





# Transfer Instructions for printing: FOREVER Multi-Trans Metallic Gold, Silver & Bronze for HARD SURFACES

**1-PAPER-SYSTEM**  
For Laser Printers with & without White Toner

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**IMAGE PREPARATION: VECTOR GRAPHICS**
  - Image: B&W & CMYK Printers: 100% Black
  - White Toner Printers: 300% Black (C: 100% + M: 100% + Y: 100% = 300% Composite Black)
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**PRINT SETTINGS: CMYW**
  - Paper & Print: Labels, Multi-Purpose Tray
  - Image Mode: Mirror Image, Color Mode, White: OFF
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**PRINT SETTINGS: CMYK + B&W**
  - Paper & Print: Labels, Multi-Purpose Tray
  - Image Mode: Mirror Image, Greyscale Mode
  - Density: Increase density if errors occur



**TRANSFER SETTINGS:**

MUGS	MUG PRESS SETTINGS
MUGS	160°C (320°F), HIGH Pressure

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**APPLICATION SETTINGS: MUGS**
    - Pre-heat your Mug Press before use.
    - Position & Fix the printed image to the mug using Heat Resistant Tape.
    - Cover the transfer with the FOREVER Mug Press Silicone Pad.
    - Place the mug in the press.
    - Press by using the settings above.
    - **IMPORTANT:** The timer should not start until the mug has reached the set temperature.  
If your press does not do this automatically, increase the press time to 4 minutes!
    - Cool the mug down by dipping into cold water . Make sure the transfer media is soft before peeling.  
ATTENTION: At this point, the mug is very HOT. Take precautions when moving the mug.
    - Clean any excess particles with Isopropanol (if necessary).
- ATTENTION: NEW APPLICATION TEMPERATURE: 160°C (320°F)**
- In case of a faulty or insufficiently scratch-resistant transfer, increase the temperature by 10-20°C (50-68°F)
  - For optimal transfer results, use a Canon LBP 6020 or Canon LBP 6030

**TRANSFER SETTINGS:**

HARD SURFACES	HEAT PRESS SETTINGS
GLASS & METAL	160°C (320°F) HIGH Pressure

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**APPLICATION SETTINGS: HARD SURFACES**
  - Set the temperature of the Heat Press to 200°C (392°F).
  - Pre-heat your Heat Press before use.
  - Position & Fix the printed image to the application using Heat Resistant Tape.
  - Place the Sensor of the Basic Digital Thermometer between the substrate and the transfer.
  - Cover the transfer with a Silicone Pad Speedy (2.5mm).
  - Press together until the Basic Digital Thermometer sensor displays the temperature shown in the table above.
  - Cool the surface down by dipping into cold water . Make sure the transfer media is soft before separating.  
ATTENTION: At this point, the application is very HOT. Be careful when moving the application.
  - Clean any excess particles with Isopropanol (if necessary).
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**TIPS & TRICKS:**
  - Using the FOREVER Mug Press Silicone Pad helps distribute the heat evenly around the whole mug & transfer.
  - The transfer area should be clean before fixing the transfer. The natural oil from our hands can cause unpredictable transfer results.
  - The Basic Digital Thermometer reads the exact surface temperature of the substrate, which is needed for constant transferring results.

**!** FOREVER only guarantees perfect results with mugs delivered through FOREVER. Transferring onto other mugs may not work. Customers should find their own settings for other mugs. FOREVER do not offer any support for mugs from other suppliers for Multi-Trans Metallic.