

## MDF Wood Products

**JOHNSON**PLASTICS  
PLUS

### MDF WOOD PRODUCTS - Heat Transfer (Hard Surfaces)

HD105FW | HD104FW | HD103FW | HD101FW | HD106FW | HD107FW | HD109FW | HD110FW |  
HD112FW | HD113FW | HD114W | HD115FW | HD116FW | HD125FW | HD126FW | HD127W |  
HD129I | HD130FW | HD131FW | HD132FW | HD133FW | HD150W | HD151FW | HD154FW |  
HD156FW | HD157FW | HD158FW | HD159FW | HD160FW | HD161FW | HD162FW | HD163FW



## GENERAL TONER HEAT TRANSFER PROCESS

### Recommended Equipment & Accessories

- Heat Transfer Printer
- Heat Transfer Paper for Hard Surfaces with paper instructions
- Standard Flat Heat Press- Swing-away style press recommended
- Heat Tape
- Teflon sheet or Blowout paper
- Heat gloves
- Optional: Orange Silicone heat pad

Recommended Settings	
<i>Refer to the Heat Transfer Paper Instructions for best results.</i>	
Time	60 seconds
Temperature	300°F
Pressure	Medium-heavy

### General Heat Transfer Instructions

- **Follow the Heat Transfer Paper Instructions for best results.**
- Adjust press pressure to medium-heavy.
- Preheat the heat press to 300°F or temperature specified per paper instructions.
  - If using an orange silicone heat pad, adjust temperature to 330°F.
- Print and place transfer sheet face down onto the surface of the product blank. Secure transfer with heat tape.
- Place the product blank with attached transfer sheet onto the heat press platen with the transfer paper on top.
- Place a piece of Teflon or blowout paper on top of the transfer paper.
  - Optional: Place an orange silicone heat pad on top of the transfer paper to help with the downward pressure on the product.
- Close and press for the recommended time.
- When finished, open the press and remove the Teflon or blowout paper.
- Using heat gloves, remove the product from the press.
- Peel the transfer paper off of the surface of the product while the product surface is still hot/warm.
  - The product should still be warm, but able to be handled without heat gloves.

### **Tips and Tricks**

- For best image placement, utilize the product template found on the product page on JPPlus.com.
  - If using an orange silicone heat pad, adjust temperature to 330°F.
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### **Troubleshooting**

- The image did not completely transfer to the product.
    - Slightly increase the press pressure.
    - The product may still be too warm when peeled. Wait a little more time before peeling the transfer paper.
  - Ensure that the Hard Surface paper used is compatible with the product material, as there are several types of Hard Surface papers available for different types of hard surface goods.
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### **Templates and Images**

- Visit [jpplus.com](http://jpplus.com) to find the product page for this item. The product template may be found under the Tech Docs and Downloads area of the page.
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**To order more of this product, see similar products and much more, please visit [jpplus.com](http://jpplus.com).**

For additional product support and troubleshooting, please contact JPPlus Advanced Support Team:

- Phone: 419-500-4877
- Email: [ast@jpplus.com](mailto:ast@jpplus.com)
- Schedule an appointment: <https://jpplusadvancedsupport.setmore.com/>