OKI®

Printing & Pressing
Forever® Flex-Soft

+ When producing textile transfers logos for a left chest position on a collared shirt, it is best to use a quality transfer media such as Forever® Flex-Soft (No Cut).

+ The following instructions will help you to print the transfer A-Foil, apply the self-weeding adhesive backing from the B-Paper, and transfer the image to your garment using a Heat Press.

1. PRINTING

Print your design using the Mirror setting of the printer driver on the Coated Side of the A-Foil sheet.

Depending on the OKI Digital Transfer Printer you are using, select the fuser temperature setting for the correct media.

In the case of the pro8432WT, select Media setting: User Type 1. On other OKI printer models, such as the C711WT or the C941DN, use the TRANSPARENCY setting.

Use the Multi-purpose tray (MPT) to feed the media along with the straight-through face up paper path to exit the printer.

Make all sides of the A-Foil approximately 1 cm smaller by trimming around the image.

2. PREPARATION OF THE HEAT PRESS

Pre-heat your Heat Press until the Lower Plate is HOT!

3. TRANSFER (B-PAPER TO A-FOIL)

1. Place 1-2 sheets of Regular Copy Paper on the lower plate to protect your silicone pad.
2. Place the trimmed A-Foil in the middle of the lower plate (Printed side facing up).
3. Place the B-Paper LowTemp on top of the A-Foil (coated side facing down).
4. Cover all with 1 or 2 sheets of Regular Copy Paper.

NOTE: It is essential that the B-Paper LowTemp is slightly larger than the A-Foil to avoid leaving edge marks around the weeded image

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3. TRANSFER (B-PAPER TO A-FOIL) CONT.

5. Press the A-Foil & B-Paper together:

	TEMPERATURE	TIME	PRESSURE
WHITE	275°-310°F / 135°-155°C	A4: 90 SEC.	A3: 120 SEC.	3-4 BAR	40-60 PSI
STANDARD, METALLIC & NEON	293°-310°F / 135°-155°C	A4: 90 SEC.	A3: 120 SEC.	2-3 BAR	30-40 PSI

6. After opening the press, rub the B-Paper with a cloth for 5–10 seconds.

Next, separate the B-Paper from the A-Foil without lifting them up from the lower plate.

When you start peeling the B-Paper, work in a low, slow, fluid motion *(once you start, you should not stop).*
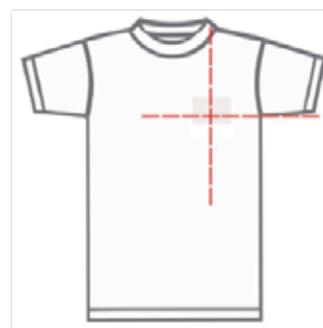
4. APPLICATION ON THE GARMENT

Place the garment on the lower plate of the heat press.

Align the transfer on the garment in the position you wish to use for placement. Using a logo template for consistency in your placement is recommended.

If you feel the need to tape the corners of the A-Foil with Heat Resistant Tape to hold it in place, if you are more comfortable not doing this step, please feel free not to use tape.

Cover it with a Matt Finish silicone sheet, press the transfer onto the garment..

Press using the parameters shown:

	TEMPERATURE	TIME	PRESSURE
COTTON	275°-310°F / 135°-155°C	30 SEC.	3-4 BAR	40-60 PSI
POLYESTER	275°F / 135°C	30 SEC	3-BAR	40PSI
POLYPROPYLENE	212°F / 100°C	20 SEC	2 BAR	30 PSI
BLEND FABRIC	266°-320°F / 130°-160°C	30 SEC	3-4 BAR	40-60 PSI

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4. APPLICATION ON THE GARMENT CONT.

Remove the A-Foil from the garment once it has become completely COLD.

Using your hand to roll the A-Foil on top of itself will give you good results, and provide the best color reproduction of your image.

5. FINISHING

For Extraordinary Good Wash ability with a Matte or Glossy finish, it is absolutely **IMPORTANT** that you repress using a sheet of Matte Finish Economy or Glossy Finishing Paper for 30 seconds at the same temperature as used to transfer of the image.

USEFUL TERMS:

HOT PEEL TRANSFERS:

Requires you to be peeled immediately after heat pressing. Premium transfer papers that can be used may leaves a minimal amount of toner residue behind. Hot peel transfers feel soft on the shirt and are quick to complete.

COLD PEEL TRANSFERS:

Requires you to peel when the paper and shirt have cooled down, they take longer due to this cool down time. Cold peel transfers tend to release almost 100% of the toner when peeled.

SINGLE-STEP:

Transfers the toner, not the back-ground film! Primary use is for color vector transfers on white and pastel colored fabrics. Can also be used with foils to decorate dark fabrics that adds value and designs that pop!

TWO-STEP:

Is an easy-to-use, two-step transfer paper that eliminates the unnecessary white background usually found around your image when using opaque type papers. When you have finished both steps, you will have created a dark colored garment with a professional-looking transfer.