



EZ PEEL TRANSFER **HARD** INSTRUCTIONS *Surface*

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For DigitalHeat FX OKI 920WT, 8432WT and 9541WT

The **DigitalHeat FX EZ Peel Hard Surface transfer paper** is self-weeding and specially formulated to be heat pressed onto various hard goods that are dark, light and opaque. The transfer paper is designed to have improved durability than other types of transfer paper through additional scratch and UV resistance.

All hard goods are made differently, comprised of different chemical compositions and various adhesion qualities, which impact the durability of the transfer. Processes to improve adhesion qualities, such as flame treatment, corona discharge, or plasma treatment may be used to improve the durability of the transfer.

In general, hard surfaces that are porous will be more durable. Slick, glazed, or non-porous substrates will be less durable.

The below recommendations are baselines. Modifications may need to be made depending on the exact chemical composition and size of the substrate. Certain hard goods may be damaged from too much heat, temperature, or time in the transfer and/or finishing step. Operator discretion is advised.

Preheat your heat press using the chart below and preheat your oven to 375°F.
Refer to Step 7 for more information regarding your oven.

PRINTING

1. Load the **EZ Peel Hard Surface** transfer paper into the multi-purpose tray of your printer with the coated, glossy side face up (labeled side face down). Adjust the guides if necessary.
2. Import your graphic into the **Graphics Queue** of the **Print Optimizer** software.
 - a. **Paper size should remain 11x17 (Tabloid)**
 - b. Adjust the Media Type to **"User Type 1"** and the Media Weight to **"Ultra Heavy 3"**.
 - i. Double click on the file in the **Queue** to open the **Job Ticket Properties** menu.
 - ii. Click on the down arrow next to **Color Layer** on the left side of the window.
 - iii. Click on **Printer Options** (the third option from the Color Layer tab).
 - iv. Change the **Media Type** to **"User Type 1"** and the Media Weight to **"Ultra Heavy 3"**.
 - v. Click **OK** on the bottom right-hand side of the window to save your changes.
3. Make any necessary adjustments to the file and then press **PRINT**.

NOTE: The application of a silicone mat is required with the transfer process to avoid quality losses. With the assistance of the silicone mat, temperature and pressure are transferred carefully and evenly to achieve the best quality. The print medium must *always* be covered *fully* with the silicone mat to ensure the substrate does not get damaged from the heat.

TRANSFER

4. First, check the pressure of the heat press. Lay the substrate on the bottom platen of the heat press and then lay the silicone mat on top. Then, fully close the heat press and check the pressure reading. Adjust the pressure based on the guidelines in the chart below. Only heat apply the transfer once the pressure has been adjusted and is correct.

5. Ensure the heat press is preheated to the desired temperature. Then, heat apply the transfer to the substrate in your heat press using the parameters in the chart below:

The below chart should be used as a starting guide. Adjustments and further internal testing may be required to achieve desired results. Parameters were created using the Hotronix Fusion heat press. Any non-porous materials (e.g. metal, glass) should be cleaned with alcohol/mineral spirits & thoroughly dried before pressing. These items are often coated with oil or a protective coating to prevent corrosion or oxidation.

Print Medium 	Pressure 	Temperature 	Time 	Accessories
Metal (Aluminum, Stainless Steel, Sheet Metal)	Medium (5)	390°F	180 - 240 sec.	Silicone mat (3 mm)
Unfinished Wood (No paint, stain or polyurethane)	Medium (5)	390°F	90 - 150 sec.	Silicone mat (3 mm)
Glass / Mirrors	Medium (5)	390°F	120 - 180 sec.	Silicone mat (3 mm)
Ceramic Tile	Medium (5)	390°F	240 - 300 sec.	Silicone mat (3 mm)
Cardboard	Medium (5)	285°F	4 - 5 sec.	-
Mugs / Tumblers	Mug Press with heating from outside	265°F	180 sec.	-

6. When the time has elapsed, carefully remove the substrate from the heat press and place it in a safe place to completely cool down. Always peel the transfer paper cold. If you peel the transfer paper while the substrate is still warm, you will experience toner loss and the transfer paper won't fully peel off the substrate.

FINISHING STEPS

7. Ensure your **oven is preheated to 375°F**. You will not be using your heat press for the finishing step when using the **EZ Peel Hard Surface** transfer paper.
8. When your oven is preheated, carefully place the substrate in the oven. Bake/finish the substrate in the oven for half the time you used in the transfer step.

**For example, if you are finishing Wood, bake it for 45 - 75 seconds, Metal for 90 - 120 seconds, etc.*

Temperatures in Fahrenheit are given as approximate values. All information is based on findings obtained through internal testing using the Hotronix Fusion heat press. Because of the high number of factors which can have an effect during handling and application, further customer testing may be required.

For additional support, please contact support@coldesi.com or open a ticket at <https://support.coldesi.com/open-a-ticket/>.