



EnduraPress Heat Press



Please check with Library staff to confirm minimum age certification requirements to use this machine with supervision, and without supervision as provided on the Equipment Usage Chart

Certification

To become certified on this piece of equipment you will need to attend a training class that lasts approximately 30 minutes. By the end of the class you will be able to:

Print a design on the transfer paper

Know which transfer paper/printer to use according to the material being pressed

Adjust settings and timer on heat press for specific materials

Press transfer designs on various materials

To sign up for a training session please see the training binder (available at the front desk).

Reservation

To reserve this piece of equipment you will need to first be certified on this equipment. After you have attended a training for the equipment you may sign up for a time slot. To see available time slots and sign up for one please see the **Reservation Binder** (available at the front desk).

Your reservation reserves the equipment for you to use during that time, if you are more than 5 minutes late to your reservation time you will lose your reservation and the machine may be used on a first come-first served basis.

Reference Sheet

Approved Materials

Fabric: Cotton or Polyester or a blend of both

The following items are consumables provided by the Nebraska Library Commission that are available for heat pressing. This is not a comprehensive list because we continue to add items that we think the libraries may like to experiment with and use to stimulate their creativity. It is important to remember that anything you Heat Press must be able to withstand temperatures up to 400 degrees. If you wouldn't iron it at a high heat you would probably not want to Heat Press the item. Always check the label to ensure the composition of the materials you choose to use whether it is provided by the Library Commission or something you bring to press on.

Aprons

Light colored cotton T-shirts

Light colored polyester T-shirts

Light colored cotton/poly blend T-shirts

Mousepads

Mini Mousepads

Canvas bags

Poly bags

Wrap around Koozies

Machine Accessories

- Sublimation transfer paper
- Pigment Ink transfer paper
- Scissors
- Paper cutter (not included but would be helpful if available)
- X-acto knife
- Cutting matt

- Pigment ink or Sublimation ink
- Teflon sheet
- Teflon pillow (not in all studios)
- Gloves or hot pad
- Ruler
- T-square (not included but would be helpful if available)
- Epson Workforce Printers (Pigment and Sublimation)
- Refillable Ink Cartridges with bottles of Pigment and Sublimation Ink
- Syringe for refilling Ink Cartridges
- Heat resistant tape
- CorelDraw (graphic design software)

Important Information:

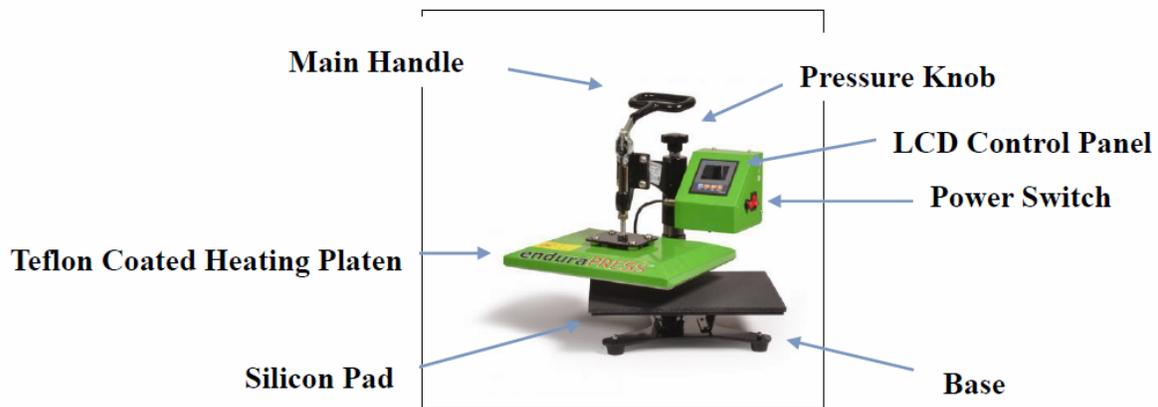
The heat press achieves temperatures of 400 °+, burn hazards exist with this process. There is also some risk of being cut with the scissors or the process of cutting the transfer paper.

Workflow:

Acquire images and open or import into CorelDraw
 Edit/adjust/size images
 Reverse the image
 Determine the composition of the material to be pressed with a design (cotton, polyester or blend)
 Select the correct printer ink type / transfer paper
 Print images on transfer paper
 Cut out images
 Set temperature, pressure and time on heat press
 Prepress to eliminate wrinkles and get rid of moisture
 Arrange material on heat press
 Place printed, cutout image on material upside down
 If using sublimation transfer paper tape down with heat resistant tape
 Cover with Teflon sheet
 Press material
 Remove from press
 Remove/peel off transfer paper from material

If pigment stretch T-shirt in all directions and then repress for 10 – 15 seconds with Teflon sheet over the design. Smooths out and sets the pigment design.

Heat Press Components



Correct voltage is 110-120V/60 Hz

Operation Instruction

1. Turn off the machine when not in use, and remove the power plug from socket.
2. Gloves are recommended as the press gets very hot.
3. Grasp the handle firmly with one hand when opening.
4. Keep children away from the machine when hot.
5. Do not touch the heating platen and platen cover (unless wearing protective gloves) while in operation.
6. Do not attempt to press products that are not intended for normal heat transfer.
7. Do not set the temperature any higher than 480°F as it may cause overheating and stop working. Nothing we provide or recommend requires more than 400° F.

Control Panel Operation

P-1: Temp. Setting Mode. Touch Set &   key to set desired temp.

2. Control Panel Setting



Control Panel Window



P-1: Temp. Setting Mode.

Touch Set &   key to set desire a temp.



P-2: Time Setting Mode.

Touch Set &   key to set desire a time.

V



Touch Set &   Choose °C or °F



P-4: Temp. collation mode
Touch Set &   key to set read-out temp. with any number plus or deduced.

VI



P-5: Pre-alarm setting
Touch Set &   to set seconds in advance, you could decide few sec. alarm in advance

VII



Touch Set to finish all settings

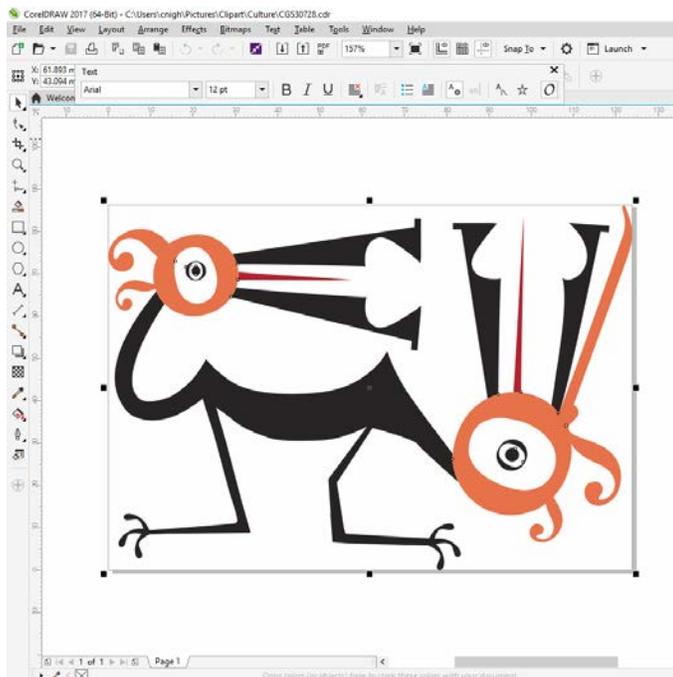
P-2 Time Setting Mode. Touch Set &   Key to set desired time.

Touch "Set" to finish all settings
General guidelines

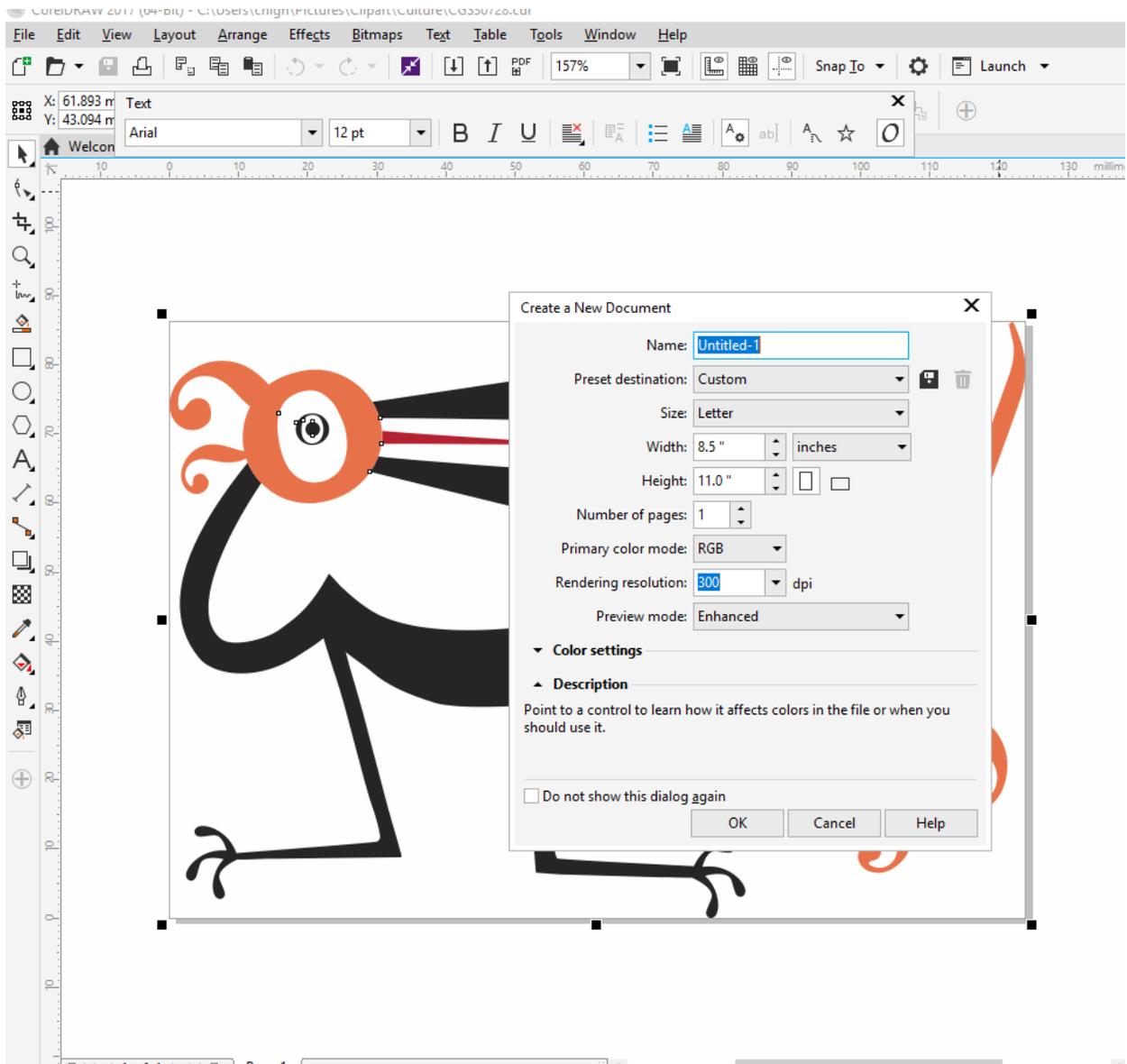
Transfer Medium	Fabric/Medium	Printer	Temp	Time	Pressure	Notes
Sublimation	Light colored T-shirts - Polyester only	Sublimation	380° –400°	20-35 seconds	Light to medium	Higher heat will permanently mark fabric
Sublimation	Mousepad	Sublimation	380° –400°	60 seconds	Medium	Need to loosen pressure handle due to height of mousepad
	Aprons (100% polyester)		380° –400°	20-35 seconds		
Pigment	Light Colored Cotton and most other fabrics	Pigment	380°	25 seconds	Medium pressure	

Preparing the Artwork

- Open/import the image with CorelDraw.
- This artwork may not be the correct size to print on an 8 ½” x 11” sheet and/or it may not be displayed in inches. To correct this, after the artwork opens in CorelDraw, select it and copy it.

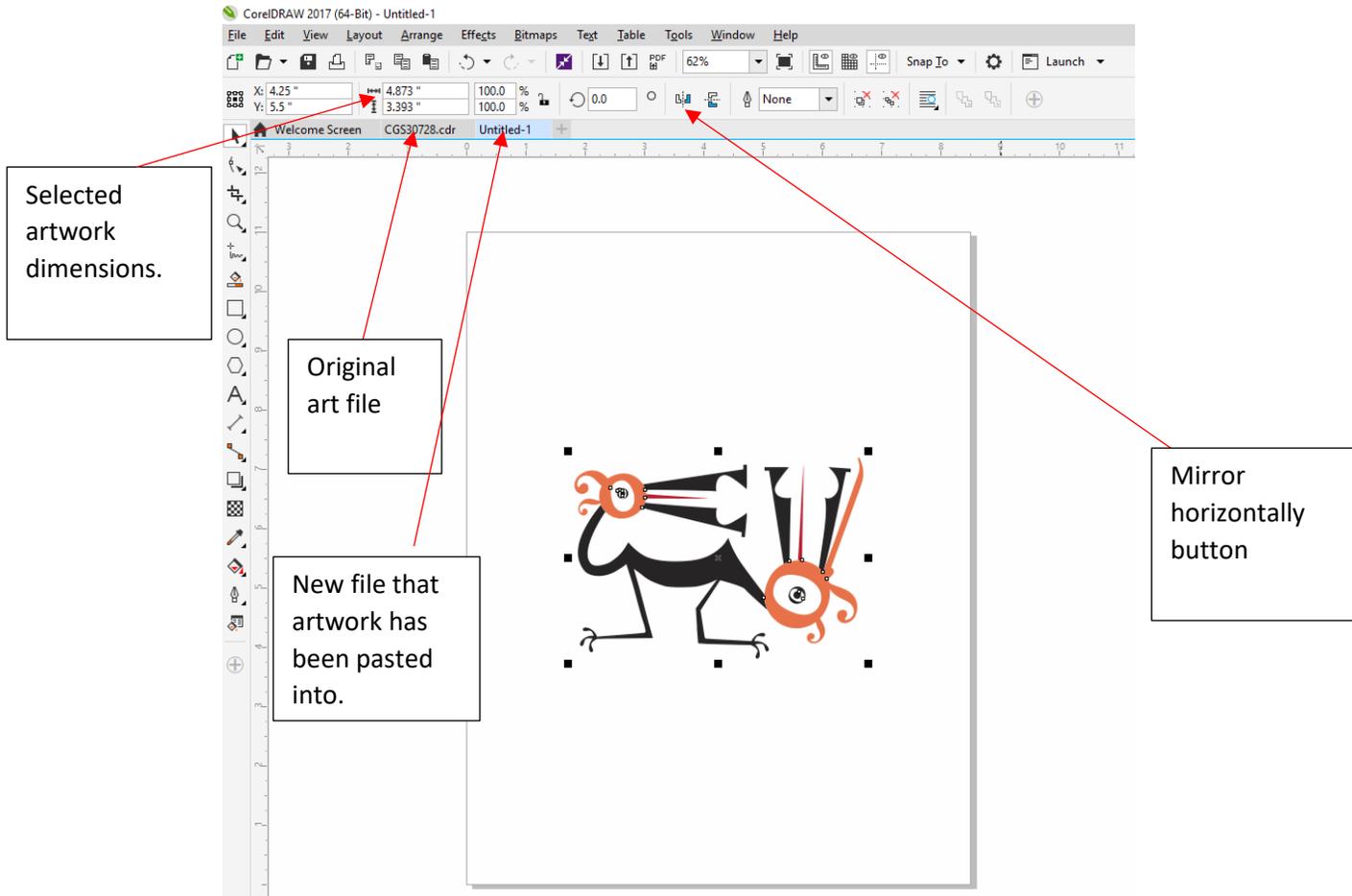


- Create a new file to paste the artwork into. The new file is set to 8.5” x 11”, Primary color mode is set to RGB and the resolution is 300 dpi.



- Click on “OK”

- Paste into the new document



- Adjust size by grabbing a corner handle and pulling towards the center to reduce size or pulling outward to increase the size.
- Reverse the image by selecting the artwork and clicking on the Mirror horizontally button shown above.
- Remember that you would only increase the size of the artwork if it is vector art. If it is a photo you can make it smaller but not bigger without it pixelating.

- Determine the type of fabric you want to print on, i.e. polyester or cotton and select the corresponding printer, ensuring the correct transfer paper is loaded in the paper drawer, right side down.
100% polyester or a high % of polyester = Sublimation
Cotton, polyester or blends = Pigment
- If the graphic is small, place several graphics on the sheet at one time that can be cut out and heat pressed later so as not to waste the expensive transfer paper.
- Print to either the pigment ink or sublimation ink printer which are both labeled Epson 3620 but one should be distinguished from the other i.e. Epson 3620 (copy). Each printer is labeled either Pigment or Sublimation. **Need to check on which is which.**

Preparing to Press

- Cut out the images being used. Trimming as close to the edges of the image as possible. If possible use a cutting machine or x-acto knife with a straight edge on a cutting matt to make the edges as straight and uniform as possible if the image is type or has straight edges.
- Set the press according to the instructions for the type of material and transfer paper being used. This will require three settings: temperature, pressure and time for each T-shirt or other item you are pressing on.
- It's a good idea to clean the item with a lint roller to ensure a perfectly clean surface prior to pressing.

- Pre-press the material first before placing the transfer. This gets rid of moisture that could prevent a good transfer of ink and gets rid of any wrinkles. Timing for this process is just a few seconds.
- Place the T-shirt or other material on the bottom plate, making sure the collar is off the edge of the plate which would reduce the pressure on the rest of the shirt.
- Lay transfer onto the spot you want the design to appear on the T-shirt or other material ink-side down. Place a Teflon sheet on top of the T-shirt to keep the top platen free of ink that could spoil subsequent pressings. The Teflon will also keep the machine from accumulating ink and dust, and Teflon is easy to wipe clean. Lock the press and follow the manufacturer timing instructions for each type of material being used.

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Tips

- Use a potholder or gloves to hold down the hot T-shirt material while lifting off the transfer paper
- **Warning:**
Never leave a heat press on and unattended.
- The printer that corresponds to the material you will be pressing the design onto, i.e. pigment ink printer to cotton, polyester or blends and sublimation ink printer to polyester only (can be a blend but a blend that has a high percentage of polyester will be most successful and long lasting)

Guidelines For Pigment Inkjet Process

- Cut out the design as close as possible since a plastic film will surround the design/artwork.
- After pressing remove transfer paper while hot, then stretch the fabric for best results.
- Wash in cool water with T-shirt turned inside out. Hang to dry.

Guidelines For Sublimation Inkjet Process

- Use heat resistant tape to hold down transfer paper as it doesn't stick and could move when lifting the press after the heating process. This could result in ink dropping on areas where you don't want it.

Refilling Ink Cartridges.

Cobra Ink System
www.cobraink.com
For Pre-filled

You must remove the yellow tab or clear vent plug completely leaving the vent hole totally exposed before installing cartridges. Remove your empty cartridge, leave the printer to sit powered on without a cartridge for 5 minutes before installing new cartridge, this allows the printers memory time to clear.

For Re-Filling

When the ink monitor senses it is out of ink “cannot recognize cartridges”, remove that cartridge, fill to the top with ink and reinsert the cartridge: do this each time the ink light comes on for each color. Note: Please make sure that you allow at least 2 minutes or more (it may need to be left to sit without a cartridge for at least 5 minutes before installing new one.) this allows the memory of the printer to clear. Also always make sure that you wipe the electronic chip on the side of the cartridge with a soft cloth to remove any residue.

Note on the Code 252XL cartridges, you will need to reset these cartridges 2 to 3 times before you need to refill them with ink. When you receive the empty warning that the color is empty, remove that color only and then snap it back into place. These are standard cartridges and will need to do this on all colors.

Refill with Cobra ink only.



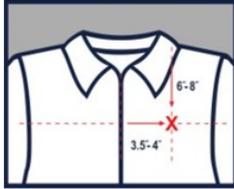
Design Placement Tips

Professional results every time.

Though heat printing is ideal for customizing garments quickly and easily, finding the perfect placement and lining up graphics can be a challenge. Follow these guidelines for logos and graphics placement to get professional results every time you heat press.

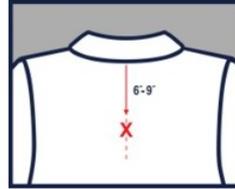
These design placement tips are intended as guidelines. Adjustments may be necessary based on the type and size of the garment.

[Download and print this handy chart.](#)



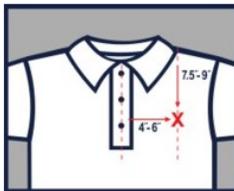
Jackets - Left Chest

3.5" to 4" from center's edge and 6" to 8" from the seam of the left shoulder.



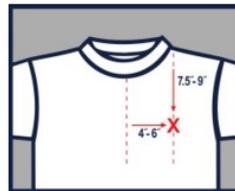
Jackets - Back

6" to 9" from the seam of the collar to the design's center.



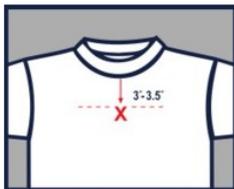
Polo Shirts

7.5" to 9" from the shoulder's left seam and 4" to 6" from the center, in line with the collar meeting the shoulder seam.



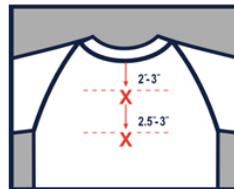
T-Shirts

7.5" to 9" from the shoulder's left seam and 4" to 6" from the center.



Sweatshirts

Top of the design 3" to 3.5" from the bottom of neck's edging.



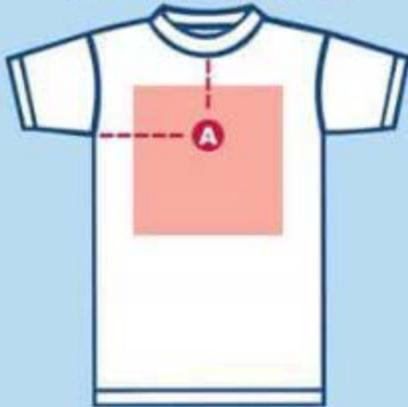
Athletic Jersey

Top of the design 2" to 3" or 2.5" to 3" from the bottom of neck's edging.

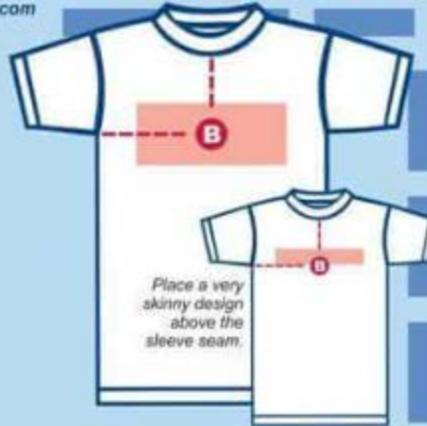
CUSTOM TRANSFER PLACEMENT TIPS

Tip: These are guideline placements. All placements depend on the size of each design. Adjust as needed. To watch application videos, visit www.TransferExpress.com

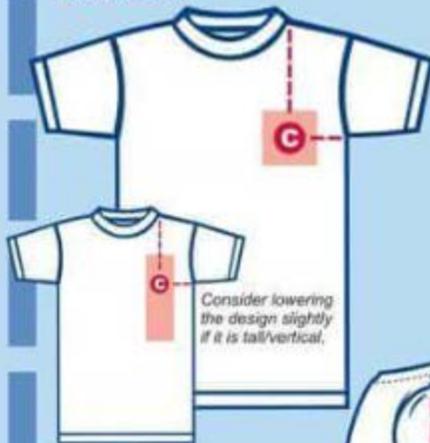
A. Full Front: Square Design



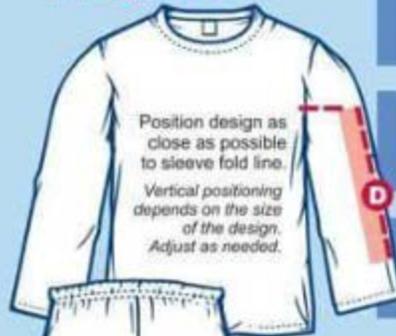
B. Full Front: Horizontal Design



C. Left Chest



D. Long-Sleeve Shirt



E. Short-Sleeve Shirt

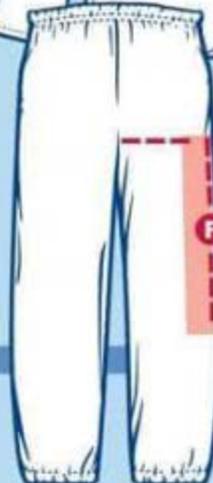
To avoid seams, use a Print Perfect Pad when pressing.



F. Pant Leg

Position design as close as possible to pant leg fold line.

Although not perfectly centered, design will look properly positioned when pants are worn.



www.TransferExpress.com



FAQs

Q: How often should I use my printer?

A: These printers use water based inks which as you know, water evaporates. If you don't use it, the print head will dry up and potentially clog and damage the head. We recommend doing a head cleaning a week and ensuring you have a perfect nozzle check to make sure your printer stays healthy and in perfect working condition.

Q: I didn't use my printer for a certain amount of time, what should I do to get it going again?

A: The very first thing you need to do is reprime the cartridges. Ensure you can pull the ink into the syringe and all the inks are flowing as they should. Once reprimed, run up to 5 head cleanings with a nozzle check after each cleanings and see if you can get a perfect nozzle check or if it's even improving. If it stays the same all 5 cleanings, there's a good chance you've got a clog and in that case you need to call one of our technicians for further instructions.

Q: What is the difference between your three types of ink?

A: Dye is for general office printing, photographs, and screen printing. **Pigment** is for general office printing, photographs, and doing cotton blended shirt transfers. (50% and higher) **Sublimation** ink is for doing poly coated substrates, license plates, phone cases, mouse pads, coffee cups, and poly clothing. (65% and higher)

Troubleshooting: