

## SUBLI-FLEX (NO-CUT)

FOR BLACK, DARK & COLORED COTTON

# 1-PAPER-SYSTEM



### PRINT SETTINGS

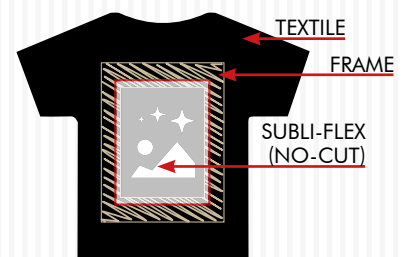
- **Image Mode:** mirrored
- **Media Settings:** see reverse
- **Colors:** You are able to control the final tone of your color! It is a mixture out of a base color from the sheet and the color you print on it with your printer. In every case, you must print a dense color (>100% = no halftones, pastel tones).
- **Color Chart:** Download the „SFNC Testchart“ in the download area on [www.forever-ots.com](http://www.forever-ots.com). If you press this chart with all Subli-Flex (No-Cut) colors onto a textile, you will have a great template to see which color is creating your desired result.

We recommend to do a Nozzle Check before each use of the printer to guarantee a perfect transfer. Please read the instructions of your printer to see how it works. If nozzles are clogged or not working properly, it leads to unclean, torn edges or incomplete transfers. If nozzles are clogged or you have replaced any ink cartridge, execute a head cleaning.



### TRANSFER PROCESS:

- The print-out has to be transferred immediately, as long as it is still wet!
- Place the T-Shirt on the lower plate of the heat press. The press has to be hot.
- Pre-Press the T-Shirt for 10 seconds.
- While pressing the paper it may happen that the edges transfer to the shirt as well. There are two options to avoid this:
  1. Tape the edges with a heat resistant tape.
    - Position and wrap the adhesive tape around the papers edge.
  2. Create a frame:
    - Cut out a window into one sheet which is 2-3 mm smaller than the actual transfer paper which you want to use.
- First place the frame onto the garment, then the transfer paper.
- Press as mentioned below.
- Peel the transfer paper immediately as long as it is hot.  
(Do not remove the T-Shirt from the press until the transfer paper is removed)
- For a better washability, place a sheet of Matt Finish Economy or Glossy Finish with the glossy side faced down on the design and press again with high pressure for 30 seconds.



### SETTINGS HEAT PRESS

	AUTOMATIC PRESS	MANUAL PRESS
PRESSURE	2-3 bar / 29-43 psi	Medium
TEMPERATURE	175-185°C / 347-365°F	175-185°C / 347-365°F
TIME	30-40 seconds	30-40 seconds
FIXING	30 seconds	30 seconds



### WASHING

- Up to 40°C (cold wash cycle). Inside out



### DRYING

- Do not tumble dry! Hang dry or line dry recommended



### IRONING

- When ironing cover the print with baking paper

Before starting a **mass production**, we recommend to make **transfer and washing test** with **all materials**. **Important advice for double-sided printing on textiles:** T-Shirts for a **double-sided print** (front side & backside), has to be put over the lower heat plate. In this case only one side will be treated with heat and you avoid that the applied design from the other side will be pressed out again. If your T-Shirt is yellowing, lay a piece of fleece onto it during the transfer process.

**SAWGRASS™**  
**SUBLIJET-HD**



**SAWGRASS**  
 SG400 & SG800  
**Paper Setting:** Inkjet Paper  
**Print Quality:** Priority Quality

Also compatible with:  
 Sawgrass VJ 628

**SAWGRASS™**  
**SUBLIJET-R**



**RICOH AFICIO**  
 SG3110DN & SG7100DN  
**Paper Setting:** Inkjet Paper  
**Print Quality:** Priority Quality

Also compatible with:  
 Ricoh GX e2600/3300N/5050N/  
 7000/7700N/e7700N

**PRINT >>>**  
 EQUIPMENT  
**SUBLI-SPLASH**



**EPSON**  
 WorkForce Pro WP-4015 DN & WF-8090 DTW  
**Paper Setting:** Normal Paper  
**Print Quality:** Strong

Also compatible with:  
 Ricoh SG 3110DN/7100DN  
 Ricoh GX e2600/3300N/5050N/  
 7000/7700N/e7700N  
 Epson Stylus Pro 4095/4450/4880

**COLOR COMBINATION CHART:**

	YELLOW		PURPLE		BLUE		GREEN		RED		BLACK	
Color	Light	Dark	Light	Dark	Light	Dark	Light	Dark	Light	Dark	BROWN	BLACK
<b>C</b>	0	0	0	100	100	100	0	100	0	0		
<b>M</b>	0	20	100	100	0	100	0	0	0	100		
<b>Y</b>	100	100	0	0	0	0	100	100	100	100	N/A	N/A
<b>K</b>	0	0	0	0	0	0	0	20	0	0		
<b>R</b>												
<b>G</b>												
<b>B</b>												

More colors are available for each of the Subli-Flex (No-Cut) colors. To find out which colors work, download the Subli-Flex (No-Cut) color chart from [www.forever-ots.com/downloads](http://www.forever-ots.com/downloads)



**TIPS:**

- If lines appear in the printouts, then a "Head Cleaning" is required.
- Ink should be replaced or refilled when the "Low Toner" warning message appears.
- "Head Cleaning" is required after ink cartridges are replaced.
- To prevent transfer issues, garments/surfaces should be cleaned before pressing the design.
- If particles are left after transferring to the garment, then reducing the pressure will prevent this.
- The rubber on the lower heat press plate should have a firm surface. If the rubber is too soft then transfer issues will occur.
- If the print-out is not wet, you have to use high pressure.