

Transfer Instructions for:  
**FOREVER Solvent-Dark 113**  
 for DARK TEXTILES (100% COTTON)



**PRINT SETTINGS:**

- 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:**

	<b>AUTOMATIC HEAT PRESS</b>	<b>MANUAL HEAT PRESS</b>
PRESSURE	<b>5 bar (70 PSI)</b>	<b>maximum</b>
TEMPERATURE	<b>180°C (356°F)</b>	<b>180°C (356°F)</b>
TIME	<b>5 + 30 seconds</b>	<b>5 + 30 seconds</b>



**TRANSFER APPLICATION:**

- **Print** the design on **FOREVER Solvent-Dark 113**.
- **Cut** the outlines.
- **Place** the application tape (high tack) on the printed areas, rub under pressure on it.
- **Remove** the backing paper from **Solvent-Dark 113**.
- **Weed** the unprinted areas off the application tape.
- **Place** the application tape with the printed areas on the garment.
- **Place** 5 sheets of copy paper on it and press for 5 seconds.
- **Remove** the application tape immediately and cover the design with Glossy Finish or Matte Finish Economy!
- **Press** again for 30 seconds and remove the paper while it is warm.



**WASHING:**

- **Up to 40°C** (cold wash cycle).



**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** (frontside & 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.

Recommended Print Parameters for different Applications\*:  
**FOREVER Solvent-Dark 113**

**WASHABLE MATERIALS**

MATERIAL	COMPONENTS	TEMPERATURE		PRESSURE	1. PRINT	2. PRINT
		(°C)	(°F)	in bar	5 sheets of copy paper on top	covered with Antistick or Variotrans
<b>Cotton T-Shirt (Colored)</b>	100% Cotton	200°C	390°F	5 Bar	5 Sec.	40 Sec.
<b>Sweatshirt (white)</b>	50% Cotton, 50% Polyester	180°C	360°F	5 Bar	5 Sec.	30 Sec.
<b>Polyester (white)</b>	100% Polyester	140°C - 160°C	280°F - 320°F	5 Bar	5 Sec.	30 Sec.
<b>Polyester (white)</b>	95% Polyester, 5% Lycra	140°C - 160°C	280°F - 320°F	5 Bar	5 Sec.	30 Sec.
<b>Polyamid (white) &amp; (colored)</b>	100% Polyamid	160°C	320°F	5 Bar	5 Sec.	30 Sec.
<b>Perlon (colored)</b>	100% Polyamid	160°C	320°F	5 Bar	5 Sec.	15 Sec.
<b>Blended Fabric</b>	95% Viskose, 5% Lycra	180°C	360°F	5 Bar	10 Sec.	20 Sec.

**NON-WASHABLE MATERIALS**

<b>Backpack-material</b>		180°C	369°F	5 Bar	5-10 Sec.	----
<b>Neoprene</b>		180°C	360°F	1 Bar	5 Sec.	----
<b>Synthetic Leather</b>		180°C	360°F	5 Bar	1 Sec.	----
<b>Leather</b>		180°C	360°F	5 Bar	5-10 Sec.	----
<b>Coated Paper</b>		180°C	360°F	3 Bar	5 Sec.	----
<b>Wood</b>		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.