Welcome to DecalPRO®!

These instructions are 'short 'n sweet' to get you up and running as quickly as possible right out of the box with just enough information so you don't go into information overload. There are many more techniques on the website for doing more complicated techniques. Our site is maintained for you to be able to stay abreast of the latest and greatest tips, tricks and techniques as they are discovered both by us and our user-base. Please visit us at "www.decalprofx.com"

Before you can start to use this kit you must have a GBC® brand "pouch laminator" and a conventional "hot air" gun. No other laminator manufacturers will work with DecalPRO®. In addition to these two items you will also need:

- Paper Cutter (optional)
- X-Acto® Knife
- Straight Edge Ruler (no raised edge)
- Paper Towel
- Water Container - 4" deep or greater
- Rubbing Alcohol - 91% (drug store)

You should do each step as they are read. If you get confused please review the video clips online and if that doesn't clear up any confusion, drop us an email at mail@pulsarprofx.com or call us at (850) 926-2009.

We are open from 9-5pm EST. Because this is a radically new way to make dry transfers it is normal for everyone to experience a "learning curve" that could take an hour or two to master the technique. To assist you in getting a fast jump-start we have included pre-printed sample images.

PREPARATION

• PRE-HEAT THE LAMINATOR:

Turn on your GBC® laminator now to allow it enough time to get up to temperature and be ready when you start. If you have the GBC "Personal" or "H-200" model, set the heat range to the "5mil" setting. The "H-210" model is set to '10'. Note: Allow a full 30 minutes for all laminators to fully "heat soak" before being used. Disregard any indicator saying it's "READY".

• CUT UP ONE CARRIER BOARD:

Follow the cutting template in the Carrier Board package to yield 3 boards. We'll be using the smallest 3"x4" board only. Take the second board in the pack and wrap with paper towel. This will be an ideal "heating" location when you are using the heat gun.

• CUT UP PRE-PRINTED SAMPLES:

Carefully cut up the preprinted sample "test" images so that each graphic has its own black border. Practice with these images before doing your own graphics.

The black toner samples are used with any of the foils in the "TRF Sampler Pack" to colorize the black toner image. Regarding the foils, keep in mind that it is the "dull" side (inside) that always gets laid over the toner image. The shiny side is just thin Mylar® that is holding the color. It will be peeled back and discarded after it has been fused to the printed toner image.

STARTUP POINTS TO REMEMBER

1) *The paper is coated on just one side. Always print on the lighter blue shade.*

2) *Keep fingerprints off the paper!*

3) *Only use B&W or color laser printers or photostatic copiers... no inkjets!*

4) *Keep the paper sealed in the bag.*

5) *Laminator requires 30 minutes to fully "heat-soak" before first use!*

6) *Graphics or text must have about 10pt (1/4") border placed all around the image.*

PROCEDURE

STEP #1 - REMOVE MOISTURE:

Let's start by making a metallic covered graphic using one of the black toner pre-printed images. Select any one of the preprinted B&W images and lay it FACE DOWN over the papertowel wrapped Carrier Board. (You may want to position the tip of the X-Acto® knife on a corner of the print to stop it from being blown away by the heat gun.) With your "hot air" gun set to the higher of its 2 heat settings, position the gun about 6" over the print. (A hair dryer does not get hot enough). Immediately, two sides of the paper will curl towards you as moisture is evaporating from the paper.

Stop for a second, flip the image over and take note of the direction of the curl relative to the printed image. Is it curling from the top down or side to side? The curl indicates which way the paper will be inserted into the "Water Bath" in a later step. The image ALWAYS goes into the water the same way it wants to curl.

This is the paper's "grain". Continue heating the paper until it starts to relax and lays nearly flat again. When the uncurling stops, flip the image over and apply about 5 seconds more heat to the front side of the transfer paper.

STEP #2 - PREPARE TWO FOILS:

Open the large "TRF Sampler Pack" and cut a 3" swath across the bottom of any of the metallic foils. For now, restrict your practice to just the first 12 metallic foils. (There are specific instructions on the website for working with many of the other foils). Cut this 8" x 3" strip at 5" long and discard the remaining 3". Do this again using the separate 6" x 9" CarrierTRF foil pack. Put this one aside for now.

STEP #3 - TRANSFER THE FOIL:

Using the included "Tack Cloth", lightly wipe over the print then lay it over the small 3" x 4" CarrierBoard about 1/4" down from the top edge of the board. Lay the foil over the entire board, covering the graphic and then wrap the 1" of remaining foil around the leading edge of the board that is going to be inserted into the laminator. (From this point on we will refer to the laminator as the TIA for "Toner Image Applicator").

Place the folded over edge on the bottom lip of the laminator and smoothly insert the board into the rollers. Now drop your fingers down on top of the foil and apply dragging resistance over the foil. This drag prevents any wrinkling over the toner image as it goes through the TIA. Keep good drag "resistance" over the foil until the TIA pulls the board out from under your fingers.

When the board exits the TIA, insert it a second time but this time you don't need to touch

the foil. When it has exited the second time, slide the graphic and foil off the board and lay it down over the work place. Place your hand over the print for a few seconds to rapidly cool it down. Peel the foil back slowly, 180º over itself and discard. You may see “excess” foil over the print where none should be. This is due to "surface tension” and the amount of excess left behind varies amongst the different foil types.

It's normal for all foils to leave a bit of extra foil, but it is NOT normal for any black toner to be visible. Black areas or “specs” means the TIA isn’t hot enough or you had dust “debris” over the print that didn’t get properly cleaned with the “tack cloth”. If you have wrinkles over the toner image, it means there was not enough drag placed over the foil as it ran through the TIA.

STEP #4 - REMOVE EXCESS FOIL:

Lay the image face-up on your table top. Take the blue 3M® "2080" tape and apply strips of tape slightly overlapping each other all the way down the graphic.

Rub well over all strips to get good adhesion. Carefully peel back the top-most strip on a bit of an angle so as not to catch the corner of the paper which might separate the paper layers. Remove all strips by peeling back 180º back over themselves and discard. Notice that each removed strip raises the edge of the one below it.

Run your finger over the raised edge to lay it back down then remove that strip. Inspect the graphic and surrounding blue paper areas for any evidence of foil where it shouldn’t be. Some foils, most notably WhiteTRF may require that this step be performed twice, 90º in the opposite direction.

STEP #5 - CLEAN THE CARRIER:

Lay the metallic covered print and the previously cut 3” x 5” piece of CarrierTRF film side-by-side. Wet a paper towel with 91% Isopropyl “Rubbing Alcohol” and quickly wipe down both. Take a dry paper towel and lightly “buff-up” the metallic print but forcibly wipe down the Carrier Mylar® even though both might have already dried. You are setting a “pre-charge” for the next step.

STEP #6 - BONDING THE CARRIER:

Position the graphic over the CarrierBoard 1/4” to 1/2” down from the top. Make certain that the direction of the graphic’s “curl” is at the top of the board. (The paper’s curl or “grain” was addressed in the second paragraph of Step #1). Now lay the cleaned side of the Carrier Mylar® over the board, wrapping the remaining 1” around the leading edge of the board. Insert the board into the TIA. When it exits, insert a second time. Carefully peel the Mylar® from under the CarrierBoard being careful not to “lift” the Mylar® ‘up’ which would tend to break the delicate bond between the Carrier Mylar® and the graphic. We just want to peel the Mylar® free from under the fiberglass so you can carefully SLIDE the print off the board.

Lay the image on your work surface and trim off all Mylar® extending off the print. Lay your straight-edge over the image to hold the print flat as you trim off the outside edge. Doing it this way prevents any shock to the Carrier Mylar® preventing separation. When done, you should not see any Mylar® visibly “lifted” from the transfer paper. If separation occurs you can lay a 3” x 5” piece of paper towel over the board, wrapping it around the leading edge like before and running it twice through the TIA.

STEP #7 - WATER BATH:

This step releases the graphic from the transfer paper. Position the graphic so that the “curling” side will be entering the water first. Slowly feed the graphic vertically into the water tray. As soon as the paper gets wet it should immediately start to curl into a scroll, much more than when you were removing moisture from Step #1. Keep feeding the paper into the water bath until it is completely submerged. The paper will start to un-scroll as the water soaks into the paper fibers. While you are waiting for the release to happen (about 1~2 minutes) lay a dry paper towel flat on your work area.

When you see that the Carrier is starting to separate from the paper, you can lift the Carrier film out of the water. The dissolved coating from the paper tends to cling a little bit to the Carrier during this release stage. Carefully drag the film through the water to ensure there is no residue remaining on the film.

Be very careful that you don't cause a wrinkle in the film since this could cause the image to break away! You might see some of the border around the graphic break away and that's OK because that is exactly what the border is there for - to protect the Carrier from prematurely separating from the graphic during this stressful release step when it first gets wet. The Carrier-TRF should be removed within a minute after separation. Lift the image out of the water and lay it on the paper towel. Fold the towel over or use another towel to blot-dry both sides.

STEP #8 - REMOVE THE BORDERS:

Trim off the four borders going around the print with an X-Acto® knife and a straight edge ruler laid over the print so the “cutting” edge is on the outside. NOTE: Do not use a paper cutter unless you are VERY careful not to "stress" the Carrier. The "shock" from the blade can cause the image to be easily damaged, ruining the graphic.

STEP #9 - APPLY SPRAY ADHESIVE:

Take a new paper towel and apply a quick “burst” of adhesive in the middle of the towel square. Lay the graphic face-down (metallic-side down) over the spot of adhesive on the new paper towel. The towel was sprayed to hold the thin Carrier from blowing away when the adhesive is applied next.

Apply two light coats of adhesive over the entire Carrier in opposite directions. It doesn't take much of this adhesive to do its job. You will want to make these passes quick and even at a distance of about 12" above the Carrier film. It is very easy to apply too much adhesive because the spray is very concentrated. Too much or too little normally results in a poor or damaged transfer. This will take a bit of practice to know how to apply. We have a short "flash" video clip on the website to demonstrate how this is best done. After applying the adhesive, allow it to setup for about 30 seconds (or blow on it for about 10~15 seconds) before you are ready to make the transfer. You don't have to use it right away - it can stay in this state for days. To protect the adhesive from settling dust, lay a small piece of Reynolds® brand” Parchment” Cooking Paper (available from any good grocery market) lightly over the adhesive and store flat in a folder.

STEP #10 - MAKE THE TRANSFER!

The “target” location must be as clean as possible using the rubbing alcohol. <u>You are now ready to make the transfer!</u> This is a critical step because there is no "undo" button!

Wherever the image first touches - that's where the image is going. When the graphic has been applied and rubbed down well (with mere finger pressure), put a small piece of the blue tape over a corner of the Carrier and peel the film back 180º over itself. If when peeling it back you notice a small piece of the image lifting with the film, stop lifting, lay it back down and apply more rubbing pressure, then continue the peel back again. All done!

CONTINUING ON...

GHOSTING:

Ghosting is when the adhesive spray around the graphic image also transferred to the "target" location. Normally this is in the form of a very light haze. To remove it, all you need to do is first let the adhesive UNDER the graphic setup for about 1 hour, then merely wet a paper towel with rubbing alcohol and wipe lightly right over the graphic. Any exposed adhesive will quickly dissolve and wipe away.

METALLIC FOIL "HALO" EFFECT:

Sometimes when the laminator has been on for a considerable amount of time, you can have a bit too much heat built up inside which can cause strange looking "halos" over the metallic surface. If this starts happening, simply cut a piece of paper towel 3"x5" and wrap it on top of the metallic foil. This will buffer excessive heat from causing this problem. Pass the image through the TIA twice.

CLEAR COAT:

You can always apply a "clearcoat" spray over the graphic and/or the entire project but in many cases you will find that if the image is not in a "hostile" location, a clear coat may not be necessary. Images that have been left to cure for a few days get extremely tough and can withstand a lot of abuse before they start to show signs of deterioration.

REMOVING A MISTAKE:

Within the first few hours you can easily remove an image from the target location by breaking it up with regular 3M Scotch tape! Simply lay it down over the image and lift UP not back. The tape won't lift off all of the image but it will break it up considerably. Now wet a paper towel with alcohol and soak/wipe over the image. The alcohol will "wick" under the remaining pieces to soften the adhesive. This breaks up the remaining graphic image, allowing all evidence of the graphic to be successfully removed. Now just reprint the graphic, prepare and make the transfer again.

OTHER FOILS:

Even though we have only discussed working with the metallic foils, all foils behave basically the same way. Please refer to the website for a lot more information on how other tricks are performed.

We sincerely hope you have a lot of fun with your new found capability giving you the power to do for yourself what has never existed before. Call us if you have any difficulty using our DecalPRO® system. Tech support is only a phone call away at (850) 926-2009. We're open 9-5 EST.

This page intentionally left black for your personal “notes”