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## Roland Inkjet Fabric Transfer Material Instruction Sheet

1. Set-up for printing images onto **PCM-HTM Opaque Heat Transfer Material**:
  - If working with an EX or VersaCAMM printer (or any printer with heating elements), make sure the heat is OFF.
  - Insert transfer material into printer, the same as vinyl or film, making sure matte white (printable) side is up.
  - Print design right reading (as a standard decal). Contour cut image without cutting through the backer sheet. Suggested cut pressure is 60g force.
  - After contour cutting, weed excess material away from image to allow for easy image lift (to place on garment). If not contour cutting the image by machine, cut around the image by hand as close to the image as possible for best results.
  
2. Items that can take transfers:
  - Light or dark colored cotton or cotton/polyester blends work well.  
(Examples: T-shirts, polo shirts, baseball or golf hats, cotton duffle bags)
  
3. Heat Press application:
  - Pre-heat press to approximately 325° about 15 minutes prior to application.
  - Place item flat on the surface of the heat press and smooth wrinkles.
  - Pre-press garment for approximately 5 seconds.
  - Place printed image right side up on garment.
  - Cover printed image with a Teflon transfer pad or silica sheet (do not use standard transfer tape!) for a matte finish, or use shiny side of the HTM carrier sheet as a transfer cover for a glossy finish.
  - **Press for 4-6 seconds at 325° F with medium to firm pressure** when using a silica sheet or the carrier sheet. **Press for 8-10 seconds when using a Teflon sheet**, or if press temperature varies.
  - Remove the Teflon pad, silica sheet or HTM carrier sheet after pressing to see results and reheat if necessary.
  
4. Washing instructions:
  - Turn garment inside out to wash.
  - Wash in cold or lukewarm water. **Do not use bleach or harsh detergent!**
  - Hang dry or use cool setting on dryer. **Do not use hot temperature to dry!**

Note: **If garment needs to be ironed, omit ironing the transferred image.**  
**When storing Heat Transfer Material, keep it in a cool dry area. Do not leave it exposed to the sun for any period of time.**

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