

LASER-DARK (NO-CUT) LITE

FOR BLACK & DARK COLORED SURFACES

2-PAPER-SYSTEM

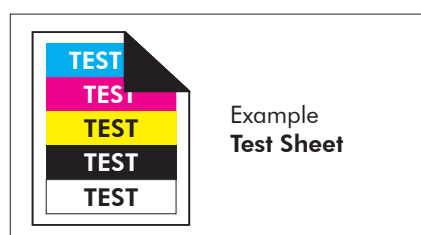
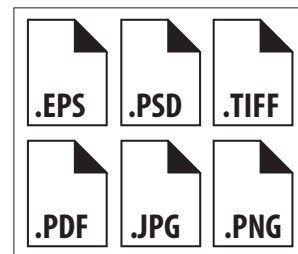
For LED-Printers With & Without White Toner



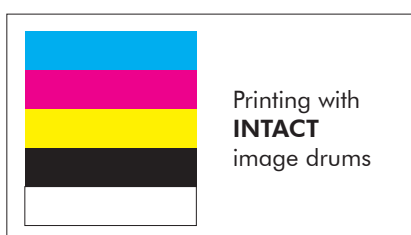
SUPPORTED FILE FORMATS

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.

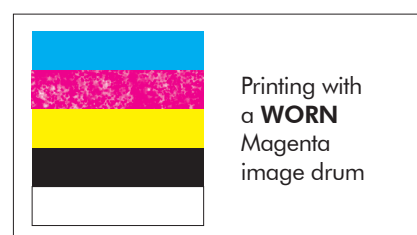
PRINTABLE FILE FORMATS:



Example
Test Sheet



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%
100%
100%
100%



PRINTER SETTINGS:

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

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.



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

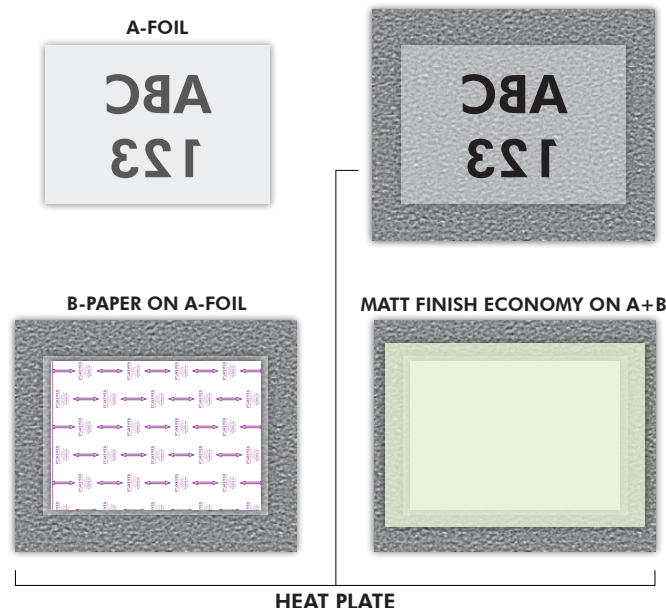
- Place the textile or another substrate on the lower plate of the heat press.
- Fix the transfer** by taping the corners of the A-Foil with **Heat Resistant Tape**.
- Press using the parameters shown in **TABLE 2**.
- Remove the A-Foil after it is **completely cold**.



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.



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

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



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!

