

TRANSFER INSTRUCTIONS

MARRYING STEP PARAMETERS

	°F		
OKI 920WT & OKI Pro8432WT	320°F	75 sec.	5 medium pressure
OKI Pro9541WT*	285°F	100 sec.	5 medium pressure

As your heat press heats up, keep the top platen of heat press lowered to make sure the bottom platen is warm.

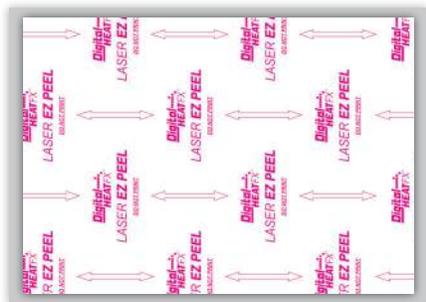
*Note: If you are using the Dots or Stripes Print Mode for the 9541 printer, please perform the marry step at 320°F for 60 seconds with medium (5) pressure.

- 1 Print your design in mirror image mode onto the frosted side of the A-Film. Load the A-Film into the printer with the frosted side (print side) face up.



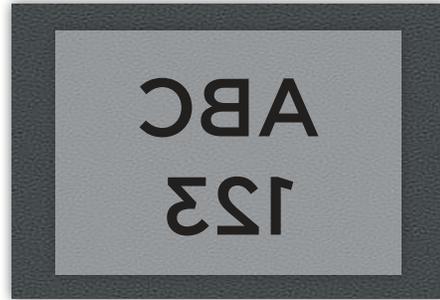
A-FILM

- 2 Please note, that the B-Paper is slightly smaller than the A-Film on purpose. This prevents your heat press from getting dirty.



B-PAPER ON A-FILM

- 3 Place the A-Film directly on the top of the lower platen (printed/frosted side showing up).

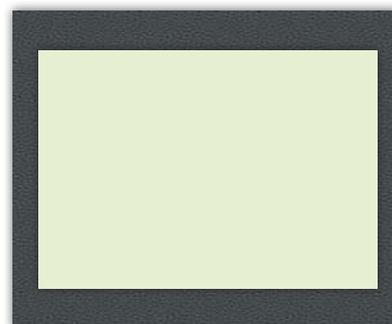


- 4 Place the B-Paper (coated side down) on top of the A-Film.

PRO TIP: Fold over a small corner of the B-Paper to assist with getting the marry peel started later on.



- 5 Place a sheet of parchment paper over the B-Paper to avoid sticking.



PAPER OVER B-PAPER AND A-FILM

- 6 Press all together using the parameters listed in the chart at the top of the page depending upon the printer you own.



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- 7** When the time is up, open the heat press and remove the parchment paper. Begin your peel 5-10 seconds after opening your heat press. Do not wait any longer. Separate the B-Paper from the A-Film without lifting them up from the lower platen of your heat press to avoid heat loss. Work in a SLOW AND FLUID motion. DO NOT PAUSE OR STOP once you begin the peel process.



- 8** Trim your design to remove the safety box and any residue left behind by the B-Paper.



- 9** Place the textile/substrate on the lower platen of the heat press. Pre-press it for 5-10 seconds to remove any wrinkles or moisture.



- 10** Using a finishing sheet or parchment paper for protection, press the transfer following the chart above for the suggested temperature setting:



For 920WT & Pro8432WT

	°F		
COTTON	320°F	45 sec.	5 med. pressure
50/50 BLEND	320°F	30 sec.	5 med. pressure
POLYESTER	270°F	20 sec.	5 med. pressure
CARDBOARD	230°F	10 sec.	5 med. pressure
BOOK COVERS	230°F	15 sec.	5 med. pressure

For Pro9541WT

	°F		
COTTON	265°-285°F	30 sec.	5 med. pressure
50/50 BLEND	265°-285°F	30 sec.	5 med. pressure
POLYESTER	265°F	20 sec.	5 med. pressure
CARDBOARD	230°F	10 sec.	5 med. pressure
BOOK COVERS	230°F	15 sec.	5 med. pressure

- 11** Carefully remove the textile/substrate from the heat press and allow to cool before peeling away the A-Film. Only remove the A-Film after it is **absolutely cold**. Failure to do so may result in a faulty transfer. Start from a corner with the most toner coverage and remove the A-Film in one, rapid motion (like a bandage).



- 12** To ensure wash-ability and a matte finish, re-press your textile/substrate with a piece of parchment paper for 20 seconds and at the same temperature you used from Step 10 above. The pressure should be bumped up to a high pressure (a 8 or 9). To achieve a more shiny finish, use a Teflon sheet instead of parchment paper. To achieve a more textured finish, use the Flexible Finishing Sheet instead of parchment paper.



PRINTER SETTINGS

USE THE MULTI-PURPOSE TRAY AND STACKER FACE-UP WHENEVER POSSIBLE	OKI ES7411WT OKI C711WT 	OKI ES9420WT OKI C920WT 	OKI ES9541DN OKI C941DN 	OKI 8432WT 	OKI 9541WT 
PRINT MODE	Foil	Transparency	Transparency	Transparency	Transparency
PAPER FEED	Multi-Purpose Tray	Multi-Purpose Tray	Multi-Purpose Tray	Multi-Purpose Tray	Multi-Purpose Tray
COLOR SETTINGS:					
CYAN	0	0	+3	0	0
MAGENTA	+2	+2	+3	0	0
YELLOW	+1	+1	0	0	0
WHITE	-3	-3	+3	+3	0
BLACK					0



FILE FORMATS

Generally, all common file formats can be used to print with a white toner OKI printer on our transfer media. However, we recommend printing from Digital Heat FX Print Optimizer. Print Optimizer can import most of the popular file formats such as .PNG, .EPS, .PSD, .TIFF, .PDF, .JPG, etc.



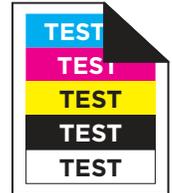
TEXTILE SELECTION

Always select a less stretchy fabric (no spandex or lycra) to prevent cracking when pulling/stretching the fabric apart.



BEFORE YOU PRINT

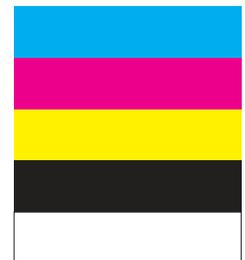
- Switch on your device.
- Go into the Calibration Menu, select **Reg. Adjust** and confirm to correct the color registration.
- Print a **test design**, preferably, with the primary colors Cyan, Magenta, Yellow, Black/White.
- A **worn drum** may lead to poor toner coverage. When the message **"Image drum near end of life"** appears, we recommend that you observe the print quality of the respective color closely and to have a spare drum on hand just in case.



Test Sheet



Printing with a **WORN** Magenta image drum



Printing with **INTACT** image drums

Questions?

Contact our DigitalHeat FX Support Team today.

Phone: 877-793-3278

Email: support@coldesi.com

Open a ticket: <https://support.coldesi.com/open-a-ticket/>

CARE INSTRUCTIONS

Cold wash inside out delicate cycle. Low dryer or hang dry. Cover transfer with parchment paper when ironing.



HEAT PRESS

If existing, remove the Teflon sheet from the upper and lower platen of your heat press.

Reason: Teflon absorbs too much heat and leads to faulty and inconsistent results.

Make sure that your silicone pad is faultless and is glued to the lower platen.

Reason: If the upper and the lower platen of the heat presses are not touching each other in a pure vertical movement, but also partially in a horizontal (slide) movement, this may lead to incomplete transfer of the B-Coating to the A-Film, especially in large, full-scale designs or pictures.

Make sure that the press has reached the set temperature on the heat platen. Then, close your press to pre-heat the lower platen until it is hot. This step should be done before beginning to work or after long breaks.

Reason: If you follow the above step, you can be sure that the lower platen definitely has the desired temperature. You can only reach consistent results with an adequately heated lower platen.

The bottom silicone pad of your heat press should not be too soft.

Reason: Extremely soft silicone pads might lead to problems in the separation of A- and B- media.

Always place the transfer media in the middle of your heat press.

Reason: Some heat presses do not have uniform heat and pressure distribution on the edges. The further you go to the edges, the more likely processing errors will occur, due to the lack of pressure on/around these areas.



SEPARATION OF A & B MEDIA

It is necessary to leave the A & B Media on the press during the separation.

Reason: Otherwise, cold air will flow under the media and will cause the transfer to cool down rapidly. If the media cools down too fast, parts of the design may transfer from the A- Film to the B-Paper which is not desired.

Do not separate the A & B Media with a harsh movement.

Reason: A too fast separation may lead to torn-out areas on round edges or other critical areas in your design.

Separate the A & B Media in a flat and constant motion.

Reason: When the media remains flat on the press the separation works perfectly.



TRANSFERRING TO THE SUBSTRATE

Remove substrate from the heat press carefully.

Reason: While opening the press or removing the substrate from your press, the corners of the A-Film may lift up from the fabric. This leads to undesired hot-peeling and to incomplete and faulty edges.



AFTER APPLICATION

Peel the A-Film when absolutely COLD.

Reason: If you remove the A-Film while still warm, it will lead to an incomplete and faulty transfer.