



▶▶▶ **INSTRUCTIONS**

Instructions for Printing onto Dark Textiles made out of 100% Cotton with FOREVER Solvent-Dark 111 & FOREVER Solvent-Dark Metallic 121

▶▶▶ **PRINT SETTINGS**

IMPORTANT!

Only for use in Solvent-Printers, UV-Printers, Offset-Printers and Flexo Printers with Solvent, Solvent Light, Mild Solvent or Eco-Solvent inks and UV-hardening inks or UV-hardening Flexo Colors.

Maximum Printer Heating: 35 °C (95° F)

(Suggested Profiles for ROLAND VersaCAMM Series = SP-M: Matte PET, High Quality (720 x 1440))
ROLAND VersaCAMM VP-Serie = FOREVER Profile

▶▶▶ **TRANSFER SETTINGS**

	AUTOMATIC HEAT PRESS	MANUAL HEAT PRESS	
PRESSURE	5 bar (70 PSI)	Maximum	
TEMPERATURE	180° C (356° F)	180° C (356° F)	
TIME	5 + 30 seconds	5 + 30 seconds	

▶▶▶ **TRANSFER APPLICATION**

- ▶ Print the design.
- ▶ Cut the outlines.
- ▶ Place the **application tape** on the printed areas, rub under pressure and mirror on it.
- ▶ Weed the unprinted areas off the application tape.
- ▶ Remove the backing paper from **FOREVER Solvent-Dark**.
- ▶ Place the **application tape Solvent** with the printed areas on the garment.
- ▶ Press for 3-5 seconds.
- ▶ Remove the application tape immediately and cover the design with **Glossy Finish** (Antistick) **hot**, **High Gloss** and **Matte Finish** (Variotrans) **cold!**
- ▶ Press for 30 seconds.

Hint: For a faster transferring you can also directly press your logo on the t-shirt for 30 seconds with the Application Tape Solvent.

Hint: In order to avoid the cotton fibers from covering the image use the low tack Application Tape Solvent.

Hint: While working with a design that doesn't require an application tape, preheat the garment for 2-3 seconds in order to avoid the curling of the transfer.

▶▶▶ **WASHING**

- ▶ **Up to 40° C** (cold wash cycle).

▶▶▶ **IRONING**

- ▶ **When ironing cover the print with baking paper.**

▶ **ANY PROBLEMS?** Visit our website www.forever-ots.com
Click Video, choose the transfer paper, transfer machine, the product and watch the specific application!

►► Recommended Print Parameters for different Solvent-Dark Applications*

FOREVER Solvent-Dark 111 & FOREVER Solvent-Dark Metallic 121

	MATERIAL	COMPONENTS	TEMPERATURE		PRESSURE in bars	1. PRINT	2. PRINT
			(°C)	(°F)		with 5 sheets of copy paper on top	covered with Antistick or Variotrans
WASHABLE MATERIALS	Cotton T-Shirt (colored)	100% Cotton	200 °C	390 °F	5 bar	5 sec.	40 sec.
	Sweatshirt (white)	50% Cotton, 50% Polyester	180 °C	360 °F	5 bar	5 sec.	30 sec.
	Polyester (white)	100% Polyester	140-160 °C	280-320 °F	5 bar	5 sec.	30 sec.
	Polyester (white)	95% Polyester, 5% Lycra	140-160 °C	280-320 °F	5 bar	5 sec.	30 sec.
	Polyamid (white)	100% Polyamid	160 °C	320 °F	5 bar	5 sec.	30 sec.
	Polyamid (colored)	100% Polyamid	160 °C	320 °F	5 bar	5 sec.	30 sec.
	Perlon (colored)	100% Polyamid	160 °C	320 °F	5 bar	5 sec.	15 sec.
	Blended Fabric	95% Viscose, 5% Lycra	180 °C	360 °F	5 bar	10 sec.	20 sec.

NON-WASHABLE MATERIALS	Backpack Material		180 °C	360 °F	5 bar	5-10 sec.	---
	Neoprene		180 °C	360 °F	1 bar	5 sec.	---
	Synthetic Leather		180 °C	360 °F	5 bar	1 sec.	---
	Leather		180 °C	360 °F	5 bar	5-10 sec.	---
	Coated Paper		180 °C	360 °F	3 bar	5 sec.	---
	Wood		130 °C	270 °F	5 bar	20 sec.	---

*The above mentioned parameters are standard values and do not replace tests with the customer's own printers and inks and especially with their own transfer presses.