

# Sublimation Cast Acrylic Sheet



**SUBLIMATION CAST ACRYLIC SHEET - Sublimation**



## GENERAL SUBLIMATION PROCESS

### Recommended Equipment & Accessories

- Sublimation Printer
- Standard Flat Heat Press- Swing-away style press recommended
- Heat Tape
- Teflon sheet or Blowout paper

Recommended Settings	
Time	105 seconds
Temperature	360-365°F
Pressure	Medium

### General Sublimation Instructions

- **For best results, it is recommended to sublimate first and then laser cut after sublimation.**
- Preheat the heat press to 360-365°F. Set the time to 105 sec., set pressure to medium.
- Print the image onto the transfer paper- TURN IMAGE MIRRORING OFF.
- Leave protective masking on the clear side of the acrylic sheet. Remove the protective masking on the white side of the acrylic sheet.
- Place the acrylic sheet blank with white layer face down onto the printed image. Secure the sheet blank to the transfer paper with heat tape.
  - To avoid paper edge crease lines from forming on the acrylic sheet, it is recommended to have the sublimation transfer paper sized larger than what the final laser cutout shape will be.
- Place blowout paper or Teflon sheet onto the heat press platen.
- Place the acrylic sheet blank with attached transfer onto the blowout/Teflon sheet, transfer on top.
  - **IMPORTANT:** Make sure protective masking is attached to the clear side of the acrylic sheet before heat pressing.
- Place another piece of blowout paper or Teflon sheet on top of the transfer sheet.
- Close and press for recommended time.
- When finished, open heat press and carefully remove the acrylic sheet.
  - **IMPORTANT:** Use caution when removing the transfer paper from the acrylic, as the acrylic will be soft from the heat of the press. Discard the transfer paper once removed.

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### Tips and Tricks

- After the heat press has heated to the press temperature, close and press the heat press empty for at least 3-5 minutes to allow the bottom platen to heat up.
  - Heating the bottom platen often helps balance the transfer of heat from the top heat platen to the product blank, ensuring a more successful transfer of the sublimation image to the product surface.

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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.
- The sublimation blank sticks to the top of the heat press when it is opened.
  - Place an additional piece of blowout paper or Teflon sheet on top of the sublimation blank and/or transfer paper before closing the press. This will help protect the surface of the product or transfer sheet, as well as prevent the vacuum effect that can cause the item to stick to the top platen when first opening the press.

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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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