

METAL ENAMEL MUG

XP8521, XP8522, XP8523

Settings (Constant Temp. Mug Press)

- **Time:** 240-270 Seconds
- **Temperature:** 390-400° F
- **Pressure:** Moderate

Tools & Accessories

- Heat Tape



Fabrication Process

- Affix the transfer to the mug using heat tape.
- Place sacrificial paper over the transfer.
- Place in mug press with the larger lip outside the heating element. Press.
- After cure time, remove from oven and set aside to cool. Water bath can be used for faster cooling.

Note

- The top and bottom 1/4" to 3/8" may not get enough heat and/or pressure to sublimate consistently.
- Full bleed image not recommended.

METAL ENAMEL MUG *(cont.)*

XP8521, XP8522, XP8523

Settings (Variable Temp. Mug Press)

- **Time:** 110 Seconds
- **Idle Temperature:** 220° F
- **Target Temperature:** 390° F
- **Pressure:** Moderate

Tools & Accessories

- Heat Tape

Fabrication Process

- Affix the transfer to the mug using heat tape.
- Place sacrificial paper over the transfer.
- Place in mug press with the larger lip outside the heating element. Press.
- After cure time, remove from oven and set aside to cool. Water bath can be used for faster cooling.

Note

- The top and bottom 1/4" to 3/8" may not get enough heat and/or pressure to sublimate consistently.
- Full bleed image not recommended.
- Ensure you have even pressure across the mug. On the JP450 you may need to place a second mug from the other side for even pressure or add a cylinder the same diameter as the mug. The bars of the mug press should be parallel to each other.



METAL ENAMEL MUG

XP8521, XP8522, XP8523

Settings (Convection Oven)

- **Time:** 7 Minutes 30 Seconds
- **Temperature:** 375° F
- **Pressure:** Moderate

Tools & Accessories

- Mug Wrap or EZ Wrap
- Heat Tape



Fabrication Process

- Affix the transfer to the mug using heat tape.
- Place sacrificial paper over the transfer.
- Wrap the mug using the mug wrap or EZ wrap. The larger lip should be outside the wrap.
- Place in convection oven.
- After cure time, remove from oven and set aside to cool. Water bath can be used for faster cooling.

Note

- The top and bottom 1/4" to 3/8" may not get enough heat and/or pressure to sublimates consistently.
- Full bleed image not recommended.