

20oz Bluetooth Speaker Skinny Tumbler

JOHNSON PLASTICS
PLUS

20OZ BLUETOOTH SPEAKER SKINNY TUMBLER - Sublimation (Drinkware)

DWBST20-W



GENERAL MUG PRESS PROCESS

Recommended Equipment & Accessories

- Sublimation Printer
- Mug Press
- Heat Gloves
- Optional: Bucket of room temperature water for cooling

Recommended Settings - Constant Temperature Mug Press (Single Side Printing)	
Time	50-60 seconds
Temperature	360-375°F
Pressure	Medium/moderate

Recommended Settings- Constant Temperature Mug Press (Full Wrap-Around Printing)	
Time	50-55 seconds (Press 1 of 2), 40-45 seconds (Press 2 of 2)
Temperature	360-375°F
Pressure	Medium/moderate

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

- Preheat the mug press to 360-375°F. Set the time to 50-55 sec., set pressure to medium/moderate.
- Remove the lid of the tumbler as well as the Bluetooth speaker by unscrewing it from the bottom of the tumbler.



- Wipe down the tumbler with a soft cloth misted with isopropyl alcohol.
- Print and apply transfer to the tumbler using heat tape.
 - For best results, utilize the product template found on product page for the 20oz Bluetooth Speaker Skinny Tumbler on JPPlus.com.
- Place the tumbler into the mug press. Close and press for the recommended time.
- When finished, remove the tumbler from press. Carefully remove the transfer paper from the tumbler and discard. Set the tumbler aside to cool.
 - Optional: Submerge the tumbler with transfer still attached into room-temperature water to cool.
- Once cooled, remove transfer paper from the tumbler and discard.

General Sublimation Instructions - Constant Temperature Mug Press (Full Wrap-Around Printing)

- Preheat the mug press to 360-375°F. Set the time to 50-55 sec., set pressure to medium/moderate.
- Remove the lid of the tumbler as well as the Bluetooth speaker by unscrewing it from the bottom of the tumbler.



- Wipe down the tumbler with a soft cloth misted with isopropyl alcohol.
- Print and apply transfer to the tumbler using heat tape.
 - For best results, utilize the product template found on product page for the 20oz Bluetooth Speaker Skinny Tumbler on JPPlus.com.
- 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.
 - 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.
- When finished pressing, open the press. Using heat-resistant gloves or an oven mitt, carefully rotate the tumbler 180 degrees.
- Close the press and heat the tumbler again for an additional 40-45 seconds.
- 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.
- Once cooled, remove transfer paper from the tumbler and discard.

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.

GENERAL CONVECTION OVEN PROCESS

Recommended Equipment & Accessories

- Sublimation Printer
- Convection Oven
- Heat Shrink Sleeves or Quick Release Wrap
- Heat Gun
- Heat Gloves
- Bucket of room temperature water

Recommended Settings- Convection Oven	
Time	6-7 minutes
Temperature	330-340°F
Pressure	Moderate

General Sublimation Instructions - Convection Oven

- Preheat oven to 330-340°F while preparing the tumbler.
- Remove the lid of the tumbler as well as the Bluetooth speaker by unscrewing it from the bottom of the tumbler.



- Print and place transfer face down on the tumbler. Secure transfer with heat tape.
- If using Shrink Sleeves: Slide heat shrink sleeve over top of the transfer paper. Use a heat gun to shrink the sleeve onto the glass.
 - To help hold the transfer paper in place on the tumbler, first shrink the wrap onto the taped ends of the transfer paper, then shrink the rest of the sleeve around the transfer paper.

- Shrink one end of the sleeve first to help secure the transfer position on the tumbler.
 - When transferring an edge-to-edge graphic, two sleeves can be used on the tumblers.
 - If using Quick Release Wrap: Wrap the tumbler and close by clasp metal ends.
 - The Quick Release Wrap may need to be adjusted in order to fit tight around the sides of the tumbler.
 - Once the oven is preheated, place the tumbler in the oven and heat for the recommended time.
 - When finished, carefully remove the tumbler from the oven using heat gloves.
 - Carefully remove the shrink sleeve or silicone wrap.
 - Remove the transfer paper from the tumbler and discard. Set tumbler aside to cool.
 - Optional: Submerge the tumbler with transfer still attached into room-temperature water to cool. Once cooled, remove the transfer paper from the tumbler and discard.
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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 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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To order more of this product, see similar products and much more, please visit jpplus.com.

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

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