

## 1. Machine Settings

**Important:** Machine must have one cushioned, soft surface

### Combo Top & Bottom Heat Machines *\*Recommended*

Top Platen Temp: 250° F (121° C)  
 Bottom Platen Temp: 350° F (178° C) with conductive rubber pad  
 Time: 15-20 seconds  
 Pressure: Medium  
 (40-60% of the pressure range of most machines.)

### Top Heat Only Machines *\*Only if bottom heat is not available*

Temp: 370° F (188° C)  
 Time: 30 seconds  
 Pressure: Medium  
 (40-60% of the pressure range of most machines.)

**NOTE:** Above settings are general recommendations. Every material and press varies. Please adjust your pressure according to your machine results. (Refer to page 2 for a more rigorous Testing Procedure to determine ideal settings. Staff are available to help with application issues.)

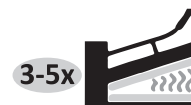
## 2. Pre-Test Fabric

Check fabric for melting, scorching, curling or other problems by applying heat at the temperature recommended above with soft, orange foam on top of the substrate. Application to waterproof/ water-resistant fabrics, leather or slick nylons is not recommended.



## 3. Warm-Up

Cycle the press 3-5 times to warm-up the machine. This is important for Top or Bottom Heat presses! Not necessary for Combo presses.



## 4. Place Transfer

Place transfer on fabric with the adhesive side down and required soft orange foam over face of transfer to prevent smashing.



## 5. Apply Heat

Apply heat for dwell time determined based on Testing Procedure results on Page 2.



## 6. Let Cool

Remove from heat press keeping flat, without pulling or twisting while warm, which can weaken the adhesion. Allow applied transfer to cool to the touch or to room temperature in a flat position.



## 7. Peel Film (for designs with freestanding elements only)

Peel away carrier backing, while checking that design is transferring. If not, repeat steps 3-6. If your transfer appears smashed or if you see an impression around your logo, decrease pressure and repeat steps 3-5.



## 8. Test Adhesion

Test transfer adhesion by machine washing with detergent. While still wet, try to pick off design. If the design only comes up slightly in the corners, then adhesion is satisfactory; if design can be peeled off in a continuous large piece, then adhesion is not satisfactory. Contact us for assistance.



## 9. Final Check

Properly applied, FiberLok apparel graphics look clear, feel soft, and will last the lifetime of the garment.



## 10. Care Instructions

Machine Wash No Bleach Tumble Dry Normal Lay Flat or Hang Medium Iron Dry Clean

\*\*\* IMPORTANT INFORMATION — DO NOT DISCARD! \*\*\*

### Quality Window Test Matrix

Temperature					
Dwell Time (seconds)	275° F (135° C)	300° F (149° C)	325° F (163° C)	350° F (178° C)	375° F (191° C)
4	<i>Test 1</i>	<i>Test 7</i>	<i>Test 13</i>	<i>Test 19</i>	<i>Test 25</i>
8	<i>Test 2</i>	<i>Test 8</i>	<i>Test 14</i>	<i>Test 20</i>	<i>Test 26</i>
12	<i>Test 3</i>	<i>Test 9</i>	<i>Test 15</i>	<i>Test 21</i>	<i>Test 27</i>
16	<i>Test 4</i>	<i>Test 10</i>	<i>Test 16</i>	<i>Test 22</i>	<i>Test 28</i>
20	<i>Test 5</i>	<i>Test 11</i>	<i>Test 17</i>	<i>Test 23</i>	<i>Test 29</i>
24	<i>Test 6</i>	<i>Test 12</i>	<i>Test 18</i>	<i>Test 24</i>	<i>Test 30</i>

### Heat Application Testing Set-up Procedure

*\*\*This procedure is optional and included for optimization\*\**

1. Pressure: Set heat press machine pressure to **Medium** for most transfer sizes. For larger transfers, increase pressure to **Medium-High**, which should be approximately 60-80% of the range of settings.
2. Use numbered textile test swatches to correspond to the italicized numbers in the above matrix.
3. Apply each with above settings; wash or pick test.
4. Mark failures in matrix with an "X" and passes with an "O".
5. Note pattern of passes (O), you have now established the Quality Window. Below is an example of a completed Quality Test Matrix.

### Quality Window Test Matrix

Temperature					
Dwell Time (seconds)	275° F (135° C)	300° F (149° C)	325° F (163° C)	350° F (178° C)	375° F (191° C)
4	<i>Test 1</i>	<i>Test 7</i>	<i>Test 13</i>	<i>Test 19</i>	<i>Test 25</i>
8	<i>Test 2</i>	X	X	<i>Test 20</i>	<i>Test 26</i>
12	X	O	O	X	<i>Test 27</i>
16	X	O	O	X	<i>Test 28</i>
20	<i>Test 5</i>	X	X	<i>Test 23</i>	<i>Test 29</i>
24	<i>Test 6</i>	<i>Test 12</i>	<i>Test 18</i>	<i>Test 24</i>	<i>Test 30</i>