

LASER/SUB COFFEE MUGS 11 OZ. – XP8610, XP8611, XP8612

Using a *constant* heat temperature mug press:

1. Set the temperature on the press to 400°. Set your time to about 4-1/2 minutes. Have your pressure set so that it is firm, but be careful, too much pressure can crack or break the mug.
2. Trim your printed image to approx. 8" x 3-1/2" in size. This will leave about 1/8" of space between the image and the top/bottom of your mug. Align the paper near the handle so that there is about 3/4" of space between each side of the handle and the paper. Secure the image in place using a heat resistant tape.
3. Cover the mug with a second piece of standard copy paper cut to the size of the image. This can be secured with heat resistant tape as well.
4. Place mug inside mug press. Close the press and start the sublimation process.
5. When the timer completes its countdown, carefully remove the mug from the press and immediately place the mug into a container of room temperature water to Cool and stop the sublimation process. You can remove the paper either before or after placing into the water

Using a *varied* temperature mug press:

1. Follow the directions for your mug press to preset your "idle" temperature, your maximum "print" temperature, and your print time. These may vary slightly from model to model, but we recommend starting with 205° idle temperature, 390° print temperature and 15 seconds print time for an 11oz ceramic mug.
2. Prepare your mug as you would for a constant temp press. See steps 2-5 above.

Using a *convection oven* and a mug wrap:

1. Set your oven temperature to 400°.
2. Prepare your mug as in steps 2 & 3 above for constant temp press.
3. Attach mug wrap and place upside down on middle rack in convection oven.
4. Heat for 12-15 minutes. When finished, remove wrap and place mug into a container of room temperature water to cool and stop the sublimation process. You can remove the paper either before or after placing into the water.



LASER SETTINGS

- 75 watt Laser | Power 40% | Speed 70% | DPI 600
- 60 watt Laser | Power 40% | Speed 70% | DPI 600

Recommend using a mug jig to secure and level product. Graphics less than 1.5" width recommended. When using 2.5" or 3" lenses, set laser focus between 1/4" and 5/8" to the left or right of the highest point (center) of the curvature of the mug. If using smaller focal length lenses, the focus threshold (left to right) may vary.

Note: All settings are considered a safe starting point and may need some minor adjustments to achieve optimal results. For other laser wattages, settings may be extrapolated from settings provided above.

TECH

TIP

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