UniNet®
iColor®
PRINTING SOLUTIONS

iColor® 2-Step *Premium* STRETCH Transfer Media Instructions
Part # ICHTSTRETCH (A4) / ICHTSTRETCHTAB (A3)

Temperature	Time	Paper Setting	Pressure
285°F / 140°C	45 Seconds	iColor 500/600: Ultra Heavy iColor 550: Coated Glossy	8

The **iColor® 2-Step Premium Stretch Transfer Media** set will allow you to transfer prints from the **iColor®** series of printers (including white and fluorescent color prints) onto a variety of garments, especially dark fabrics and allow for extra elasticity on stretchy fabrics. A common problem in the industry is the stretchable limit of certain transfer papers. This new stretch product will give you added confidence in the ruggedness of your design and finished product. Added rasterization or breathability in your design, as well as using the garment color as a mask, will also add to the stretch limits. The white adhesive applied as a result of the 2-step process enhances the color of your print, and increases the adhesion to your garment for maximum durability, opacity and vibrancy on your finished product. The **iColor® 2-Step Premium Series Transfer Media** is considered the best choice of media when the softest possible hand is required. This media is also brighter than any other media on the market today and has the best color reproduction, especially when printing red.

Similar to the **iColor® 2-Step Premium Transfer Media**, the **iColor® 2-Step Premium Stretch Transfer Media** has added elastic in the adhesive to allow for stretching, while maintaining its original shape. Print and press onto cotton, as well as many types of synthetic material such as nylon, polyester and poly-cotton blends without the risk of scorching or melting the fabric. Save time, money, and space. No need to purchase a second heat press when using the **iColor® Premium Stretch Transfer Media** system. The first and second presses share the same temperature, pressure and press duration so you don't have to wait for the press to change temperature.

The **iColor® 2-Step Premium Stretch Transfer Media** is a weed-free system, ensuring your time is not wasted picking and weeding your transfer prints, enabling you to produce detailed, quality images while dramatically reducing your production time.

Wash-tested up to 100 washes at 104°F / 40°C, your images will remain durable, vibrant and stretchable!

Designed to work with the **iColor®** series of specialty printers, the **iColor® 2-Step Premium Stretch Transfer Media** will also work with many popular color laser printers – please check with your printer manufacturer to be certain. White toner enabled printers are suggested for best results.

The **iColor® 2-Step Premium Stretch Transfer Media** is used as a set, comprising of a 'Transfer Sheet' and an 'Adhesive Sheet'. Please follow the steps below for best results:

1. Place transfer sheet into the appropriate tray of the iColor® printer, print side up or down depending on your model (the coated, brighter white, slicker side is the print side). You may need to stack a few sheets in the tray at once so the printer pulls the media cleanly if using the multipurpose tray.
Note: NEVER run the adhesive sheet through your printer. This will result in fuser failure.

2. Paper type should be 'Ultra Heavy' if printing from the iColor® 500/600 and 'Coated Glossy' if printing from the iColor® 550. Page size should be either 'A4' or 'A3', depending on the stock being used. Remember to set the job to mirror print to ensure it looks correct when transferred to the garment. Use the iColor® TransferRIP or ProRIP Software for the required amount of white overprint. A white spot coverage (white overprint) of 150% - 200% is suggested. Select 2 - 3 pixel underfilling for best results.

3. Print the image.

4. Once image is printed, place the adhesive sheet on top of the print, white (adhesive coated) side down - the image and the adhesive should be face-to-face.

5. Run the two sheets together through a laminator on a medium-high heat setting prior to pressing - this will ensure all air bubbles are removed and all adhesive is transferred during the pressing process. Do not use a carrier sleeve, run the paper directly through. Pull the edges of the papers outward and keep them taut as you feed them into the laminator to prevent any air from getting in between the sheets. If the sheet is buckling through the laminator, you may have a humidity issue. Refer to the tech tips below for advice on how to deal with this.

6. Preheat the press to 285°F / 140°C and keep the press closed for at least 30 seconds before proceeding to heat up the lower platen. This step is extremely important to ensure a good bond during the marrying process.

7. Place the transfer/adhesive page on the press 'adhesive side up'. Fold a small corner of the adhesive sheet over, prior to pressing - this will make it easier to peel apart after pressing. Cover the media with a Teflon sheet and press the two sheets together using a heat press at 285°F / 140°C for 45 seconds with medium-high pressure.

8. Open the press and while hot - immediately peel the adhesive sheet away from the transfer sheet diagonally in one smooth, low, continuous motion. This should be done with the sheets on the press to minimize heat loss. The use of heat resistant gloves may help this process.

9. Observe the used adhesive sheet – you will see the adhesive was removed only where toner was present on the transfer sheet. If you see any part of your design on the adhesive sheet, you did not get a clean pull. Examine your transfer sheet to determine if the transfer is acceptable. Discard the used adhesive sheet.

10. Trim the edges away from the transfer sheet - this will ensure no excess adhesive sticks to the garment and eliminate the chance of a white box around your design.

11. Place your garment on the press. Position the transfer sheet (print side down) onto the garment. It is suggested that you use heat resistant tape to secure the sheet to the garment. Otherwise, opening the press can cause the transfer sheet to lift prematurely. For more precise placement, lay the garment out on a table, position the transfer sheet appropriately and tape the corners before placement on the press.

12. Cover the transfer sheet and garment with kraft paper or a Teflon sheet and press the garment using a heat press at 285°F / 140°C for 10 seconds with medium-high pressure.

13. Remove the garment from the heat press carefully and immediately lay flat. Allow it to cool for at least 5 minutes.

14. Once the garment is completely cooled, carefully peel away the transfer sheet in one smooth, low, continuous motion. Removal while still warm could lead to an incomplete or faulty transfer. It is suggested that you start your pull from an area that has the most toner coverage. The image will adhere to the garment. Do not wait too long for this step (under one hour).

15. Re-Pressing (fixing) the image into the garment is important for wash durability. It is best to re-press the image for roughly 20 seconds at 285°F / 140°C with kraft paper on top of the image.

16. Wait a few seconds before removing the kraft paper. Pull slowly in one smooth, continuous motion. It is important to wait before pulling the paper off, otherwise it could pull the design off the shirt! While the garment is still on the press and still hot, lightly stretch the material to allow the toner to soak into the fabric to prevent cracking

TECH TIPS

There are many variables that could produce different results. Specific steps may need to be altered based on:

• **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. Clam shell and swing away presses may also yield different results.

• **Type of image**: Photos or full-color graphics may require a longer press time than vector images or text.

• **Type of garment**: Cotton, Polyester, and Spandex material all respond differently to heat. All instructions are based on cotton garments.

• **Toner Coverage**: Halftones in image may cause undesired results. Toner coverage should not be less than 50% otherwise there will be issues with transferring the adhesive to the transfer sheet.

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 to the paper.

If you are printing a very densely covered page, it is suggested you choose "heavy" for the paper type to avoid a paper jam at the fuser. If you do get a paper jam, shut off the printer, remove the fuser and clear the jam, then print some test pages on regular paper to clear the excess toner out of the fuser. Then reprint with "heavy" paper settings.

During Step 7 of these instructions, it is important that the adhesive sheet is placed on top because a) The heat platen is on top so heat is transferred directly to the adhesive sheet instead of passing through the transfer sheet and b) When pulling them apart, the sheet on top tends to curl. If that was your transfer sheet, it would then be difficult to place on your garment and could be ruined if the image touched itself.

During Step 8, note that the denser your image, the more difficult it will be to pull the A & B sheets apart. Start out with less dense, weeded images to perfect your process. Full coverage images take some skill to successful pull cleanly and may require a longer press time and/or higher temperature. Full coverage tabloid (A3) graphics are not suggested.

If some of your image isn't pulling properly during Step 14 of these instructions, start your pull from an area that has the most toner coverage. For example, don't start your pull from a dot or a small independent portion of your graphic. The more toner coverage, the higher the probability that you won't lose part of your image when getting started.

If your transfer and adhesive sheets are crinkled or buckled after running through the laminator, pull the edges of the paper outward and keep them taut as you feed them into the laminator to prevent any air from getting in between the sheets.

Humidity Suggestions: If your transfers are incomplete (gaps or holes where the adhesive didn't transfer over) or if your transfer and adhesive sheets are crinkled or buckled after running through the laminator (even after pulling the edges of the papers outward as you feed them into the laminator), then your adhesive media has been affected by humidity. Follow these steps to remove the humidity: 1) Place the adhesive sheet(s) face up in the heat press while hot. Do not press them, just leave them there for approximately 1 minute. 2) Prior to running the transfer/adhesive set through the laminator, lightly press them in the heat press for approximately 15 seconds. Then proceed as normal.

Adhesive sheet storage: To prevent humidity from affecting your media, store in a resealable bag. Adding a silica pack will help to absorb any moisture. Use of a de-humidifier will help as well.

Transfer sheet storage: If the media is sticking together due to static electricity, store in a resealable bag. Adding a dryer sheet will help reduce the static. Fan out the media before loading into the printer to ensure proper feeding.

When fixing dri-fit or spandex material, use medium press pressure or the paper and toner will be driven into the material too much, causing cracking.

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 help 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 wash ability or scuff-resistance when applying transfer media to such materials.

It is recommended to wash finished garments inside out in cold or warm water and low agitation. Tumble dry on low setting - For best results, hang to dry. 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.

To see video instructions for iColor® Premium Stretch Transfer Media, visit www.icolorprint.com/video (Coming soon)

Also available:

IColor 2-Step *Premium* Transfer Media for light and dark colored garments
IColor 1-Step LIGHT and SPEED TRANS LIGHT Transfer Media for light colored garments
IColor 2-Step *Standard* Transfer Media for light and dark colored garments
IColor 2-Step *Select* Transfer Media for light and dark colored garments
IColor 2-Step GLITTER Adhesive Transfer Media (for use with IColor 2-Step *Standard* Transfer Media)
IColor 2-Step Presto! Transfer Media hard surfaces
IColor 1-Step **CLASSIC** *Premium*, WOOD AND LEATHER and CERAMIC Hard Surface Transfer Media
IColor 2-Step Temporary Tattoo Transfer Media
IColor Label Media (Clear and White) – Letter and Tabloid size
IColor Banner Media

…and more! Contact your dealer for more information.

Easily print oversized images on letter/A4 sized printers with UniNet's optional iColor® SmartCUT software. Use any oversized graphic, and the software will split it in half along the most logical path. You can choose to have it split along dark or light areas, depending on the color garment you will be pressing onto. With this software, you can make 3XL shirts that are not possible with even the most expensive of printing systems because you can gang up as many transfer sheets as you want. For use with **iColor® 2-Step** *Standard* and *Select* Transfer Media.
Trial version available, contact your sales rep for more information.

About UniNet

UniNet is a worldwide Original Equipment Manufacturer with over 25 years of experience in the imaging industry. With sales, service and distribution networks on every continent, we have earned a global reputation for high quality products and customer service. The UniNet iColor® Digital Color + White Transfer Media Printers feature full color plus white, combined with true black printing - a unique and low cost digital solution for the short to mid run market. With the most opaque white toner available, users can print on black, dark and clear media or garments in vibrant, colors + white. Imagine custom T-shirts, sweatshirts, hard surfaces, invitations, menus, stationary, promotional items, labels, banners, and more which include full color and brilliant white! Add our option specialty toner kits to produce fluorescent colors, security documents, clear watermarking and even dye sublimation prints, all in the same printer! What's more, our exclusive iColor® TransferRIP or ProRIP technology allows you print white as an overprint or underprint in one pass!