

## SUBLIMATION

### Printing

For Epson SureColor Series, please use a acrylic profile. For sublijet users, please use the Sawgrass Print Manager with the setting "Acrylic". All images should be MIRRORED unless specified below.

### Important

When the image is printed, it may look dull on the paper—this is normal. Trim the image to make it easier to position on your item. Secure your image to the object with heat tape to keep it from slipping or shifting. Protective plastic sheet on the metal must be peeled off before use with sublimation.

### Heat Press Setup

Before pressing, test the pressure on a blank piece. The pressure should be medium. Ensure that your press has reached the appropriate temperature before pressing.

Protect your heat press with silicon sheets underneath your substrate and on top of your substrate

### Pressing

#### OVERVIEW

**Press Temperature: 390°F for 90 seconds (1 minute and 30 seconds)**

**Firm Pressure, Cold peel recommended**

#### DETAILS

- 1.) Remove plastic cover from **both sides** of the acrylic.
- 2.) **Place two sheets of paper on the base of the heat press. (Important)**
- 3.) Place imaged sublimation paper face up in press and hover the press over it for 10-20 seconds to remove any moisture. (recommended)
- 4.) Remove imaged sublimation paper from heat press. And place on a table.
- 5.) With the imaged paper face up on the table, place acrylic on top of paper with printable side of acrylic face down. Tape both acrylic and paper together with heat tape.
- 6.) **Flip acrylic and paper over and place in heat press with paper on top.**
- 7.) Press at 395°F for 90 seconds using medium pressure.
- 8.) Remove acrylic **immediately!** Do not allow the acrylic to cool, place immediately on the mold and place the mold weight on top of the acrylic.
- 9.) Allow the acrylic to cool completely before lifting from the mold in order to retain its curved shape.

Note: Recommended cooling on cold surface for 120-180 seconds (2-3 minutes).

**IMPORTANT:** be careful not to press down on the mold weight, otherwise it'll cause cracks in the image.

**WARNING:** Acrylic is extremely hot after pressing, DO NOT handle with bare hands.

**NOTE:** **Extra care should be taken when handling the acrylic hot. The acrylic is vulnerable to damage while it is hot. Do not use a Teflon sheet when pressing**

### For Technical Support and to Re-Order

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