



## The Ultimate Sublimation Panels

### GUIDELINES TO SUBLIMATE DURALUXE PANELS

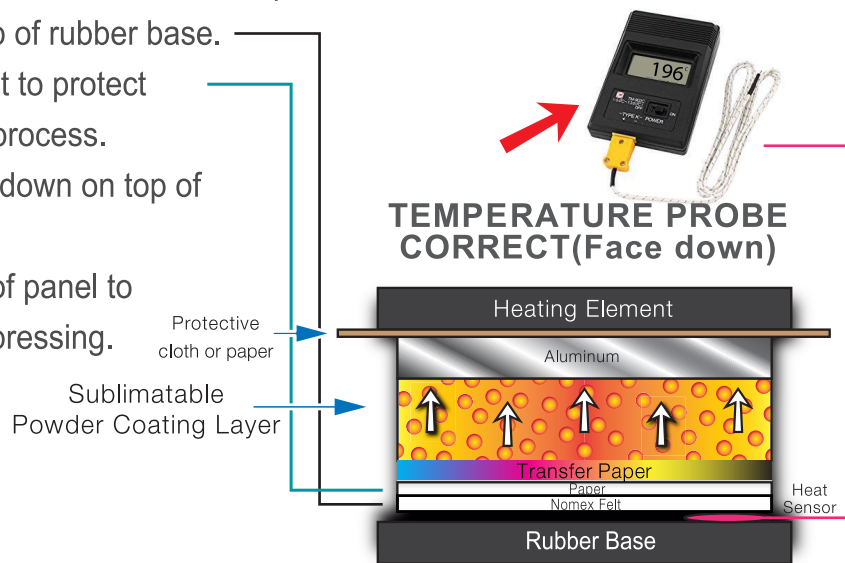
#### Duraluxe Panel Preparation

1. Remove the white protective film from the panel
2. Make sure surface is free of lint and dirt.
3. You may use alcohol to clean surface.
4. Make sure panel is dry before applying transfer paper.

#### Pressing Instructions:

1. Preheat heat press by cycling the press two times to warm up the base.
2. Place a Nomex or similar heat felt on top of rubber base.
3. Place a clean sheet of paper to cover felt to protect from excess ink gas during sublimation process.
4. Place Duraluxe Panel with transfer face down on top of protective paper.
5. Place clean paper or heat fabric on top of panel to protect from heat platen surface during pressing.
6. Check temperature is set for 196C/385F
7. Press time is set for 120 seconds\*
8. Pressure is medium or 60 psi.
9. Press the panel.
10. Remove protective paper from back of panel.
11. Lift panel from press careful with heat gloves.
12. Remove transfer paper and place panel face up on a cooling table or rack.

\* Adjust time depending on your heat press





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### TEMPERATURE SENSOR PROBE

Whenever you buy a heat press machine you need to make sure that it is accurate with a Temperature Sensor Probe (thermocouple), which is available online or a local hardware store. We do not recommend laser temperature guns as they may vary up to 15 degrees +/- . False readings can cause the press to sublimate at the wrong temperature and affect the ink from transferring completely to the panels.

Each manufacturer builds their heat press machines using their own designs. They make machines with a different spacing and density of their heating elements. It is critical to make sure that your heat press machine performs at its best.

It is very important that the Duraluxe panel surface reach 196C/385F for 1 or 2 seconds for an optimal and durable sublimation. A Temperature Sensor Probe (thermocouple) can be useful to determine the correct settings on your heat press to achieve this temperature. The results may vary from case to case based on the type of heat press, density of heating elements, heating power and transfer efficiency.