

Sublimation on 12oz Enamel Mug



12OZ ENAMEL MUG- 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

Recommended Settings - Constant Temperature Mug Press	
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 product with soft cloth misted with isopropyl alcohol.
- Print and apply transfer to the product 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 image not recommended.
- Place in mug press with the larger lip outside the heating element.
- Close and press for recommended time.
- When finished, remove the product from press and submerge in room-temperature water to cool.

Recommended Settings- Variable Temperature Mug Press	
Time	105-115 seconds
Idle Temperature	115-225° F
Press Temperature	385-395° F
Pressure	Moderate

General Sublimation Instructions - Variable Temperature Mug Press

- Preheat the press to 115-225° F idle temp., and 385-395° F press temperature. Set the time to 105-115 sec., set pressure to moderate.
- Wipe down the product with soft cloth misted with isopropyl alcohol.
- Print and apply transfer to the product 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 image not recommended.
- Place the product into the mug press with the larger lip outside the heating element. 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. Close and press for recommended time.
- When finished, remove the product from press and submerge in room-temperature water to cool.

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

Recommended Settings- Convection Oven	
Time	7 minutes, 25 seconds- 7 minutes, 35 sec.
Temperature	370-380° F
Pressure	Moderate

General Sublimation Instructions - Convection Oven

- Preheat oven to 370-380° F while preparing your product.
- Print and place transfer face down on product. 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 image not recommended.
- If using Shrink Sleeves, slide heat shrink sleeve over top of the transfer paper. Use the heat gun to shrink the sleeve onto the mug. The larger lip should be outside the wrap.
- Shrink one end of the sleeve first to help secure the transfer position on the product.
- If using Quick Release Wrap, wrap the product and close by clasping metal ends.
- Once oven is preheated, place product in oven and heat for the recommended time.
- Submerge the product 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 drinkware before shrinking to ensure even pressure across the entire graphic.
- When heating multiple drinkware, additional heating time may be required.

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.
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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/>