

Sublimatable Steel Tumblers with Lid and Straw

JOHNSONPLASTICS
PLUS

SUBLIMATABLE STEEL TUMBLERS WITH LID AND STRAW - Sublimation (Drinkware)

DW248SS | DW249SS | DW250SS | DW251SS | DW20S-P | DW20S-SW | DW20S-MG | DW20SPI |
DWSUB12-BG | DWSUB12-PP



GENERAL MUG PRESS PROCESS

Recommended Equipment & Accessories

- Sublimation Printer
- Mug Press
- Skinny Tumbler Mug Heating Attachment (JP4H6-4 or JP4H7-4)
- Heat Tape
- Heat resistant gloves or oven mitt
- Optional: Bucket of room-temperature water for cooling tumbler

Recommended Settings- Constant Temperature Mug Press (Single Side Printing)	
Time	50-60 seconds
Temperature	360-370°F
Pressure	Medium/Moderate

Recommended Settings- Constant Temperature Mug Press (Full Wrap-Around Printing)	
Time	45-50 seconds (Press 1 of 2), 30-40 seconds (Press 2 of 2)
Temperature	360-370°F
Pressure	Medium/Moderate

General Sublimation Instructions- Constant Temperature Mug Press (Single Side Printing)

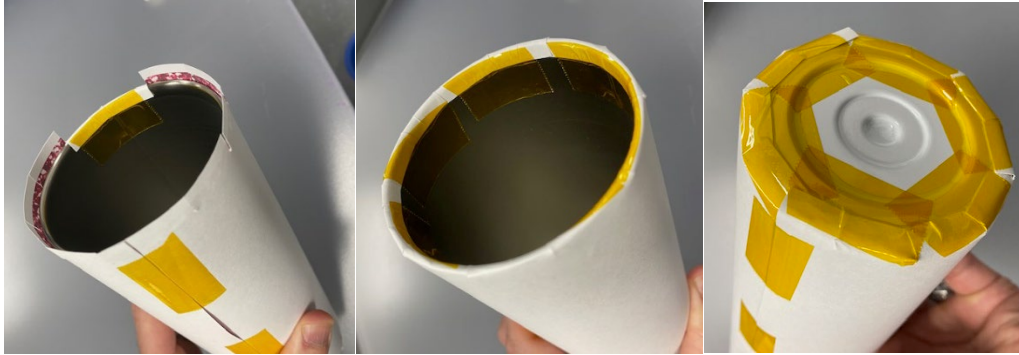
- Assemble and connect the tumbler attachment to the mug press.
 - For instructions on assembling the tumbler attachment to the mug press, see the "4 prong Mug Press Attachment for Skinny Tumblers" Tech Tip.
- Preheat the mug press:
 - Set the idle **and** press temperature to 360-370°F. Set pressure to Medium. Set press time to 50-60 sec.
 - **CAUTION:** Due to the idle temperature being the same as the press temperature, it is not recommended to leave the mug press power on for long durations between pressing the tumblers.
- Wrap the printed image around the outside of the tumbler. Ensure that the wrapped image is tightly fitted on the entire surface of the tumbler. Secure ends of the paper with heat tape.

- Place the tumbler into the open tumbler attachment. Ensure that the tumbler is centered inside the attachment.
 - It is recommended that the taped ends of the transfer paper are face up, in between the opening of the tumbler attachment.
- Close the press and start the timer (green button on the front of the control box).
- When finished pressing, open the press. Using heat-resistant gloves or an oven mitt, carefully remove the tumbler from the press.
- Carefully remove the transfer paper from the tumbler. Set tumbler aside to cool.
- Optional: Submerge the tumbler into a bucket of room-temperature water for faster cooling time.

General Sublimation Instructions (Full Wrap-Around Printing)

- Assemble and connect the tumbler attachment to the mug press.
 - For instructions on assembling the tumbler attachment to the mug press, see the “4 prong Mug Press Attachment for Skinny Tumblers” Tech Tip.
- Preheat the mug press:
 - Set the idle **and** press temperature to 360-370°F. Set pressure to Medium. Set press time to 50-60 sec.
 - **CAUTION:** Due to the idle temperature being the same as the press temperature, it is not recommended to leave the mug press power on for long durations between pressing the tumblers.
- Wrap the printed image around the outside of the tumbler. Ensure that the wrapped image is tightly fitted on the entire surface of the tumbler. Secure ends of the paper with heat tape.
 - Tip: For best sublimation results, ensure that the printed image is minimum 0.5”-0.75” away from both the top and bottom ends of the tumbler.

Image Transfer Tips
For best sublimation results, ensure that the printed image is minimum 0.5”-0.75” away from both the top and bottom ends of the tumbler.
If an image must run to the top and bottom ends of the tumbler, ensure that the printed image bleeds past the top and bottom ends of the tumbler.
To help the image slightly wrap around the top and bottom ends of the tumbler, cut slits into the ends of the transfer paper. Space the slits approx. 1/2- 3/4” apart. Fold the slits down and tape them to the inner lip on the top end and the bottom of the tumbler.



- Place the tumbler into the open tumbler attachment. Ensure that the tumbler is centered inside the attachment.
 - It is recommended that the taped ends of the transfer paper are face up, in between the opening of the tumbler attachment.
- Close the press and start the timer (green button on the front of the control box).
 - (This is press step 1 of 2.)
- When finished pressing, open the press. Using heat-resistant gloves or an oven mitt, carefully rotate the tumbler 180 degrees.
 - The taped ends of the transfer paper should now be on the bottom of the tumbler, opposite of the tumbler attachment opening.
 - **IMPORTANT:** When rotating the tumbler, take special care that the transfer paper does not move on the tumbler when rotating to avoid a blurred or ghosted image.
- Once the tumbler has been rotated, close the press and start the timer again. Allow the press to heat the tumbler for 30-40 seconds for 20oz tumblers.
 - (This is press step 2 of 2.)
- When finished pressing, open the press. Using heat-resistant gloves or an oven mitt, carefully remove the tumbler from the press.
- Carefully remove the transfer paper from the tumbler. Set tumbler aside to cool.
- Optional: Submerge the tumbler into a bucket of room-temperature water for faster cooling time.

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 tumbler before shrinking to ensure even pressure across the entire graphic.
 - Due to the materials most tumblers are made of, variable mug press settings are not recommended for these drinkware products.
 - For instructions on assembling the tumbler attachment to the mug press, see the “4 prong Mug Press Attachment for Skinny Tumblers” Tech Tip.
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GENERAL CONVECTION OVEN PROCESS

Recommended Equipment & Accessories

- Sublimation Printer
- Convection Oven
- Heat Shrink Sleeves or Quick Release Wrap
- Heat Gun
- Heat resistant gloves or oven mitt
- Optional: Bucket of room-temperature water for cooling tumbler

Recommended Settings- Convection Oven	
Time	6-7 minutes
Temperature	320-330°F
Pressure	Moderate

General Sublimation Instructions - Convection Oven

- Preheat oven to 320-330°F while preparing your drinkware.
- Print and place transfer face down onto the drinkware. Secure the transfer with heat tape.
- Using Shrink Sleeves: Slide heat shrink sleeve over top of the transfer paper. Use the heat gun to shrink the sleeve onto the tumbler.
- Shrink one end of the sleeve first to help secure the transfer position on the drinkware.
 - When transferring an edge-to-edge graphic, two sleeves can be used on the drinkware.
 - When using two sleeves, overlap towards the center of the tumbler before shrinking to ensure even pressure across the entire graphic.
- Using Quick Release Wrap: Wrap the drinkware and close by clasp metal ends.
- Once oven is preheated, place drinkware in oven and heat for the recommended time.
 - When heating multiple tumblers, additional heating time may be required.
- When finished, remove the drinkware from the oven.
- Submerge the drinkware in water immediately after removing from oven to cool. Remove wrapping after the product has cooled.

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 tumbler before shrinking to ensure even pressure across the entire graphic.
 - When heating multiple tumblers, 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 jplusplus.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.

To order more of this product, see similar products and much more, please visit jplusplus.com.

For additional product support and troubleshooting, please contact JPPlus Advanced Support Team:

- Phone: 419-500-4877
- Email: ast@jplusplus.com
- Schedule an appointment: <https://jplusplusadvancedsupport.setmore.com/>