

# Application Instructions

## HTGLM & PTM2



1 Use a flatbed heat press (clamshell or swing-away). Preheat the heat press to 311° Fahrenheit (155° Celsius) for:

- 100% Cotton
- 100% Polyester
- Poly/Cotton blends

Use medium pressure setting. Set application time to 15 seconds.

*Note: Always test fabric and transfer for compatibility. Adjust time, temperature and pressure as needed.*

2 Perform Cut Test from Cut Config menu on your printer/cutter. Set Cut Pressure (approximately 100–300 grams of force) according to conditions of cutting blade and results. Due to the product's thick caliper, using a newer 60° blade will produce the best quality results.

3 Set Heat Settings on your printer to 113°–122° Fahrenheit (45°–50° Celsius). For VersaWorks®, select the Roland DGA HTGLM: HeatSoft™ GLAM media profile from the Roland Profile Center. If a profile is not available, please use one of the following profiles:

- Generic Vinyl – already in VersaWorks
- Roland DGA HTMS: HeatSoft SATIN

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 and VersaWorks Dual. Set the dry time between printing and cutting to 5 minutes for best results*

5 Remove all excess material from the graphic by weeding.

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

6 Lay the printed/weeded ESM-HTGLM on a smooth, flat surface. Make sure that the piece of PGM-PTM2 is larger than your transfer. Remove the paper liner from polyester transfer mask and hold the mask with adhesive side down with both hands to make a "U" shape. Apply the mask onto the graphics (starting from the center) and roll the mask outwards. Once applied, either manually swipe or squeegee from the center out with firm even 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.

8 Position the graphic in the desired location of the garment and press for 15 seconds. **If you are not applying the graphics immediately to the fabric, store the masked graphics by placing it back on the glossy (coated) side of the PTM2 paper liner.**

*Note: Pre-press the garment for 2–3 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 Do a hot peel. 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.

*Note: 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 or cold with mild detergent and dried on normal dryer settings. While the garment does not need to be washed inside out, this is recommended in order to extend the longevity of the graphic. Do not use chlorine bleach. If necessary, you can iron the entire garment, including the transfer.*