



▶▶▶ INSTRUCTIONS

Instructions for Printing onto Dark Textiles made out of 100% Cotton with FOREVER Solvent-Dark 113

▶▶▶ PRINT SETTINGS

IMPORTANT!

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

	AUTOMATIC HEAT PRESS	MANUAL HEAT PRESS
PRESSURE	5 bar (70 PSI)	Maximum
TEMPERATURE	180°C (356 F)	180°C (356 F)
TIME	5 + 30 seconds	5 + 30 seconds

▶▶▶ TRANSFER APPLICATION

- ▶ Print the design.
- ▶ Cut the outlines.
- ▶ Place the **application tape (high tack)** on the printed areas, rub under pressure on it.
- ▶ Weed the unprinted areas off the application tape.
- ▶ Remove the backing paper from **FOREVER Solvent-Dark 113**.
- ▶ Place the **application tape** with the printed areas on the garment.
- ▶ Press for 5 seconds.
- ▶ Remove the application tape after 5 seconds and cover the design with **Glossy Finish** (Antistick) 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.**

►►► **Recommended Print Parameters for different Solvent-Dark Applications***

FOREVER Solvent-Dark 113							
	MATERIAL	COMPONENTS	TEMPERATURE		PRESSURE in bars	1. PRINT	2. PRINT
			(°C)	(F)		with 5 sheets of copy paper on top	covered with Antistick or Variotrans
WASHABLE MATERIALS	Cotton T-Shirt (colored)	100% Cotton	200°C	390 F	5 bar	5 sec.	40 sec.
	Sweatshirt (white)	50% Cotton, 50% Polyester	180°C	360 F	5 bar	5 sec.	30 sec.
	Polyester (white)	100% Polyester	140-160°C	280-320 F	5 bar	5 sec.	30 sec.
	Polyester (white)	95% Polyester, 5% Lycra	140-160°C	280-320 F	5 bar	5 sec.	30 sec.
	Polyamid (white)	100% Polyamid	160°C	320 F	5 bar	5 sec.	30 sec.
	Polyamid (colored)	100% Polyamid	160°C	320 F	5 bar	5 sec.	30 sec.
	Perlon (colored)	100% Polyamid	160°C	320 F	5 bar	5 sec.	15 sec.
	Blended Fabric	95% Viscose, 5% Lycra	180°C	360 F	5 bar	10 sec.	20 sec.

NON-WASHABLE MATERIALS	Backpack Material		180°C	360 F	5 bar	5-10 sec.	---
	Neoprene		180°C	360 F	1 bar	5 sec.	---
	Synthetic Leather		180°C	360 F	5 bar	1 sec.	---
	Leather		180°C	360 F	5 bar	5-10 sec.	---
	Coated Paper		180°C	360 F	3 bar	5 sec.	---
	Wood		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.