

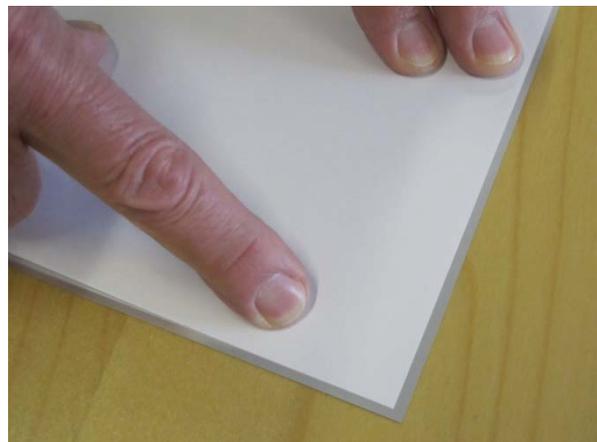
## TRANSFERFILM 4<sup>th</sup> GENERATION PRODUCT INFORMATION 15 - 01

The latest ORIS Media Transfer Film (4<sup>th</sup> generation) combines the advantages of previous media in just one product, which is a thermal-transfer mono-layer film with a thickness of approx. 30 microns. It is almost invisible, with no color-cast and can be hot-laminated to any substrate, to form a receptive layer for eco solvent inks, enabling customer's own stock to be printed on printers, such as the Roland VersaCAMM VS(i) series. The media can be transferred with any laminator with heated pressure rollers, capable of a temperature range of 80° - min. 150° C (180-300° F). It can alternatively be printed first and then transferred. Make sure that the print is thoroughly dry before the transfer process.



For sensitive media like PE film, set the temperature to approx. 90° C (195° F) and a slow speed (1-2 on the DH-650 model). For thicker media with rough surfaces like cardboard or heat-resisting materials like sheet-metal, a higher temperature of up to 170° C (340° F) is recommended. In general, always use the highest temperature, depending on the substrate. Make sure that the pressure rollers are in the 'close' position.

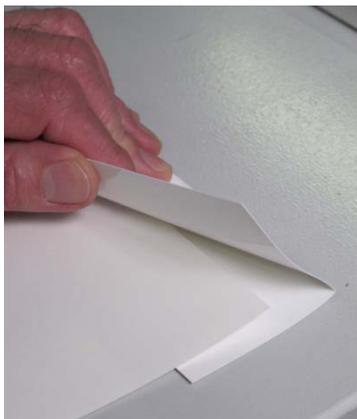
Cut the media to size and make sure that it is slightly smaller than the substrate to be laminated; otherwise residue might collect on the rollers.





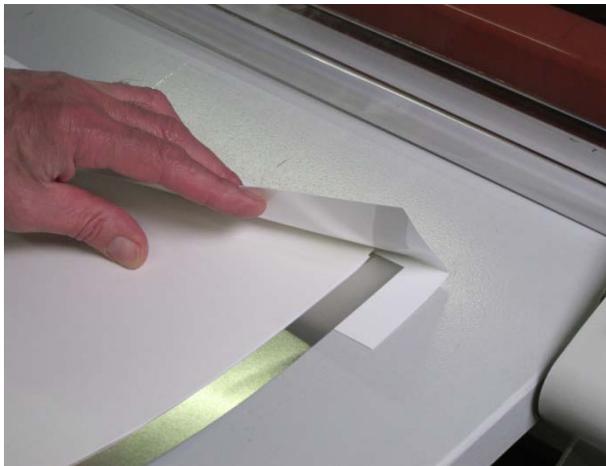
Hold the transfer film and the substrate together and push them onto the pressure rollers until the roller have caught and transport the material. Do not use the full width of the laminator; otherwise the material gets damaged if not fed in straight.

Hold the material on the corners and keep it under tension to avoid wrinkles. The use of an extension table makes it easier to align the substrates and is highly recommended. (Available from CGS for the DH-650 model)



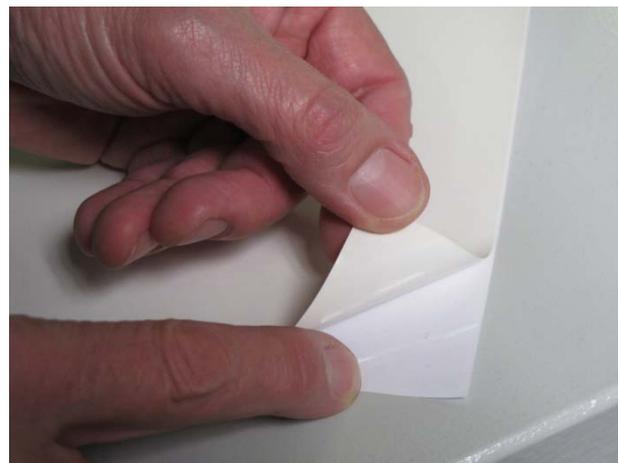
To laminate thin media like tin foil or thin paper or any film, make a pouch by folding cardboard or stiff paper in half.

Insert a few centimeters of the transfer media and the substrate into the pouch and feed the pouch into the machine. Make sure that the media is firmly gripped. Pay attention that the media does not stick to the rollers to avoid damage.

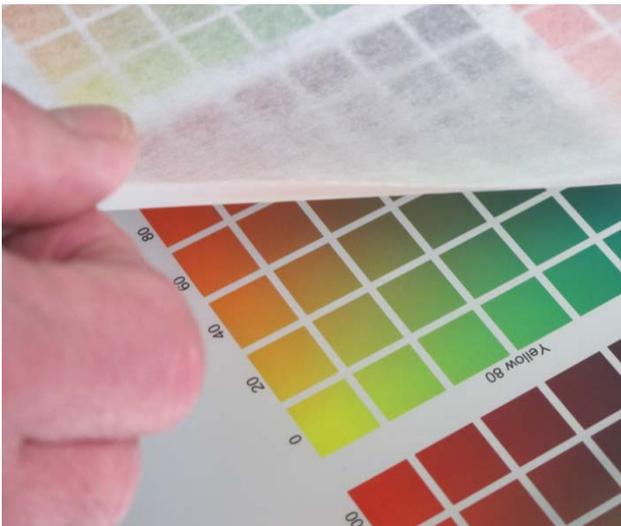


When using thin materials like PE, PET or OPP films, place the film and transfer media on a piece of thin sheet metal (e.g. an offset plate etc.) and then let it pass through the laminator. The metal should be as thin as possible, to avoid damage of the rollers. If the transfer film does not properly bond with the stock, increase the temperature slightly.

Let the material cool off for 2 - 3 min. and then peel off the backing layer. When using substrates like carton with a rough surface, pass the laminated piece through the machine a second time with the laminated side face up, *after* the protective layer has been peeled off. Note that this will also create a slightly matte finish (see also the next page).



## Creating different surface structures:



To create different surface structures (e.g. semi-matte, matte, textile- or linen-structured), use a sheet of siliconized paper (parchment paper) or the ORIS Media Embossing Film, which has been specially developed for a uniform semi-matte appearance, been. Place it over the already transferred transfer media and let it pass through the laminator again. This requires a higher temperature (up to 150<sup>o</sup> C - 300<sup>o</sup> F) depending on the pressure setting of the laminator. Depending on the desired effect, the transfer film can be embossed before or after printing. The film can be cut in the Roland printer and can therefore be used to achieve spot-varnish effects.