ArTainium UV+ | SubliJet IQ | SubliJet R | SubliJet E PROFESSIONAL

Printing and Heat Transfer Instructions
Mug Sublimation

RECOMMEND APPLICATIONS

White or very light-colored polyester coated products.

Mug Sublimation: Step-By-Step

Once your sublimation system is setup and in place, printing and transferring an image onto a white or light-colored polyester coated mug is a breeze. Just follow these simple steps, and you are on your way to creating one-of-a kind, beautiful and profitable products.

1.) Import an image (it could be a photograph from a digital camera) into your graphics application and manipulate it to suit your desired result. Manipulation may include sizing the graphic, setting the proper page margins and borders for printing or applying color correction if required.

2.) Load quality transfer paper into your printer. The printable side is the brighter of the two sides.

3.) Click Print in your application and select the appropriate printing device. Ensure that the Mirror option is selected, unless you have already reversed the image in your graphics application.

4.) Once the image has been printed, trim the transfer paper around the image so that it may fit properly when wrapped around the mug. A print template is helpful in eliminating any guess work in this process.

5.) Center the transfer on the mug, smooth out any wrinkles and use heat tape to hold the paper in place. The printed side of the transfer should be placed directly against the polyester coated surface of the mug.

6.) Adjust your mug press settings. See chart below for ***suggested*** settings.

7.) Carefully insert the mug in the mug press. It is recommended to wrap the mug with protective paper before inserting it in the press. Close the heat press.

8.) After the allotted time, release the press. While still hot, peel the transfer paper from the mug (hot peel). Use care when removing the transfer paper as the mug will be extremely hot. Once the transfer paper has been removed, you can quickly cool the mug by placing it in room-temperature water.

ArTainium UV+/ SubliJet (Suggested Press Parameters)		
Ceramic	**US**	**Europe**
Temperature	375°F - 400°F	190°C - 204°C
Pressure	40 psi	2.81 kg/cm² ; 2.76 bar
Time	270-150 seconds	270-150 seconds
Metal	**US**	**Europe**
Temperature	350°F - 375°F	177°C - 190°C
Pressure	40 psi	2.81 kg/cm² ; 2.76 bar
Time	180-90 seconds	180-90 seconds

NOTE: *The temperatures expressed in this table are ACTUAL measured temperatures and are NOT based on the digital readings on the mug press display. Digital readout accuracy varies from press to press and therefore each mug press will need to be calibrated for accuracy.*

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IMPORTANT:

Due to variations in mug coatings and mug presses, these settings may vary. For best results, test different time/temperature combinations to find one that works best with your mug/mug press combination. Please note, higher temperatures generally require less time to prevent scorching. An insufficient time/temperature combination may hinder sublimation inks from completely curing to the polyester coating.

TIPS

- **Calibrating the heat press is recommended to ensure an accurate temperature. For this procedure, temperature test strips are more accurate than the use of infrared temperature guns.**

- **Consult the manufacturer's sublimation guide (supplied with your substrate) for recommended time, temperature, and pressure settings. The chart on Page 1 contains a compilation of suggested transfer times, temperatures, and pressures, based on various substrate surfaces. For best results, test different settings to find one that works for your application.**

- **If "browning" or "burn-out" occurs around the edges of the image, try reducing the temperature. A good rule of thumb is to reduce the temperature in increments of 10 degrees until the browning stops (the transfer paper should have a slight brown discoloration). Once you have eliminated any "browning" around the image, you may notice that the colors appear to be slightly faded or "washed out". This can be corrected by increasing the time in increments of 10 seconds until the colors are vibrant.**

- **If your mug has been in storage, allow it to reach room temperature before pressing. For best results, heat the mug until it is warm to the touch before applying the transfer paper.**

- **Avoid cheap inkjet transfer papers. We recommend using only high quality sublimation transfer papers that have been tested and approved by Sawgrass.**

- **If your press has an "idling temperature" setting, set the idling temperature 5 degrees lower than the operating temperature. This type of mug press requires the least amount of press time because the timer does not actually start until the temperature rises to the operating temperature.**