

INFORMATION & INSTRUCTIONS

General use

- Fabrics (100% polyester or special fabric for sublimation - SoftL'ink);
- Specially coated ceramics, metals (super-hard polymer coating);
- Mousepad material, fabric coasters, Unisub plastics

Printing

When using SubliJet refer to the PowerDriver Manual or if using ArTainium or another brand of ink use the instruction manual provided from the vendor you purchased your ink from. All images should be MIRRORED unless specified below.

IMPORTANT

When the image is printed (it will look dull on the paper-this is normal) you may want to trim the image to make it easier to position on your item to be printed. Secure your image to the object with heat tape to keep it from slipping or shifting. Place the item in your pre-heated heat press and follow the applicable instructions below. When pressing is done, gently remove the object and remove the paper (be careful not to let the paper shift across the surface of the object, or you may create a "ghost" image). When the object is removed from the press, just let it cool and it's done! Some imprintables have specific instructions to follow after the item has been removed from the press.

Heat Press Set-Up

Pressing time may vary. Adjust according to your own press. In order to properly heat set your sublimation transfers, you will need to adjust some settings depending on what type of material you are transferring to. Below is a guide for most sublimatable imprintables.

► Ceramic Mugs

Temperature: Phoenix Mug Press: 360°F; Idle 300°F; Other mug presses without an Idle: 400°F / **Time:** 240 seconds / **Pressure:** light

Tips: Print transfer and attach to the mug using a heat resistant tape. Wrap the mug with pellow (recommended) or plain white paper. Place the mug in the press for 4 minutes. Remove the mug from the press and remove the transfer immediately. Place the mug in room temperature water to cool and to stop the sublimation process.

Additional notes: It is important to recognize what your specific mugs "safe area" is. It is suggested that you make a test mug to define an area that you can depend on for quality results. For example, an average mug may take an image up to 1/2 inch of the top and bottom and no closer than 1 inch of the handles horizontally.

► Porcelain Mugs / Porcelain Money Banks / Porcelain Jar Holders / Porcelain Candles Holder

Temperature: Phoenix Mug Press: 360°F; Idle 300°F; Other mug presses without an Idle: 400°F / **Time:** 180-190 seconds / **Pressure:** light

Tips: Print transfer and attach to the mug using a heat resistant tape. Wrap the mug with pellow (recommended) or plain white paper. Place the mug in the press for 3 minutes. Remove the mug from the press and remove the transfer immediately. Place the mug in room temperature water to cool and to stop the sublimation process.

► Stainless Steel Travel Mugs

Temperature: Phoenix Mug Press: 360°F; Idle 300°F; Other mug presses without an Idle: 400°F / **Time:** 60 seconds / **Pressure:** light

Tips: Print transfer and trim to slightly smaller size than mug. Remove the plastic lid. Attach the transfer in position to the mug, using a heat resistant tape. Wrap the mug with pellow (recommended) or plain white paper. Place the mug in the press and press for 60 seconds. Remove the mug from the press and remove the transfer immediately. Allow to cool.

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▶ Aluminum Water Bottles

Temperature: Phoenix Mug Press: 390°F; Idle 205°F; Other mug presses without an Idle: 400°F / **Time:** 60 seconds / **Pressure:** light

Tips for Phoenix Mug Press: Print transfer and attach to the water bottle using a heat resistant tape. Using the green heat shield, wrap around the bottle and close the mug press. Press for 60 seconds. Remove the bottle from the press and remove the transfer immediately. Place the water bottle on a clean surface in room temperature to cool and to stop the sublimation process.

Conventional Oven using mug wrap and heat shield: 400F at 8 mins

Additional notes: It is important to recognize what your specific water bottles "safe area" is. It is suggested that you test the product before pressing.

▶ Porcelain Ornaments / Porcelain Magnets

Temperature: 400°F / **Time:** 180 - 240 seconds / **Pressure:** light

Tips: Prepare your artwork and make transfer with consideration to the size and shape of the ornament or magnet. First place your rubber or felt pad on the press. Place item face down on image and tape with heat resistant tape. Place the item facing down on the heat press and cover with plain white paper. Press at 400°F for 3 - 4 minutes using light pressure.

Remove transfer immediately being very careful as ornament is extremely hot. Allow to cool on a clean surface.

▶ Ceramic Tiles

Temperature: 400°F / **Time:** 360-420 seconds / **Pressure:** light

Tips: Make transfer larger than the tile by at least 0.25". Using a heat resistant tape, secure the transfer face down on the tile. First place your rubber or felt pad on the press. Place the tile facing down and place a sheet of plain white paper on top. Press at 400°F for 6-7 minutes using light pressure.

Remove transfer immediately being very careful as tile is extremely hot. Allow to cool on a clean surface.

▶ Plastic Ornaments

Temperature: 360°F / **Time:** 45 seconds / **Pressure:** Light to Medium

Tips: Prepare your artwork and ensure plastic protective layers are removed from both sides of the aluminum inserts. Place item face down on image and tape with heat resistant tape. Place the item face down on heat press with the paper on top. Then place silicone paper on top. Remove transfer immediately being very careful as the aluminum inserts get very hot. Allow to cool on a clean surface before sublimating the other side.

▶ Tumbled Stone Tiles

Temperature: 400°F / **Time:** 300-360 seconds / **Pressure:** light to medium

Tips: Make transfer larger than the tile by at least 0.25". Using a heat resistant tape, secure the transfer face down on the tile. First place your rubber or felt pad on the press. Place the tile facing down and place a sheet of plain white paper on top. Press at 400°F for 5-6 minutes using light pressure.

Remove transfer immediately being very careful as tile is extremely hot. Allow to cool on a clean surface.

▶ Mousepads / Coasters / Can Coolers / Fabric Puzzles

Temperature: 400°F / **Time:** 35-45 seconds / **Pressure:** light to medium

Tips: Prepare your artwork and size transfer with consideration to the size of the item. Using heat resistant tape, fasten the item in position facing the printed side of the transfer. Spread a white piece of paper on the bottom of the press. Place the item on the heatpress with the transfer on top of the item. Cover transfer with a sheet of plain white paper. Press with light to medium pressure for 35-45 seconds. Remove transfer immediately and set item to the side to cool.

*For Can Coolers, fold the black Velcro piece to the back before pressing to avoid crushing and flattening the velcro.

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► **Bags (See Joto's Bag Instructions for more info)**

Temperature: 390°F / **Time:** 40 seconds / **Pressure:** high

Tips: Prepare artwork and size transfer with consideration to the size of the bag flap. Remove any lint or fibers which might still be on the flap. If applicable (Ladies' Handbag and Wallet), cover the leather part of the flap with heat tape, silicon paper or Teflon sheets. **Prepress flap** for 20 seconds at 390°F. Use heat resistant tape to fasten the transfer image side down on top of the flap. Lay a piece of white paper on the bottom of the press and place the flap on the heat-press with transfer on top. Cover transfer with a sheet of plain white paper. Press at 390°F for 40 seconds with high pressure. Remove transfer while hot.

► **Unisub Plastics**

Temperature: 400°F / **Time:** 75-80 seconds / **Pressure:** medium (40 psi)

Tips: Prepare your artwork and design transfer with consideration to the size and shape of the specific Unisub product. Don't forget to remove the protective plastic covering. Place a sheet of plain white paper on the press. Using heat resistant tape, fasten the Unisub item in position facing the printed side of the transfer. Lay the imprintable face up on the heat press so that you are pressing onto the transfer. Cover imprintable with a sheet of plain white paper.

Press for 75-80 seconds using medium pressure. When pressing is finished carefully remove the transfer paper and allow to cool on a clean surface.

NOTE: If you are using item that can be printed on both sides allow the plastic to cool to room temperature before pressing to the 2nd side. Refer to the Unisub pressing guide for additional instructions.

► **Unisub Wood & Plaques**

Temperature: 400°F / **Time:** 75-80 seconds / **Pressure:** medium (40 psi)

Tips: Prepare your artwork and design transfer with consideration to the size and shape of the specific Unisub product. Don't forget to remove the protective plastic covering. Place a sheet of plain white paper on the press. Using heat resistant tape, fasten the Unisub item in position facing the printed side of the transfer. Lay the imprintable face up on the heat press so that you are pressing onto the transfer. Cover imprintable with a sheet of plain white paper.

Press for 75-80 seconds using medium pressure. When pressing is finished carefully remove the transfer paper and allow to cool on a clean surface.

NOTE: If you are using item that can be printed on both sides allow the plastic to cool to room temperature before pressing to the 2nd side. Refer to the Unisub pressing guide for additional instructions.

► **Unisub Metals**

Temperature: 400°F / **Time:** 60 seconds / **Pressure:** medium (40 psi)

Tips: Prepare your artwork and design transfer with consideration to the size and shape of the specific Unisub product. Don't forget to remove the protective plastic covering. Place a sheet of plain white paper on the press. Using heat resistant tape, fasten the Unisub item in position facing the printed side of the transfer. Lay the imprintable face up on the heat press so that you are pressing onto the transfer. Cover imprintable with an smooth absorbent paper towel. Press for 60 seconds using medium pressure. When pressing is finished carefully remove the paper towel and transfer paper.

Allow to cool on a clean surface. You may want to try pressing the metal from the back side with the transfer facing the rubber pad.

NOTE: If you are using item that can be printed on both sides allow the metal to cool to room temperature before pressing to the 2nd side. Refer to the Unisub pressing guide for additional instructions.

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Vapor Apparel Performance Fabric / SoftL'ink Garments

► **Vapor Apparel Performance Fabric (100% polyester)**

Temperature: 375°F / **Time:** 35 seconds / **Pressure:** light to medium

Tips: Place the shirt face-up on the platform, smoothing out folds and wrinkles. Cut transfer to size and place the transfer face-down on the shirt. Press with light to medium pressure for 35 seconds. Peel the transfer and remove the shirt from the press. Allow to cool on a clean surface. With all polyester shirts pressing lines will occur. To reduce the visibility of the pressing lines you can place a clean sheet of teflon on the heat pad before positioning the shirt. You may also want to bevel the edges of the heat press pad to a 45 degree angle using an exacto knife.

****Important for pressing Ringer or Player T-shirts:** Do NOT put the colored collar or colored sleeve edge of the Ringer or Player t-shirts in the heat-press. If necessary, silicon paper may be placed inside the collar/t-shirt and around the collar to protect the rest of the t-shirt and the heat press.**

Vapor Apparel Production Recommendations

In order to ensure your success with our Vapor Apparel shirts we would like to strongly recommend and encourage these minor heat press modifications, production tips, and image preparations:

1. **Reduce Pressure & Temperature / Extend Dwell Time:**

A well known way to reduce heat press lines from apparel is by reducing the heat and pressure during pressing. We recommend all at 375°F for 35 seconds.

2. **Bevel Your Heat Press Pad at 45° Angle:**

By beveling or rounding the edge of your heat pad you are dramatically reducing pressure on the edge of the garment from the heat press. **This will dramatically reduce heat transfer impressions on the garment.** For a smooth edge, we recommend that you use an exacto knife to trim the heat pad.

3. **Make Sure Paper is Larger than the Press Platen:**

This can usually be done with Epson 4000 and larger printers and will keep you from having paper press lines.

4. **Trim Images to Eliminate Paper Lines:**

When the printer is a 1280 or smaller, some decorators often take the time to trim the excess paper surrounding the transfer image. **This prevents any detection of the paper press line by the customer.** This step can be labor intensive if the graphics are odd shaped. Some decorators will also frame images with a darker color outline and then trim the excess paper.

5. **Other Tips for Eliminating the Paper Line:**

- Drop the head of the heat press on the sublimated shirt for 2-3 seconds after the paper is removed.
- Roll the shirt with a Teflon rolling pin immediately after pressing.
- Run your finger along the paper line immediately after pressing (Be careful - it will be hot!).
You may want to protect your finger with something.

► **SoftL'ink Garments**

Temperature: 400°F / **Time:** 20-25 seconds / **Pressure:** T-shirts-medium (approx. 40 psi)
Sweat Shirts-light (approx. 20 psi)

Tips: Place the shirt face-up on the platform, smoothing out folds and wrinkles. Cut transfer to size and place the transfer face-down on the shirt. Press for 5 seconds before applying transfer to remove any moisture.

Use a lint-roller brush over the surface of the garment that will come into contact with the heat press. This removes any lint, dust that may have settled on the fabric. Allow to cool on a clean surface.

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