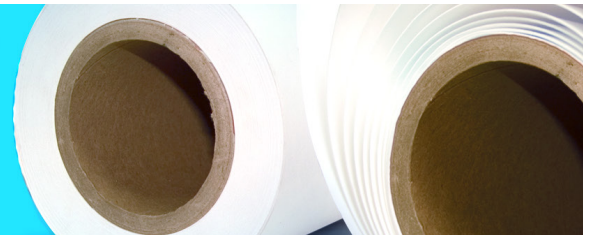


HTM3 & PTM2 Application Instructions



- 1 Use a flatbed heat press (clamshell or swing-away). Preheat the heat press to 295°F (146° C) for:
 - 100% Cotton
 - Poly/Cotton blends
 - 100% Polyester
 - Spandex / Lycra®
 - LeatherUse medium pressure setting.
Set application time to 15-20 seconds.
NOTE: Always test fabric and transfer for compatibility. Adjust temperature and pressure as needed.
- 2 Perform Cut Test from the Cut Config menu on your printer/cutter. Set Cut Pressure* according to conditions of cutting blade and results. Due to the product's thin caliper, using a newer blade will produce the best quality results.
* Approximately 50 - 70 grams of force.
- 3 Set Heat Settings on your printer to 113° - 122° F (45° - 50° C). For VersaWorks®, select the ESM-HTM3 media profile from the Roland Profile Center.
- 4 Print and cut your graphic. *There is no need to wait for ink to dry before weeding. You can also cut at full bleed.*
NOTE: For very small objects, use the "Dry Time" feature in VersaWorks. Set the dry time between printing and cutting to 5 minutes for best results.
- 5 Remove all excess material from the graphic by weeding.
- 6 Remove the paper liner from PGM-PTM2 Polyester Transfer Mask. Lay the clear PTM2 with adhesive side up on a smooth, flat surface. Make sure that the piece of PTM2 is larger than your transfer. Apply printed/weeded HTM3 face side down onto PTM2 starting from the center and rolling the graphic outwards. Once applied, squeegee from the center out with firm pressure to ensure the transfer adheres properly to the mask.
- 7 **Immediately after masking, lift the graphic off** of the backing liner with a quick fluid motion at a sharp angle to ensure the heat transfer material does not stretch.
*** To store graphics, place graphic back on the glossy side of the PTM2 paper liner.**

- 8 Position the graphic in the desired location of the garment and press for 15-20 seconds.
NOTE: Pre-press the garment for 3-5 seconds to remove any moisture from the garment as well as wrinkles. Removing the moisture from the textile is crucial as moisture can have an adverse effect on the transfer bonding with the textile.
- 9 Perform a hot peel (peeling immediately after transfer, while graphic is still hot). Remove the PGM-PTM2 Polyester Transfer Mask at a sharp angle to ensure that the graphic is not distorted or stretched in the process. For additional durability, **cover the graphic and press for another 2 - 3 seconds.**
- 10 The graphic is ready to wear.*
* Wait 24 hours before first wash. Do not dry clean. Follow garment manufacturer's care instructions regarding washing and drying. The garment can be machine washed warm with mild detergent and dried on normal dryer settings. Garment does not need to be washed inside out, However, it is recommended in order to extend the longevity of the graphic. Do not use chlorine bleach. If necessary, you can iron the entire garment and over the transfer.



This information is intended as a guide; testing for compatibility with the application garment and durability is strongly recommended.