teflon and press for 30 seconds.
TABLE 1: B SHEET TO A SHEET

<table>
<thead>
<tr>
<th>CMYW</th>
<th>°F</th>
<th>°C</th>
<th>Time</th>
<th>Pressure</th>
</tr>
</thead>
<tbody>
<tr>
<td>310° - 320°F</td>
<td>154° - 160°C</td>
<td>120 Seconds</td>
<td>8 Bar 116 PSI</td>
<td></td>
</tr>
</tbody>
</table>

TABLE 2: TRANSFER TO TEXTILE

<table>
<thead>
<tr>
<th>Fabric</th>
<th>°F</th>
<th>°C</th>
<th>Time</th>
<th>Pressure</th>
</tr>
</thead>
<tbody>
<tr>
<td>COTTON</td>
<td>310° - 320°F</td>
<td>154° - 160°C</td>
<td>30 Seconds</td>
<td>8 Bar 116 PSI</td>
</tr>
<tr>
<td>POLYESTER</td>
<td>248° - 266°F</td>
<td>120° - 130°C</td>
<td>30 Seconds</td>
<td>8 Bar 116 PSI</td>
</tr>
<tr>
<td>POLYPROPYLEN</td>
<td>220°F</td>
<td>105°C</td>
<td>30 Seconds</td>
<td>8 Bar 116 PSI</td>
</tr>
<tr>
<td>BLEND FABRIC</td>
<td>285°F</td>
<td>140°C</td>
<td>30 Seconds</td>
<td>8 Bar 116 PSI</td>
</tr>
<tr>
<td>PAPER/CARTON</td>
<td>210°F</td>
<td>100°C</td>
<td>15 Seconds</td>
<td>1 - 2 Bar 14.5 - 29 PSI</td>
</tr>
<tr>
<td>BOOK COVERS</td>
<td>230 - 250 °F</td>
<td>110 - 120 °C</td>
<td>15 Seconds</td>
<td>1 - 2 Bar 14.5 - 29 PSI</td>
</tr>
</tbody>
</table>

Allow garment to cool completely. With garment on flat surface, peel away the A sheet 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 10 seconds.

Before Fixing, cut finishing foil to size and place over your printed image (foil face side up)

Cover with a sheet of parchment, kraft, or teflon and press for 30 seconds. (310° F/155°C at 72.5 PSI)

Allow to cool, then peel.

Cover with a sheet of parchment, kraft, or teflon and press for 30 seconds. (310° F/155°C at 72.5 PSI)

Allow to cool, then peel.

Before fixing, cut flock sheet to size and place over your printed image (flock side down)

Before Fixing, cut flock sheet to size and place over your printed image (foil face side up)

Cover with a sheet of parchment, kraft, or teflon and press for 30 seconds. (310° F/155°C at 72.5 PSI)

Allow to cool, then peel.

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