FOREVER
DIGITAL TRANSFER APPLICATIONS TECHNOLOGY
nothing's impossible

LASER-DARK (NO-CUT) LITE
FOR BLACK & DARK COLORED SURFACES

QUALITY DIGITAL SOLUTIONS
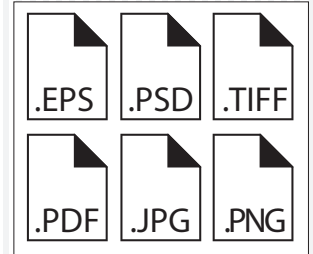#12, 5815 - 40 Street S.E.
Calgary, Alberta, T2C 2H6

403.262.6915   888.235.2838
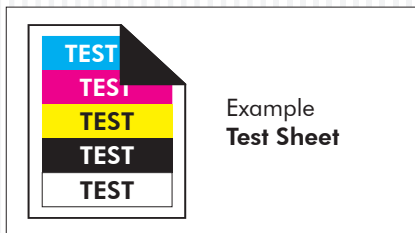**qualitydigitalsolutions.ca**

2-PAPER-SYSTEM
For LED-Printers With & Without White Toner

PRINTABLE FILE FORMATS:

.EPS .PSD .TIFF
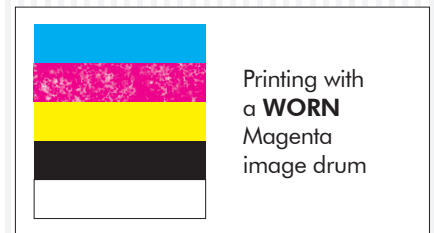.PDF .JPG .PNG

SUPPORTED FILE FORMATS

Generally, all common file formats can be used when printing with a White Toner OKI printer on to our transfer media. If you are not using **TransferRIP**, we recommend printing from CorelDraw. CorelDraw can import most of the popular file formats. For example, you can create and save your designs in any Adobe program or create and print directly from CorelDraw. Printing detailed designs from Photoshop requires more effort and is only possible with high-end graphic computers.

TEST	
TEST	Example
TEST	**Test Sheet**
TEST	
TEST	

Printing with **INTACT** image drums

Printing with a **WORN** Magenta image drum

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 (if you do not have one at hand, please refer to our website at www.forever-ots.com)
- 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 ready just in case.

IMPORTANT:
FOR CMYK DESIGNS WITHOUT WHITE TONER
Please note the Color Density (on the right) which is needed to achieve optimal results.

100%	(cyan)
100%	(magenta)
100%	(yellow)
100%	(black)

PRINTER SETTINGS:

USE THE **MULTI-PURPOSE TRAY** FOR FEEDING AND THE REAR OR SIDE TRAY FOR COLLECTING	**OKI** ES7411WT/ C711WT/PRO7411WT & **OKI** ES9420WT/ C920WT/PRO920WT	**OKI** PRO8432WT WITH +2 COLOR PAPER SETTING	**OKI** ES9541DN **OKI** C941DN	**OKI** LED CMYK	**OKI** PRO 6410 NEON COLOR
PRINT MODE	Transparency	**UserType 1**	Transparency	Transparency	Transparency
PAPER FEED	Multi-Purpose-Tray	Multi-Purpose-Tray	Multi-Purpose-Tray	Multi-Purpose-Tray	Multi-Purpose-Tray
COLOR SETTINGS:		COLOR PAPER SETTING: +2	**Use only with FOREVER TransferRIP5C**		
CYAN	0	0		0	0
MAGENTA	+2	0		0	0
YELLOW	+1	0		0	0
WHITE	-3	0		-	0
BLACK	-	-		0	0

IMPORTANT! If you use TransferRIP make sure that the printer is set to the factory settings!

IMPORTANT: FOR ES7411WT / C711WT / PRO7411WT - If you have used a different print mode other than "transparent foil", turn off your printer completely for at least 20 Minutes before printing on A-Foil.

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1. PRINT

- Print your design in **Mirror Image Mode** onto the **Matt Side** of the **A-Foil**.

2. HEAT PRESS

- Place the **A-Foil** in the middle of the lower plate (Printed side **facing up**).
- Place the **B-Paper Lite** on top of the A-Foil (coated side **facing down**).
- Cover with a sheet of **Silicone or Baking Paper**.

The **B-Paper Lite can be cut slightly smaller than the A-Foil.** This prevents your transfer press from becoming dirty.
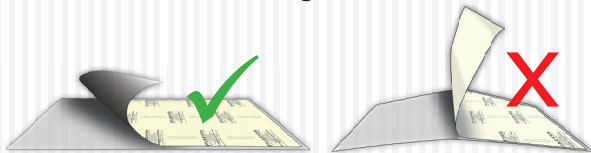
NOTE: It is possible that on unprinted areas some kind of white spots are appearing after pressing it with the B-Paper. To avoid that, put 5 sheets of normal copy paper onto the B-Paper Lite.

3. TRANSFER B-PAPER LITE TO A-FOIL

- Press the A-Foil & B-Paper Lite together at **150°C (300°F)** for **45-60 seconds** with **2-3 bar (29-43.5 psi) medium pressure**.

Increase the time to **75-90 seconds for full-scale White Toner & CMYK designs** (see **TABLE 1**).

- Separate the B-Paper Lite from the A-Foil without lifting them up from the lower plate of your heat press. Please work in a **SLOW, LOW & FLUID MOTION**.

- Cut around your design to remove the coating frame caused by the bleeding of the B-Paper Lite.

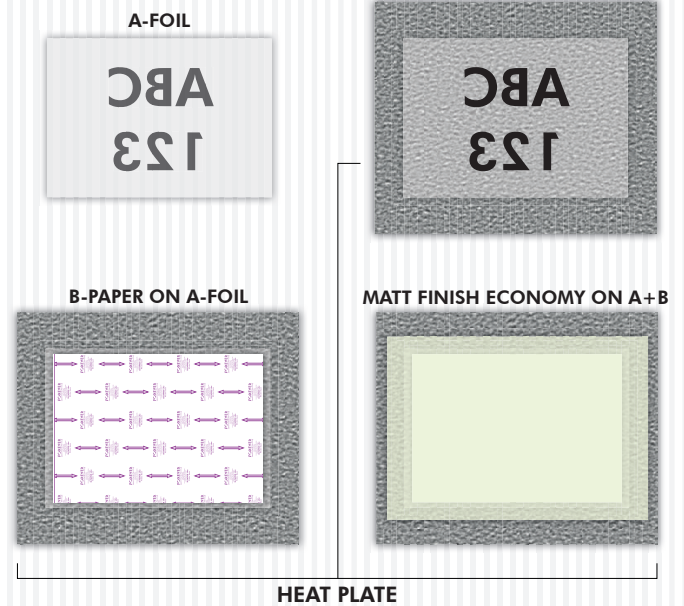## 4. APPLICATION TO TEXTILES & OTHER SUBSTRATES

- Place the textile or another substrate on the lower plate of the heat press.
- **Fix the transfer** by taping the corners of the A-Foil with **Heat Resistant Tape**.
- Press using the parameters shown in **TABLE 2**.
- Remove the A-Foil after it is **completely cold**.

5. FIXING

- It is important to **repress** the transfer properly to **soften the touch** and **increase the washability**.
- For a **Matte Finish** use our "**FOREVER Matte Finish Economy**" and press for 1-2 seconds with temperature and pressure as indicated in TABLE 2.
- For a **Glossy Finish** use our "**FOREVER Glossy Finish**" Paper and press for 1-2 seconds with temperature and pressure as indicated in TABLE 2.

As the B-Paper Lite was especially **developed for merchandising products only**, it is **not recommended** for products and materials, **which need to be highly washing resistant**. It is also not recommended to use on highly flexible or stretchable materials.

A-FOIL

ABC
123

B-PAPER ON A-FOIL

MATT FINISH ECONOMY ON A+B

HEAT PLATE

TABLE 1: B-PAPER LITE TO A-FOIL			
🖨	°C °F	🕐	↕
OKI WHITE TONER	**150°C 302°F**	**45 - 60 sec. 75 - 90 sec.**	**2 - 3 Bar 29 - 43.5 PSI**
CMYK	**150°C 302°F**	**75 - 90 sec.**	**2 - 3 Bar 29 - 43.5 PSI**

IMPORTANT: Different CMYK printer manufacturers use different types of toner. The settings above are only reference values! Finding out the optimal temperature and time requires experimentation.

TABLE 2: TEXTILES & OTHER SUBSTRATES			
👕	°C °F	🕐	↕
COTTON	100 - 150°C 212 - 302°F	1-5 sec.	2 - 3 Bar 29 - 43.5 PSI
POLYESTER	120 - 130°C 248 - 266°F	1-5 sec.	2 - 3 Bar 29 - 43.5 PSI
POLYPROPYLEN	105°C 220°F	1-5 sec.	2 - 3 Bar 29 - 43.5 PSI
BLEND FABRIC	120 - 130°C 248 - 266°F	1-5 sec.	2 - 3 Bar 29 - 43.5 PSI
PAPER/CARTON	100°C 210°F	1-5 sec.	1 - 2 Bar 14.5 - 29 PSI
BOOK COVERS	110 - 120°C 230 - 250°F	1-5 sec.	1 - 2 Bar 14.5 - 29 PSI

ABC
123

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FINISHING WITH HOT STAMPING FOILS
ONLY FOR LASER-DARK (NO-CUT) A-FOIL & B-PAPER AND ALSO A-FOIL & B-PAPER LITE

TRANSFER SETTINGS (B-PAPER):

	°C / °F	⧖	⬍
B-PAPER TO A-FOIL	**155°C / 310°F**	**90 Sec.**	2-3 Bar / 29-43.5 psi / **medium pressure**
TRANSFER ON THE SUBSTRATE WITH B-PAPER	**155°C / 310°F**	**5-10 Sec.**	2-3 Bar / 29-43.5 psi / **medium pressure**
HOT STAMPING FOIL WITH B-PAPER	**155°C / 310°F**	**30 - 45 Sec.**	5 Bar / 72.5 psi / **high pressure**

TRANSFER SETTINGS (B-PAPER LITE):

	°C / °F	⧖	⬍
B-PAPER LITE TO A-FOIL	**150°C**	**45 - 60 Sec.**	2-3 Bar / 29-43.5 psi / **medium pressure**
TRANSFER ON THE SUBSTRATE WITH B-PAPER LITE	**100 - 150°C / 212 - 310°F**	**1 - 5 Sec.**	2-3 Bar / 29-43.5 psi / **medium pressure**
HOT STAMPING FOIL WITH B-PAPER LITE	**100 - 150°C / 212 - 310°F**	**10 Sec.**	5 Bar / 72.5 psi / **high pressure**

HSF+ FINISHING WITH HOT STAMPING FOILS:

PREPARATION OF THE TRANSFER:
• **Print** your design using **CMYK BLACK** (4-Color-Black*)
  & **Press** with B-Paper (See Table above).
• **Separate** the B-Paper from the A-Foil while HOT, in a **Slow, Low & Fluid Motion**.
• **Cut** around your transfer to remove the coating frame.

TRANSFER TO TEXTILE
• **Place** the transfer on your textile & **press** together (See Table above).
• **Wait** until the **textile has completely cooled down**, BEFORE removing the
  A-Foil!

APPLYING THE HOT STAMPING FOIL
• **Place** the desired sheet of Hot Stamping Foil on your design, cover it with a sheet
  of **Matt Finish Economy** & **press** together (See Table above).
• **Wait** until the Hot Stamping Foil has **completely cooled down**, BEFORE removing.

DURABILITY AND WASHABILITY
• **B-PAPER:**
  Wash resistant up to 40°C (Cold Wash Cycle).

• **B-PAPER LITE:**
  40°C Hand wash. As the B-Paper Lite was especially developed for merchandising products only,
  it is not recommended for products and materials, which need to be highly washing resistant. It is also not recommended to
  use on highly flexible or stretchable materials.

TIP: Use a textile to rub over the finished design to remove left-over HSF particles!
* 4-Color-Black consists of 100% Cyan, 100% Magenta & 100% Yellow!