

1. Machine Settings

Important: Machine must have one cushioned, soft surface

LumoTex[®] Heat Transfers

Temp: 325° F (163° C)

Time: 15-20 seconds

Pressure: Medium/Low
(30-40% 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.
(Please refer to Page 2 for a more rigorous Testing Procedure to determine ideal settings. Staff are available to help with any application issues.)

2. Pre-Test Fabric

Check fabric for melting, scorching, curling or other problems by applying heat at the temperature recommended above. Application to waterproof/water-resistant fabrics, leather or slick nylons is not recommended, due to adhesion or scorching problems. To maximize results, use the Testing Set-Up Procedure on the reverse side.



3. Place Transfer

Place transfer on fabric with the adhesive side down.
Recommended: Cover with a clean piece of application paper to keep items clean.



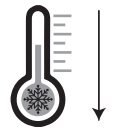
4. Apply Heat

Apply heat for specified dwell time based on Testing Procedure results on Page 2.
Once heat cycle is complete, remove application paper (if used).



5. 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.



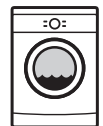
6. Peel Film (if applicable)

Prior to peeling film, let transfer cool to room temperature.
Peel away film backing, while checking that design is transferring.



7. Test Adhesion

Test transfer adhesion by machine washing with detergent. While still wet, try to pick off design. If the design 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.



8. Final Check

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



*** 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-Low** for most transfer sizes. For larger transfers, increase pressure to **Medium**, which should be approximately 40-60% 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>