

# HARD SURFACE PAPERS INSTRUCTION GUIDE

• CL Metal Plus | CL Leather/Wood | CL Ceramic Plus •

<b>Contents</b>	<b>Page</b>
Paropy CL Metal Plus .....	2
Paropy CL Leather/Wood .....	3
Paropy CL Ceramic Plus.....	4
Acrylic .....	5
Cardboard Puzzles .....	6
Ceramic Mugs.....	7
Ceramic Tiles .....	9
Crystal.....	10
Glass.....	10
Leather .....	11
Magnets.....	11
Metal .....	12
Wood .....	13
Aluminum Bottle .....	14
Stainless Steel Bottle.....	15

## CL METAL PLUS

# APPLICATION INSTRUCTIONS

### STEP BY STEP

#### Step 1

Feed paper into laser printer so that the printer is printing on the printable side (white gloss coated side).

#### Step 2

Design your image and and resize if necessary

#### Step 3

Set Heat Press temperature and time and let press reach set temperature

#### Step 4

Tape transfer onto metal with heat tape. Image facing the mug

#### Step 5

Place metal with printable side face up in heat press and close. Use medium to light pressure.

#### Step 6

Once Heat press beeps, remove metal from press. Peel the transfer warm.

#### Step 7 (optional)

Place mug in glazing unit or oven for 1-2 mins or 5 mins respectively. This will make image more scratch resistant.

### APPLICATION

Substrate	Metal
Paper Mode	Heavy to Label*
Image	Mirror
Press Time:	90-180 sec.
Temperature:	330F (180-190C)
Pressure:	Medium to Heavy
Peel:	Cold

\*These settings are recommended, you may need to conduct your own tests  
All technical information and recommendations are based on tests we have conducted.  
Users should conduct their own tests before proceeding

### NOTES

#### Recommended Substrates

Metals  
Plastics\*  
Cardboard\*

\*please refer to the hard surface booklet for instructions

To print onto colored substrates, a white toner printer is required.  
Recommended white toner printers are OKI 711, OKI 920

#### Accessories Required

Computer, Color Laser Printer, Heat Press.

#### Printable side

The printable side (white gloss coated side) without the red lettering.

#### Pressure Settings

We recommend to use high pressure. If this paper is applied with inadequate pressure, the transfer will not stick to the mug.

#### Peeling

This paper is to be peeled completely cold.

#### Care Instructions

If step 7 is performed, the mug is dishwasher safe.

#### Storage

CL Metal Plus Transfer Paper has an indefinite shelf life when stored at room temperature. Keep away from direct heat, sunlight and humidity. It is recommended to store in plastic ziplock bag (provided) and the bag sealed while paper is not in use.

## PAROPY CL LEATHER/WOOD

### OVERVIEW

#### DESCRIPTION

Paropy CL Leather/Wood is for imaging to hard substrates with a porous surface in full color using a laser printer or copier and heat press.

Print Mirror imaged and heat apply.

The paper will leave a thin transparent microfilm around all areas of the surface which helps to protect the surface from scratches. The original texture of the surface will be maintained when imaged. Ideal for awards and trophy applications!

Due to the varying instructions for the different substrates that this paper can apply to, please refer to the detailed instructions for the specific substrate you plan to image onto.

#### Recommended Materials

Light Colored  
Wood, Leather  
Glass, Crystal, Acrylic  
Lacquer finished wood is not recommended

#### Accessories Required

Computer, Color Laser Printer, Heat Press. Foam Heat Pad

#### Printable side

The printable side (white glossy coated side) It is also the adhesive side

#### Pressure Settings

Using high pressure will allow the texture of the substrate to show through more. However this is not recommended for Glass, Crystal, or Acrylic.

#### Picking Substrates

When picking substrates, ensure that there is minimal warping when heat is applied. After pressing, we recommend to put a heavy heat resistant paper weight on all areas of the substrate to prevent warping.

#### Image Design

This paper works best with a full bleed image. When designing your image, ensure that you bleed your image at least 0.5 inches more than the substrate.

#### Peeling

It is recommended to peel the back off cold. This will prevent any excess film from sticking onto the surface.

#### Care Instructions

After imaging, do not put in direct sunlight. Store at room temperature.

#### Storage

CL Leather/Wood has an indefinite shelf life when stored at room temperature. Keep away from direct heat, sunlight and humidity.



## CL CERAMIC PLUS

# APPLICATION INSTRUCTIONS

### STEP BY STEP

#### Step 1

Feed paper into laser printer so that the printer is printing on the printable side (white gloss coated side).

#### Step 2

Design your image and and resize if necessary

#### Step 3

Set mug press temperature and time and let mug press reach set temperature

#### Step 4

Tape transfer onto mug with heat tape. Image facing the mug

#### Step 5

Place mug in press and close. Use medium to light pressure.

#### Step 6

Once mug press beeps, remove mug from press. Cool the mug using hot/warm water, then cold water. Once mug is cool. peel the transfer.

#### Step 7 (optional)

Place mug in glazing unit or oven for 1-2 mins or 5 mins respectively. This will make image more scratch resistant.

### APPLICATION

Substrate	Matte Ceramic Mugs
Paper Mode	Heavy to Label*
Image	Mirror
Press Time:	150-180 sec.
Temperature:	300F (180-190C)
Pressure:	Medium to Heavy
Peel:	Cold

\*These settings are recommended, you may need to conduct your own tests  
All technical information and recommendations are based on tests we have conducted.  
Users should conduct their own tests before proceeding

### NOTES

#### Recommended Substrates

White Gloss Ceramic Mug  
White Matte Ceramic Mug  
Colored Gloss Ceramic Mug\*  
Colored Matte Ceramic Mug\*  
Glass Mugs

\*To print onto colored mugs, a white toner printer is required.  
Recommended white toner printers are OKI 711, OKI 920

For gloss mugs, we recommend trimming your image

For glass and other substrates, please refer to hard surface booklet for instructions.

#### Accessories Required

Computer, Color Laser Printer, Mug Press.

#### Printable side

The printable side (white gloss coated side) without the red lettering.

#### Pressure Settings

We recommend to use high pressure. If this paper is applied with inadequate pressure, the transfer will not stick to the mug.

#### Peeling

This paper is to be peeled completely cold.

#### Care Instructions

If step 7 is performed, the mug is dishwasher safe.

#### Storage

CL Ceramic Plus Transfer Paper has an indefinite shelf life when stored at room temperature. Keep away from direct heat, sunlight and humidity. It is recommended to store in plastic ziplock bag (provided) and the bag sealed while paper is not in use.

## ACRYLIC

### INSTRUCTIONS

#### CL Ceramic Plus

Paper Mode: Color to Label 1

Print mode Mirror Image

Temperature: 300F

Time: 60 seconds

Peel: Cool

Pressure: Heavy

#### CL Leather/Wood

Paper Mode: Heavy to Label 1

Print Mode: Mirror Image

Temperature: 300F

Time: 50 seconds

Peel: Cool

Pressure: Heavy

CL Ceramic Plus: For OKI 6100 &  
6150 print in Glossy mode

#### Acrylic

Any white or light colored acrylic

#### Materials Required:

Heat Press, Laser Printer, Felt Heat Pad, Acrylic substrate

#### CL Ceramic Plus

- 1.) Insert into bypass tray and print mirror imaged.
- 2.) Print image in color to label 1 mode, mirror image
- 3.) Place substrate with image side face up
- 4.) Place imaged paper with image face down
- 5.) Place foam pad on top
- 6.) Press at 300F for 60 seconds.
- 7.) Wait for substrate to cool and peel backing off cool.

#### CL Leather/Wood

- 1.) Insert into bypass tray and print mirror imaged.
- 2.) Print image in heavy to label 1 mode, mirror image
- 3.) Place substrate with image side face up
- 4.) Place imaged paper with image face down
- 5.) Place foam pad on top
- 6.) Press at 300F for 60 seconds.
- 7.) Wait for substrate to cool and peel backing off cool.

## CARDBOARD PUZZLES

### INSTRUCTIONS

#### CL Metal Plus

Paper Mode: Heavy to Label 1

Print Mode: Right Reading

Temperature: 300F

Time: 60 sec

Peel: Hot

Pressure: Heavy

CL Metal Plus: For OKI 6100 &  
6150 print in Glossy mode

#### Cardboard Puzzles

Any white or light colored cardboard puzzle.

#### Materials Required:

Heat Press, Laser Printer, Foam Heat Pad, Cardboard Puzzle

#### CL Metal Plus:

- 1.) Insert into bypass tray and print mirror imaged.
- 2.) Print image in Color to Label 1 mode depending on your printer
- 3.) Place substrate with image side face up
- 4.) Place imaged paper with image face down onto substrate
- 5.) Place foam heat pad on top of substrate
- 6.) Press at 300F for 60 seconds. Use Heavy Pressure. Peel hot.

## CERAMIC MUGS

### INSTRUCTIONS

#### CL Ceramic Plus

##### *11oz Mugs*

Paper Mode: Color to Label 1

Print Mode: Mirror Image

Temperature: 300F

Time: 150-180 sec

Peel: Cool

Pressure: Heavy

##### *15oz Mugs*

Paper Mode: Color to Label 1

Print Mode: Mirror Image

Temperature: 300F

Time: 150-180 sec

Peel: Cool

Pressure: Heavy

##### *Curing Step*

##### *Glazing Unit*

Level: 5

Curing Time: 60-85 sec

##### *Oven*

Temperature: 350F

Time: 8-10 mins

CL Ceramic Plus: For OKI 6100 & 6150 print in Glossy mode

#### Coated Ceramic Mugs

##### Mug Press without idle time

Any white or light colored coated ceramic mugs

##### Materials Required:

Mug Press, Laser Printer, Foam Heat Pad, Coated Ceramic Mug, Curing Unit

##### CL Ceramic Plus:

- 1.) Insert into bypass tray and print mirror imaged.
- 2.) Print image in Color to Label 1 mode depending on your printer
- 3.) Wrap imaged paper with image facing the mug
- 4.) Secure the imaged paper onto mug with heat tape
- 5.) Wrap foam pad around mug and place into mug press.
- 6.) Adjust pressure accordingly. Ensure pressure is heavy
- 7a.) For 11oz mugs, close mug press and press at 300F for 150-180 sec
- 7b.) For 15oz mugs, close mug press and press at 300F for 150-180 sec.
- 8.) Let Mug cool and dunk into cold water. Then peel paper off.

Note: Not enough pressure will result in incomplete image transfer

**Curing** - This step is required for the mug to become scratch resistant

##### Option 1: Glazing Unit

- 1.) Ensure the mug is at room temperature
- 2.) Place mug on curing unit.
- 3.) Set curing level to 5
- 4a.) For 11oz mug, cure for 60 seconds
- 4b.) For 15oz mug, cure for 75-85 seconds

##### Option 2: Oven

- 1.) Ensure the mug is at room temperature
- 2.) Place mug on in oven.
- 3.) Set temperature to 350F
- 4a.) For 11oz mug, cure for 8-10 mins
- 4b.) For 15oz mug, cure for 8-10 mins

## CERAMIC MUGS

### INSTRUCTIONS

#### CL Ceramic Plus

##### *11oz Mugs*

Paper Mode: Color to Label 1

Print Mode: Mirror Image

Press Temp:: 300F

Time: 150-180 sec

Peel: Cool

Pressure: Heavy

##### *15oz Mugs*

Paper Mode: Color to Label 1

Print Mode: Mirror Image

Temperature: 300F

Time: 150-180sec

Peel: Cool

Pressure: Heavy

##### *Curing Step*

##### Glazing Unit

Level: 5

Curing Time: 60-85 sec

##### Oven

Temperature: 350F

Time: 8-10 mins

CL Ceramic Plus: For OKI 6100 & 6150 print in Glossy mode

#### Coated Ceramic Mugs

##### Mug Press with idle time

Any white or light colored coated ceramic mugs

##### Materials Required:

Mug Press, Laser Printer, Foam Heat Pad, Coated Ceramic Mug

##### CL Ceramic Plus:

- 1.) Insert into bypass tray and print mirror imaged.
- 2.) Print image in Color to Label 1 mode depending on your printer
- 3.) Wrap imaged paper with image facing the mug
- 4.) Secure the imaged paper onto mug with heat tape
- 5.) Wrap foam pad around mug and place into mug press.
- 6.) Adjust pressure accordingly. Ensure pressure is heavy
- 7.) Ensure that the mug press is at idle temperature 300F
- 8a.) For 11oz mugs, close mug press and press at 300F for 150-180 secs
- 8b.) For 15oz mugs, close mug press and press at 300F for 150-180 secs
- 9.) Let Mug cool and dunk into cold water. Then peel paper off.

Note: Not enough pressure will result in incomplete image transfer

**Curing** - This step is required for the mug to become scratch resistant

##### Option 1: Glazing Unit

- 1.) Ensure the mug is at room temperature
- 2.) Place mug on curing unit.
- 3.) Set curing level to 5
- 4a.) For 11oz mug, cure for 60 seconds
- 4b.) For 15oz mug, cure for 75-85 seconds

##### Option 2: Oven

- 1.) Ensure the mug is at room temperature
- 2.) Place mug on in oven.
- 3.) Set temperature to 350F
- 4a.) For 11oz mug, cure for 8-10 mins
- 4b.) For 15oz mug, cure for 8-10 mins



## CERAMIC TILES

### INSTRUCTIONS

#### CL Ceramic Plus

Paper Mode: Color to Label 1

Print Mode: Mirror Image

Temperature: 330F

Time: 300 sec

Peel: Cool

Pressure: Heavy

#### Ceramic Tiles Full Bleed Image

Any white or light colored uncoated or coated Ceramic Tiles. These instructions are meant for a full bleed image.

##### Materials Required:

Heat Press, Laser Printer, Felt Heat Pad, Foam Heat Pad, Ceramic Tile

##### CL Ceramic Plus:

- 1.) Insert into bypass tray and print mirror imaged.
  - 2.) Print image in Color to Label 1 mode depending on your printer
  - 3.) Place felt pad onto heat press
  - 4.) Place imaged paper with image face up onto felt pad
  - 5.) Place substrate on top of paper with image side face down
- Note: You can secure the paper and substrate with heat tape
- 6.) Place Foam Heat Pad on top of substrate to protect heat press
  - 7.) Press at 330F for 300 seconds. Use heavy pressure and peel cool.

Note: Too much pressure and you will crack the tile, not enough pressure will cause beveled areas not to image completely

#### CL Ceramic Plus

Paper Mode: Color to Label 1

Print Mode: Mirror Image

Temperature: 330F

Time: 180 sec

Peel: Cool

Pressure: Heavy

#### Ceramic Tiles Non Full Bleed Image

Any white or light colored uncoated or coated Ceramic Tiles. These instructions have a shorter press time for non full bleed images only.

##### Materials Required:

Heat Press, Laser Printer, Foam Heat Pad, Ceramic Tile

##### CL Ceramic Plus:

- 1.) Insert into bypass tray and print mirror imaged.
- 2.) Print image in Color to Label 1 mode depending on your printer
- 3.) Place substrate with image side face up
- 4.) Place imaged paper with image face down
- 5.) Place foam pad on top
- 6.) Press at 330F for 180 seconds using heavy pressure
- 7.) Wait for substrate to completely cool before peeling paper off.

Note: This instructions set is for images that do not bleed over to the side. The shorter time will allow for faster production of tiles that do not have full bleed images.

## CRYSTAL/GLASS

### INSTRUCTIONS

#### CL Ceramic Plus

Paper Mode: Color to Label 1

Print Mode: Mirror Image

Temperature: 300F

Time: 60 seconds

Peel: Cool

Pressure: Heavy

#### CL Leather/Wood

Paper Mode: Heavy to Label 1

Print Mode: Mirror Image

Temperature: 300F

Time: 50 seconds

Peel: Cool

Pressure: Heavy

CL Ceramic Plus: For OKI 6100 & 6150 print in Glossy mode

#### Crystal/Glass

Any transparent Crystal or Glass substrate.

#### Materials Required:

Heat Press, Laser Printer, Felt Heat Pad, Acrylic substrate

#### CL Ceramic Plus

- 1.) Insert into bypass tray and print mirror imaged.
- 2.) Print image in color to label 1 mode
- 3.) Place substrate with image side face up
- 4.) Place imaged paper with image face down
- 5.) Place foam pad on top
- 6.) Press at 300F for 60 seconds.
- 7.) Wait for substrate to cool and peel backing off cool.

#### CL Leather/Wood

- 1.) Insert into bypass tray and print mirror imaged.
- 2.) Print image in heavy to label 1 mode
- 3.) Place substrate with image side face up
- 4.) Place imaged paper with image face down
- 5.) Place foam pad on top
- 6.) Press at 300F for 60 seconds.
- 7.) Wait for substrate to cool and peel backing off cool.

## LEATHER/MAGNETS

### INSTRUCTIONS

#### CL Leather/Wood

Paper Mode: Heavy to Label 1

Print Mode: Mirror Image

Temperature: 300F

Time: 50 sec

Peel: Hot

Pressure: Heavy

#### Leather

Any white or light colored leather fabric. Recommended to print on the smooth side of the leather.

#### Materials Required:

Heat Press, Laser Printer, Foam Heat Pad, Leather Fabric

#### CL Leather/Wood:

- 1.) Insert into bypass tray and print mirror imaged.
- 2.) Print image in Heavy to Label 1 mode depending on your printer
- 3.) Place substrate with image side face up
- 4.) Place imaged paper with image face down onto substrate
- 5.) Place foam heat pad on top of substrate
- 6.) Press at 300F for 50 seconds. Use Heavy Pressure. Peel hot.

#### CL Metal Plus

Paper Mode: Color to Label 1

Print Mode: Mirror Image

Temperature: 300F

Time: 60 sec

Peel: Cool

Pressure: Heavy

#### Uncoated Magnetic Sheeting

Any white or light colored uncoated magnetic sheeting.

#### Materials Required:

Heat Press, Laser Printer, Foam Heat Pad, Uncoated Magnets

#### CL Metal Plus:

- 1.) Insert into bypass tray and print mirror imaged.
- 2.) Print image in Color to Label 1 mode depending on your printer
- 3.) Place substrate with image side face up
- 4.) Place imaged paper with image face down onto substrate
- 5.) Place foam heat pad on top of substrate
- 6.) Press at 300F for 60 seconds. Use Heavy Pressure. Peel cool.

Note: For CL Metal Plus, in OKI 6100 & 6150 print in Glossy mode

## METAL

### INSTRUCTIONS

#### CL Metal Plus

Paper Mode: Color to Label 1

Print Mode: Mirror Image

Temperature: 330F

Time: 90 sec

Peel: Cool

Pressure: Heavy

#### Anodised Metal (Brass)

Any white or light colored uncoated metals. This includes, silver, gold, and white metals

##### Materials Required:

Heat Press, Laser Printer, Foam Heat Pad, Metal Substrate

##### CL Metal Plus:

- 1.) Insert into bypass tray and print mirror imaged.
- 2.) Print image in color to Label 1 mode depending on your printer
- 3.) Place substrate with image side face up
- 4.) Place imaged paper with image face down onto substrate.
- 5.) Place foam heat pad on top
- 4.) Press at 330F for 90 seconds, use medium to heavy pressure
- 5.) Wait for substrate to cool and peel with even and smooth motion

Note: For CL Metal Plus, in OKI 6100 & 6150 print in Glossy mode

#### CL Metal Plus

Paper Mode: Color to Label 1

Print Mode: Mirror Image

Temperature: 330F

Time: 180 sec

Peel: Cool

Pressure: Heavy

#### DynaSub/UNISUB Metals

Any white or light colored polyester coated metal. This includes silver, gold, and white metals

##### Materials Required:

Heat Press, Laser Printer, Foam Heat Pad, Metal Substrate

##### CL Metal Plus:

- 1.) Insert into bypass tray and print mirror imaged.
- 2.) Print image in color to Label 1 mode depending on your printer
- 3.) Place substrate with image side face up
- 4.) Place imaged paper with image face down onto substrate.
- 5.) Place foam heat pad on top
- 6.) Press at 330F for 180 seconds, use medium to heavy pressure
- 7.) Wait for substrate to cool and peel with even and smooth motion

Note: For CL Metal Plus, in OKI 6100 & 6150 print in Glossy mode

## WOOD

### INSTRUCTIONS

#### CL Leather/Wood

Paper Mode: Heavy to Label 1

Print Mode: Mirror Image

Temperature: 300F

Time: 50 sec

Peel: Hot

Pressure: Heavy

#### Uncoated Wood

Any white or light colored uncoated wood. Wood substrates that are sensitive to heat and warp when heated are not recommended. Please test before commercial production.

#### Materials Required:

Heat Press, Laser Printer, Foam Heat Pad, Uncoated Wood

#### CL Leather/Wood:

- 1.) Insert into bypass tray and print mirror imaged.
- 2.) Print image in Heavy to Label 1 mode depending on your printer
- 3.) Place substrate with image side face up
- 4.) Place imaged paper with image face down onto substrate
- 5.) Place foam heat pad on top of substrate
- 6.) Press at 300F for 50 seconds. Use Heavy Pressure. Peel hot.

#### CL Leather/Wood

Paper Mode: Color to Label 1

Print Mode: Mirror Image

Temperature: 275F

Time: 120 sec

Peel: Cool

Pressure: Heavy

#### Coated Wood (Lacquered)

Any white or light colored coated wood. Wood substrates that are sensitive to heat and warp when heated are not recommended. Not all coated wood surfaces will work, please thoroughly test before commercial production.

#### Materials Required:

Heat Press, Laser Printer, Foam Heat Pad, Ceramic Tile

#### CL Leather/Wood:

- 1.) Insert into bypass tray and print mirror imaged.
- 2.) Print image in Color to Label 1 mode depending on your printer
- 3.) Place substrate with image side face up
- 4.) Place imaged paper with image face down onto substrate
- 5.) Place foam heat pad on top of substrate
- 6.) Press at 275F for 120 seconds. Use heavy pressure. Peel cool.

Note: Do not press at higher temperatures as the coating on the wood may be heat sensitive and may cause bubbles to form.

## ALUMINUM BOTTLE

### INSTRUCTIONS

#### CL Metal Plus

Paper Mode: Color to Label 1

Print Mode: Mirror Image

Temperature: 360F

Time: 200 sec

Peel: Cool

Pressure: Heavy

#### Aluminum Bottle

##### Mug Press without idle time

Any white or light colored Polyester Coated Aluminum Bottle.

##### Materials Required:

Mug Press, Laser Printer, Foam Heat Pad, Aluminum Bottle

##### CL Metal Plus:

- 1.) Insert into bypass tray and print mirror imaged.
- 2.) Print image in Color to Label 1 mode depending on your printer
- 3.) Wrap imaged paper around bottle with image facing bottle.
- 4.) Wrap felt heat pad around bottle
- 5.) Place bottle in mug press
- 6.) Close mug press and press at 360F for 200 secs
- 7.) Let Bottle cool and dunk into cold water. Then peel paper off.

Note: Not enough pressure will result in incomplete image transfer  
No Glazing is required for scratch resistance.

#### CL Metal Plus

Paper Mode: Color to Label 1

Print Mode: Mirror Image

Idle Temp: 300F

Press Temp: 360F

Time: 150 sec

Peel: Cool

Pressure: Heavy

#### Aluminum Bottle

##### Mug Press with idle time

Any white or light colored Polyester Coated Aluminum Bottle.

##### Materials Required:

Mug Press, Laser Printer, Foam Heat Pad, Aluminum Bottle

##### CL Metal Plus:

- 1.) Insert into bypass tray and print mirror imaged.
- 2.) Print image in Color to Label 1 mode depending on your printer.
- 3.) Wrap imaged paper around bottle with image facing bottle.
- 4.) Set mug press to idle at 300F. Ensure that it is at idle temperature.
- 5.) Wrap Foam heat pad around bottle. Place bottle in mug press.
- 6.) Close mug press and press at 360F for 150 secs
- 7.) Let Bottle cool and dunk into cold water. Then peel paper off.

Note: Not enough pressure will result in incomplete image transfer  
No Glazing is required for scratch resistance.

## STAINLESS STEEL BOTTLE

### INSTRUCTIONS

#### CL Metal Plus

Paper Mode: Color to Label 1

Print Mode: Mirror Image

Temperature: 360F

Time: 100 sec

Peel: Cool

Pressure: Heavy

#### *Curing Step*

Level: 3

Curing Time: 10-12 sec

CL Metal Plus: OKI 6100 & 6150  
print in Glossy mode

#### Stainless Steel Bottle

##### Mug Press without idle time

Any white or light colored Polyester Coated Stainless Steel Bottle.

##### Materials Required:

Mug Press, Laser Printer, Foam Heat Pad, Stainless Steel Bottle, Curing Unit

##### CL Metal Plus:

- 1.) Insert into bypass tray and print mirror imaged.
- 2.) Print image in Color to Label 1 mode depending on your printer
- 3.) Wrap imaged paper around bottle with image facing bottle.
- 4.) Wrap felt heat pad around bottle
- 5.) Place bottle in mug press
- 6.) Close mug press and press at 360F for 100 secs
- 7.) Let Bottle cool and dunk into cold water. Then peel paper off.

Note: Not enough pressure will result in incomplete image transfer

##### Curing The Bottle

This step is required for the bottle to become scratch resistant.

- 1.) Ensure the bottle is at room temperature
- 2.) Place bottle on curing unit.
- 3.) Set curing unit to level to 3
- 4.) Cure for 10-12 seconds

Note: DO NOT GO OVER 12 SECONDS. Overcuring can cause the coating on the bottle to discolor and burn.

## STAINLESS STEEL BOTTLE

### INSTRUCTIONS

#### CL Metal Plus

Paper Mode: Color to Label 1

Print Mode: Mirror Image

Idle Temp: 300F

Temperature: 360F

Time: 50 sec

Peel: Cool

Pressure: Heavy

#### *Curing Step*

Level: 3

Curing Time: 10-12 sec

CL Metal Plus: OKI 6100 & 6150  
print in Glossy mode

#### Stainless Steel Bottle

##### Mug Press with idle time

Any white or light colored Polyester Coated Stainless Steel Bottle.

##### Materials Required:

Mug Press, Laser Printer, Foam Heat Pad, Stainless Steel Bottle, Curing Unit

##### CL Metal Plus:

- 1.) Insert into bypass tray and print mirror imaged.
- 2.) Print image in Color to Label 1 mode depending on your printer
- 3.) Wrap imaged paper around bottle with image facing bottle.
- 4.) Set mug press to idle at 300F. Ensure that it is at idle temperature.
- 5.) Wrap Foam heat pad around bottle. Place bottle in mug press
- 6.) Close mug press and press at 360F for 50 secs
- 7.) Let Bottle cool and dunk into cold water. Then peel paper off.

Note: Not enough pressure will result in incomplete image transfer

##### Curing The Bottle

This step is required for the bottle to become scratch resistant.

- 1.) Ensure the bottle is at room temperature
- 2.) Place bottle on curing unit.
- 3.) Set curing unit to level to 3
- 4.) Cure for 10-12 seconds

Note: DO NOT GO OVER 12 SECONDS. Overcuring can cause the coating on the bottle to discolor and burn.