

# 12oz Enamel Mug with Flat Bottom



## 12OZ ENAMEL MUG WITH FLAT BOTTOM - Sublimation

XP8521 | XP8528 | DW268GR | XP8527 | XP8535 | XP8526 | XP8529



## GENERAL MUG PRESS PROCESS

### Recommended Equipment & Accessories

- Sublimation Printer
- Mug Press
- Bucket of room temperature water for cooling
- Heat Tape

<b>Recommended Settings - Constant Temperature Mug Press</b>	
Time	390-400°F
Temperature	240-270 seconds
Pressure	medium/moderate

### **General Sublimation Instructions - Constant Temperature Mug Press**

- Preheat the press to 390-400°F. Set the time to 240-270 sec., set pressure to medium/moderate.
- Wipe down the mug with a soft cloth misted with isopropyl alcohol.
- Print and apply the transfer to the mug using heat tape.
  - The top and bottom 1/4" to 3/8" may not get enough heat and/or pressure to sublimate consistently. Full bleed images are not recommended.
- Place the mug in the mug press, making sure the larger lip of the open end of the mug is outside of the heating element.
- Close and press for recommended time.
- When finished, remove the mug from press. Carefully remove the transfer paper from the mug and discard. Set mug aside to cool.
  - Optional: Submerge product with transfer still attached into room-temperature water to cool. Once cooled, remove transfer paper from the product and discard.

<b>Recommended Settings- Variable Temperature Mug Press</b>	
Time	105-115 seconds
Idle Temperature	220-225° F
Press Temperature	380-390° F
Pressure	Moderate

### **General Sublimation Instructions - Variable Temperature Mug Press**

- Preheat the press to 220-225° F idle temperature, and 380-390° F press temperature. Set the time to 105-115 sec. Set pressure to moderate.
- Wipe down the mug with a soft cloth misted with isopropyl alcohol.
- Print and apply transfer to the mug using heat tape.
  - The top and bottom 1/4" to 3/8" may not get enough heat and/or pressure to sublimate consistently. Full bleed images are not recommended.
- Place the mug in the mug press, making sure the larger lip of the open end of the mug is outside of the heating element.

- Close and press for recommended time.
- When finished, remove the mug from press. Carefully remove the transfer paper from the mug and discard. Set mug aside to cool.
  - Optional: Submerge product with transfer still attached into room-temperature water to cool. Once cooled, remove transfer paper from the product and discard.

## GENERAL CONVECTION OVEN PROCESS

### Recommended Equipment & Accessories

- Sublimation Printer
- Convection Oven
- Heat Shrink Sleeves or Quick Release Wrap
- Heat Gun
- Bucket of room temperature water for cooling

Recommended Settings- Convection Oven	
Time	7-8 minutes
Temperature	370-380°F
Pressure	Moderate

### General Sublimation Instructions - Convection Oven

- Preheat oven to 370-380° F while preparing the mug.
- Print and place transfer face down onto the mug. Secure transfer with heat tape.
  - The top and bottom 1/4" to 3/8" may not get enough heat and/or pressure to sublimate consistently. Full bleed images are not recommended.
- If using Shrink Sleeves: Slide heat shrink sleeve over top of the transfer paper. Use a heat gun to shrink the sleeve onto the mug.
  - To help hold the transfer paper in place on the mug, first shrink the wrap onto the taped ends of the transfer paper, then shrink the rest of the sleeve around the transfer paper.
  - Shrink one end of the sleeve first to help secure the transfer position on the mug.
- If using Quick Release Wrap: Wrap the mug and close by clasping metal ends.
  - If the mug has tapered sides, the Quick Release Wrap may need to be adjusted in order to fit tight around the tapered sides of the mug.
- Once oven is preheated, place the mug in the oven and heat for the recommended time.

- When finished, carefully remove the mug from the oven using heat gloves.
  - Carefully remove the shrink sleeve or silicone wrap.
  - Remove the transfer paper from the mug and discard. Set mug aside to cool.
    - Optional: Submerge mug with transfer still attached into room-temperature water to cool. Once cooled, remove transfer paper from mug and discard.
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### **Tips and Tricks**

- For best image placement, utilize the product template found on the product page on JPPlus.com.
  - When using two sleeves, overlap towards the center of the drinkware before shrinking to ensure even pressure across the entire graphic.
  - When heating multiple drinkware, additional heating time may be required.
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### **Troubleshooting**

- The image came out light and/or faded.
  - The time setting may need to be increased.
  - The temperature setting may need to be increased.
  - The pressure setting on the press or wrap may be too light and need to be increased for better contact between the sublimation transfer paper and the surface of the product.
  - The press or oven may not be heating at the temperature set on the display.
  - The sublimated image may have been printed on the wrong side of the sublimation paper.
- The image colors are dull on the sublimated product.
  - The press/heat time may need to be decreased.
  - The press/heat temperature may need to be decreased.
  - The print settings may need to be adjusted. Also check that the proper paper type and/or color profile is selected before printing the image.
- The image colors are not correct on the sublimated product.
  - The print settings may need to be adjusted. Also check that the proper paper type and/or color profile is selected before printing the image.
  - Convert the colors used in the image to RGB color mode in the design/layout software before printing.
  - If spot colors are used in the image (common for logos), convert the spot colors to RGB color mode in the design/layout software before printing.
- The sublimation paper is brown and sticking to the product.
  - The press/heat time may need to be decreased.
  - The press/heat temperature may need to be decreased.
  - The pressure setting may need to be decreased.
  - Use of a different sublimation paper brand or type may be needed for the particular product.
- The sublimated image appears blurry or fuzzy.

- The pressure setting may need to be increased.
  - The sublimation transfer paper may need to be secured to the product to prevent the paper from moving.
  - The sublimatable coating on the product may be defective.
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### **Templates and Images**

- Visit [jpplus.com](http://jpplus.com) to find the product page for this item. The product template may be found under the Tech Docs and Downloads area of the page.
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For additional product support and troubleshooting, please contact JPPlus Advanced Support Team:

- Phone: 419-500-4877
- Email: [ast@jpplus.com](mailto:ast@jpplus.com)
- Schedule an appointment: <https://jpplusadvancedsupport.setmore.com/>