UNINET

ICOLOR PAPER ™

IColor™ Select 2 Step™ Transfer Paper Instructions

Part # ICHTSELA4 (8.27" x 11.69") (210mm x 297mm)
Part # ICHTSELA3 (11.7" x 16.5") (297mm x 420 mm)
Part # ICHTSELA4XL (8.27" x 17") (210mm x 432 mm)
Part # ICHTSELTABXL (11.8" X 19") (300mm x 483mm)

AVAILABLE IN A4, A4XL, A3 AND TAB XL PAPER SIZES

Temperature	Time	Paper Setting	Pressure
310°F / 154°C	120 / 25 Seconds	IColor™ 500/600 - Media Type: Transparency / Media Weight: UH1 IColor™ 650 - Media Type: User Type 2 / Media Weight: UH2 IColor™ 550/540 - Paper Type: Coated Glossy IColor™ 560 - Paper Type: Thick to 105g IColor™ 800 - Paper Type: Thick to 300g	8

The IColor™ Select 2 Step™ Transfer Paper set will allow you to transfer prints from the IColor™ series of printers (including white and fluorescent color prints) and most laser printers, onto a variety of garments, especially dark fabrics. The translucent adhesive applied as a result of the 2 Step process increases the adhesion to your garment for increased durability, and stretchability on your finished product. Rasterization and breathability integrated into your design, as well as using the garment color as a mask, will enhance the stretch limit and softness of your finished product.

IColor™ Select 2 Step™ Transfer Paper works at a higher temperature as compared to the IColor™ Premium paper (310°F / 154°C), so some care must be taken when pressing onto some types of synthetic material such as nylon or polyester. Spandex or Lycra material is not recommended at this temperature. This paper has several advantages which complements UNINET'S robust line of transfer paper. It has a matte texture instead of a shiny finish, and has a very strong adhesive which helps prevent images from pulling apart. This lower cost paper is a great everyday choice for textile transfers.

IColor™ Select 2 Step™ Transfer Paper is a weed-free system, enabling you to produce detailed, high quality images while dramatically reducing your production time.

Finished garments will last between 30 to 50 washes depending on how it's laundered.

- It is recommended to wash finished garments inside out in cold or warm water and low agitation.
- Avoid fabric softener.
- Tumble dry on low setting - 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.

Designed to work with the IColor™ series of specialty printers, the IColor™ Select 2 Step™ Transfer Paper will also work with many popular color laser printers - please check with your printer manufacturer for compatibility. White toner enabled printers are highly suggested for best results.

IColor™ Select 2 Step™ Transfer Paper is used as a set, comprising of a 'Transparent Transfer Sheet' and an 'Adhesive Sheet'. Note that these are sold as a set and cannot be sold individually.

INSTRUCTIONS FOR BEST RESULTS:

1. Place the transparent transfer sheet into the appropriate tray of the IColor™ printer.

⚠ The coated, rough side is the print side.

- IColor™ 650 / 600 / 500 / Most OKI Printers: Print side face up in the Multipurpose Tray
- IColor™ 550 / 540 / 800: Print side face down in the Bypass Tray
- IColor™ 560: Print side face down in bypass tray or print side face up in tray 1 (ProRIP defaults to bypass tray)

⚠ To avoid printer jams in Tray 1, stack a few sheets in the tray at once so the printer pulls the paper cleanly.

2. Printer Settings:

In the RIP software settings, choose the paper type according to the printer being used. Make sure you are working within the overprint queue in the ProRIP software or 'B' Configuration if using the TransferRIP software.

⚠ Specific print modes and sizes for this paper are available when using the IColor™ ProRIP software.

- Listed as 'UNINET IColor 2 Step Select'
- The page size should match the size of the paper being used (A4, A4 XL, A3 or TAB XL).

Otherwise, use the following settings based on the printer:

- IColor™ 600 / 500 / Most OKI Printers: Set media type to 'Transparency' and media weight to 'Ultra Heavy 1'
- IColor™ 650: Set media type to 'User Type 2' and media weight to 'Ultra Heavy 2'
- IColor™ 550 / 540: Set paper type to 'Coated Glossy'
- IColor™ 560: Set paper type to 'Thick to 105g'

AVOID MISFEEDS OR JAMS IN THE ICOLOR™ 560

⚠ Maximum print length is 14". Do not run the A4 XL media or longer lengths.

- IColor™ 800: Set paper type to 'Thick to 300g' (Thick to 220g can be used for low coverage graphics without black print)

⚠ If not already done automatically in the RIP, remember to set the job to mirror print, ensuring the correct orientation when transferred to the substrate.

⚠ White overprint should be set to 225% for the IColor™ 560/550/540, 300% for all other models.

NOTE FOR IColor™ 560/550/540 ONLY: For a brighter or more vibrant image, use the Ultra Bright Version. If not, you can print on the adhesive sheet, but do so at your own risk.

⚠ UNINET does not cover fuser damage if a jam occurs, so pay particular attention to the print settings.

- See the Tech Tips section on 'increasing brightness' and 'increasing vibrancy' for more details.

3. Print the image.

4. Preheat the press to 310°F / 154°C and keep the press closed for at least 5 minutes before proceeding to heat up the lower platen.

- This step is extremely important to ensure a good bond during the marrying process.
- Do not proceed until you feel the heat radiating from the bottom of the press platen, or you may experience incomplete transfers.

5. Place the printed image in the middle of the press with the printed side facing up.

- Place the adhesive sheet on top of the print, adhesive coated side down – the image and the adhesive should be face-to-face.

⚠ Adhesive side is the smooth, coated side. Back of the paper has one grey stripe printed across the page.

- TIP: Fold a small corner of the adhesive sheet over, prior to pressing (this will make it easier to peel apart after pressing).

6. Cover the 2 sheets with kraft paper, IColor™ black or white marrying cloth, and press the two sheets together in the heat press at 310°F / 154°C for 120 seconds with medium high pressure.

⚠ If you do not have and IColor™ marrying cloth, you can use kraft paper or one ply of a cotton or polyester T shirt, but if you experience marrying defects, it's suggested to use the cloth for best results.

⚠ If your graphic has significant dark or black aspects, it may be necessary to press at 340°F / 171°C for 135 seconds to allow for proper adhesion to the adhesive sheet.

⚠ Do not cover with a PTFE-based sheet as it may cause defects.

⚠ Users might notice some magenta staining on the adhesive sheet when printing with the IColor™ 540/550/560/800 series printers and a slight greenish tint when printing with the IColor™ 650. In all cases, it does not affect the image quality.

⚠ If areas of darker colors appear blotchy or inconsistent after pressing, see Tech Tips.

7. Open the press and immediately (while hot) - rub the paper with a piece of textile for 5 seconds, then peel the adhesive sheet away from the transparent transfer sheet diagonally in one slow, low and fluid motion.

- This must be done with the sheets on the press to minimize heat loss. The use of heat resistant gloves will help keep the paper in place due to the temperature of the lower platen.
- TIP: In order to avoid a faulty peel, it is recommended to peel from the side of the image with the greatest toner density.
- TIP: For images with a lot of black print (especially when printing with the IColor™ 800W and IColor™ 650), it may be necessary to press for a longer period of time and increase the dwell time in order to achieve a clean adhesive pull.
- TIP: Slow down at the end of the peel and allow the adhesive sheet to 'fall off' to ensure that you do not lose the last edge of the graphic.

8. 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. See Tech Tips for reasons why this may have happened.
- Examine the transfer sheet to determine if the transfer is acceptable and proceed to Step 9. Discard the used adhesive sheet.

9. Trim off the edges of the transparent transfer sheet using a pair of scissors or a cutting board. This will ensure no excess adhesive sticks to the garment and eliminate the chance of a white box around your design.

10. Place or thread 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.

11. Cover the transfer sheet and garment with kraft paper or a PTFE-based sheet and press the garment at 310°F / 154°C for 25 seconds with high pressure for cotton textiles.

- If you are pressing onto 100% poly, press at 265°F / 129°C.
- If you are pressing onto 50/50 cotton/poly, press at 285°F / 140°C.
- You can perform this step ONLY as low as 250°F / 121°C if necessary to avoid dye migration on polyester fabrics.
- TIP: Pressing at a lower temperature in all cases will result in a more vivid final product.

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

13. Once the garment is completely cooled, carefully peel away the transfer sheet in one smooth, continuous rolling 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. Perform this step within 60 mins or less.
- TIP: If you are encountering resistance when peeling (climate changes can affect this), you can instead use the quick pull method and peel the sheet away 'like a band-aid'; one quick, fast pull.

14. Re-Pressing (AKA post press or fixing press) the image into the garment is required for wash durability.

- Place the textile back on the heat press
- Cover with kraft paper or IColor™ T. Seal, for a matte finish.

⚠ TIP: UNINET recommends re-pressing at a lower temperature to retain the vibrancy of the image. A hotter post press may dull out the pressed image. Repress at 265°F / 129°C for 30 seconds with heavy pressure to increase durability.

- If re-pressing at 310°F / 154°C, do so for only 10 seconds.

15. Wait 10 seconds before removing the fixing or kraft paper to avoid any part of the transfer from sticking to the cover sheet.

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

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

• If your presses are not pulling cleanly, preheat the lower platen of the press in the closed position for several minutes to retain the necessary heat to perform this step.

• Toner Coverage: Halftones in image may cause undesired results. Toner coverage should not be less than 70% otherwise there may be issues with transferring the adhesive to the transfer sheet. The RIP will add the necessary amount of white to the image to avoid this situation. Those printing outside of the RIP software may encounter issues such as incomplete adhesive transfer.

• 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 (recommended). Clam shell and other types of swing away presses may also yield different results. Always place the transfer paper in the middle of your heat press. Some heat presses do not have uniform heat and pressure distribution, which can affect your final project.

⚠ 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.

Increasing brightness:
For IColor™ 560/550/540 owners only: If printing with the IColor™ 550/540 printer, use up to 280% white coverage for a brighter image. However, using too much white can result in washed out colors. If this is the case, proceed to the next section, 'increasing vibrancy'. Alternatively, use the Ultra Bright version of this paper for more vivid and brighter images.

Increasing vibrancy:
For IColor™ 560/550/540 owners only: If a more vivid image is required after using the above suggestions, you can print on the adhesive sheet of the paper as well.

To print on the adhesive 'B' sheet using the IColor™ ProRIP software:

- Select the Underprint Queue and DO NOT MIRROR.
- Print mode should be set to 'transparency' and media setting to 'card stock'. This method will allow you to add a bit more white (280%) without the washed out look that may occur.

⚠ UNINET does not cover fuser damage if a jam occurs, so pay particular attention to the print settings. Do so at your own risk. Fusers are not covered under warranty.

To achieve the darkest black color:
For all IColor™ printers (except the 650 & 800W): Set the color of the black portions of your artwork to 100% C, 100% M, 100% Y. It may be necessary to do this from the RIP, as some file formats may convert differently than others once imported.

For the IColor™ 800W only: Set the color of the black portions of your artwork to 90% C, 90% M, 80% Y.

For the IColor™ 650 only: Set the color of the black portions of your artwork to 80% C, 80% M, 70% Y.

⚠ The ProRIP color profile will adjust the black portions of your artwork for you automatically when you choose the correct print mode (IColor™ 800W & 650 only). Be sure you are working with the latest print mode update!

During Step 6 of these instructions, it is important that the adhesive sheet is placed on top because:

- The source of heat is on top and heat is transferred directly to the adhesive sheet instead of passing through the transfer sheet
- When pulling the sheets 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 while hot.

If, after performing Step 7, certain colors appear 'blotchy' or inconsistent, it is recommended to use the IColor™ black or white cotton cover cloth, or a piece of cotton or polyester fabric on top of the cover sheet and when pressing to the adhesive. This slows the rate at which the transfer heats up and assists with evening out the pressure when pressing.

During Step 7, 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 or rasterized 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 graphics are not recommended.

If, during Step 8, your images are not peeling cleanly, first ensure that you are printing the right amount of white over your image.

- If so, then preheat the bottom platen of your heat press to ensure it's hot enough. Cool lower platens are the main cause of inconsistent A/B pulls.
- If this still does not resolve the issue, consult the Humidity and Storage section on page 6.
- When pressing large areas of black (especially using the IColor™ 800W), it may be necessary to increase the press time from 120 sec to 200 sec because of heavier than normal toner coverage. Increasing the dwell time before pulling will also help with adhesion.

If, during Step 11, you are adjusting the heat press temperature to accommodate delicate material, you must increase the temperature to 310°F / 154°C for Step 6. The adhesive will not transfer over properly if set at a lower temperature. Using two heat presses would greatly increase your output and is recommended.

For Cotton / Poly blends and hoodies:

- Press at 250°F / 121°C for 20 seconds, cool immediately and roll the transfer sheet off very tightly.
- Repress for 15 seconds and cool immediately. A lower press temperature and immediate cooling are necessary to prevent dye migration.

If you are seeing stray adhesive sticking to your garment or substrate during the transfer Step 11 of these instructions, try reducing the press pressure to 'medium' or '5'.
If some of your image isn't sticking to the garment properly during Step 13, start your pull from an area that has the most toner coverage.

- For example, DO NOT 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.

On a lower quality press when heat distribution is an issue, you can increase your success rate by using a black piece of cotton fabric over the A/B sheet during Step 6, and pressing at 335°F / 168°C for 120 seconds. Make sure to reduce temp when pressing to the garment. Using 2 heat presses would greatly increase your output.

Humidity Suggestions: If your transfers are incomplete (gaps or holes where the adhesive didn't transfer over), then your adhesive paper may have been affected by humidity.
Follow these steps to remove the humidity:

- Place the adhesive sheet(s) face up in the heat press while hot.
- Do not press them, just allow to sit for approximately 1 – 2 minutes. Then proceed as normal.

Adhesive sheet storage: To prevent humidity from affecting your paper, store in a resealable bag. Adding a silica pack if not already provided will help to absorb any moisture. Use of a de-humidifier will help reduce excess moisture.

Optimal Humidity Level: 45% - 65%

- Regulated with A/C, a humidifier or de-humidifier, depending on current atmospheric conditions.

Optimal Temperature Range: 50°F / 10°C - 75°F / 24°C

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

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 assist 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 washability or scuff-resistance when applying transfer paper to such materials.

It is recommended to wash finished garments inside out in cold or warm water and low agitation. Avoid fabric softener, as it may prematurely degrade the transfer. Tumble dry on low setting - 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™ Select Transfer Paper, visit www.icolorprint.com/video

OPTIONALLY AVAILABLE

IColor™ SmartCUT Software

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™ Standard and Select 2 Step™ Transfer Paper. Trial version available at https://www.icolorprint.com/support

ALSO AVAILABLE:

- IColor™ Premium 2 Step Transfer Paper for light and dark colored garments
- IColor™ Select and Select Ultra Bright 2 Step Transfer Paper for light and dark colored garments
- IColor™ Standard 2 Step Transfer Paper for light and dark colored garments
- IColor™ Glitter Adhesive 2 Step Transfer Paper (for use with IColor™ Standard 2 Step Transfer Paper)
- IColor™ Light 1-Step Transfer Paper for light colored garments
- IColor™ Presto 2 Step Transfer Paper for textiles and hard surfaces
- IColor™ Temporary Tattoo 2 Step and Easy Tattoo Transfer Paper
- IColor™ Premium and Wood and Leather Hard Surface 1-Step Transfer Paper
- IColor™ AquaClear 1-Step Transfer Paper for candles and other substrates not resistant to heat
- IColor™ Label / Sticker Paper (Clear and White) in Letter and Tabloid size
- IColor™ Window Cling Media (Clear and White) in Banner and cut sheet options
- IColor™ Banner Paper
- IColor™ Magnetic Media in Letter and Tabloid size

…and more! Contact your dealer for more information.

IColor™ Transfer Paper Comparison Charts

ICOLOR TEXTILE TRANSFER PAPER

ATTRIBUTE	PREMIUM	STANDARD	SELECT UB	SELECT	PRESTO	LIGHT	SPEEDTRANS LIGHT
PROCESS	2 Step	2 Step	2 Step	2 Step	2 Step	1 Step	1 Step
DURABILTY (# of Washes @ 104 °F/40 °C)	Up to 100	50+	50+	50+	50+	15+	15+
DARK TEXTILES (BRILLANCE)	BEST	BETTER	BEST	GOOD	BETTER	FAIR	FAIR
DELICATE TEXTILES	BEST	GOOD	GOOD	GOOD	GOOD	DT RECOMMEND	NOT RECOMMENDED
STRETCHABILITY	BETTER	GOOD	BEST	BEST	GOOD	GOOD	GOOD
FINISH	MATTE	SEMI GLOSS	MATTE	MATTE	SEMI GLOSS	SATIN	SATIN
TRANSFER 'A' SHEET CHARACTERISTIC	OPAQUE	TRANSPARENT	TRANSPARENT **	TRANSPARENT	OPAQUE	OPAQUE	OPAQUE
PRESS TEMPERATURE (°F/°C)	250°F / 120°C	310°F / 154°C	320°F / 160°C	310°F / 154°C	285°F / 140°C	390°F / 200°C	375°F / 190°C
PRESS TIME	30 + 30 secs	120 + 30 secs	135 + 25 secs	120 + 25 secs	120 + 30 secs	15 secs	10 secs
SOFT HAND	BEST	GOOD	GOOD	GOOD	GOOD	BETTER	BETTER
COST	$$$	$$	$$	$$	$$	$	$

ICOLOR HARD SURFACE TRANSFER PAPER

ATTRIBUTE	PREMIUM	CERAMICS	WOOD/LEATHER	PRESTO! HARD SURFACE	PRESTO! PAPER/WOOD	AQUACLEAR	2 STEP TATTOO	1 STEP TATTOO
PROCESS	1 Step	1 Step	1 Step	1 Step	1 Step	1 Step	2 Step	1 Step
DURABILTY (RESISTANT TO SCRATCHING/CHIPPING	BEST	BEST	BEST	BEST	BEST	GOOD	BETTER	GOOD
COLOR BRILLIANCE	BETTER	BETTER	BETTER	BEST	BEST	BETTER	BETTER	BETTER
METALLIC FINISH	NO	NO	NO	YES	YES	NO	NO	NO
PRESS TEMPERATURE (°F/°C)	300°F / 150°C *	300°F / 150°C *	300°F / 150°C *	320°F / 160°C *	265°F / 130°C *	N/A	265°F / 130°C	N/A
PRESS TIME	60 SECS *	180 SECS *	60 SECS *	180 SECS *	90 SECS *	N/A	40 SECS	N/A
ACRYLIC	YES	YES	YES	YES	NO	YES	YES	YES
METAL	YES	NO	NO	YES	NO	YES	YES	YES
CERAMIC	YES	YES	NO	YES	NO	YES	YES	YES
TILE	YES	YES	NO	YES	NO	YES	YES	YES
GLASS	YES	YES	YES	YES	NO	YES	YES	YES
CRYSTAL	YES	YES	YES	YES	NO	YES	YES	YES
PAPER/WOOD/CARDBOARD	YES	NO	YES	YES	YES	NO	YES	NO
LEATHER	YES	NO	YES	NO	NO	NO	YES	NO
CANDLES	NO	NO	NO	NO	NO	YES	YES	YES
FLESH	NO	NO	NO	NO	NO	NO	YES	NO
COST	$	$	$	$$	$$	$$	$$$	$$

* Temperature and press time varies based on substrate

Dec 2023 Revision