



The Ultimate Sublimation Panels

GUIDELINES FOR PERFECTLY SUBLIMATED PANELS



## BEFORE YOU START

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All presses operate slightly different, and your ambient temperature can affect the outcome as well. It is suggested to test with some small pieces of material to zero in the process to your setup before pressing large pieces.

The surface of your Duraluxe panel has been coated with Decoral's superior powder which is unique in the sublimation world, so it presses differently than other products to get the best results.

Before you start decorating remove the protective adhesive film. Be sure the panel surface is free of all dust, debris, and is perfectly dry. Any contaminants will negatively effect the outcome of your finished decoration. Warm up your press and run it on empty cycle two times before decorating.

## LET'S DECORATE

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To achieve a perfectly decorated surface, Duraluxe strongly suggests to sublimate your panels face down and to use a cloth or paper between the heating element and the Duraluxe panel.

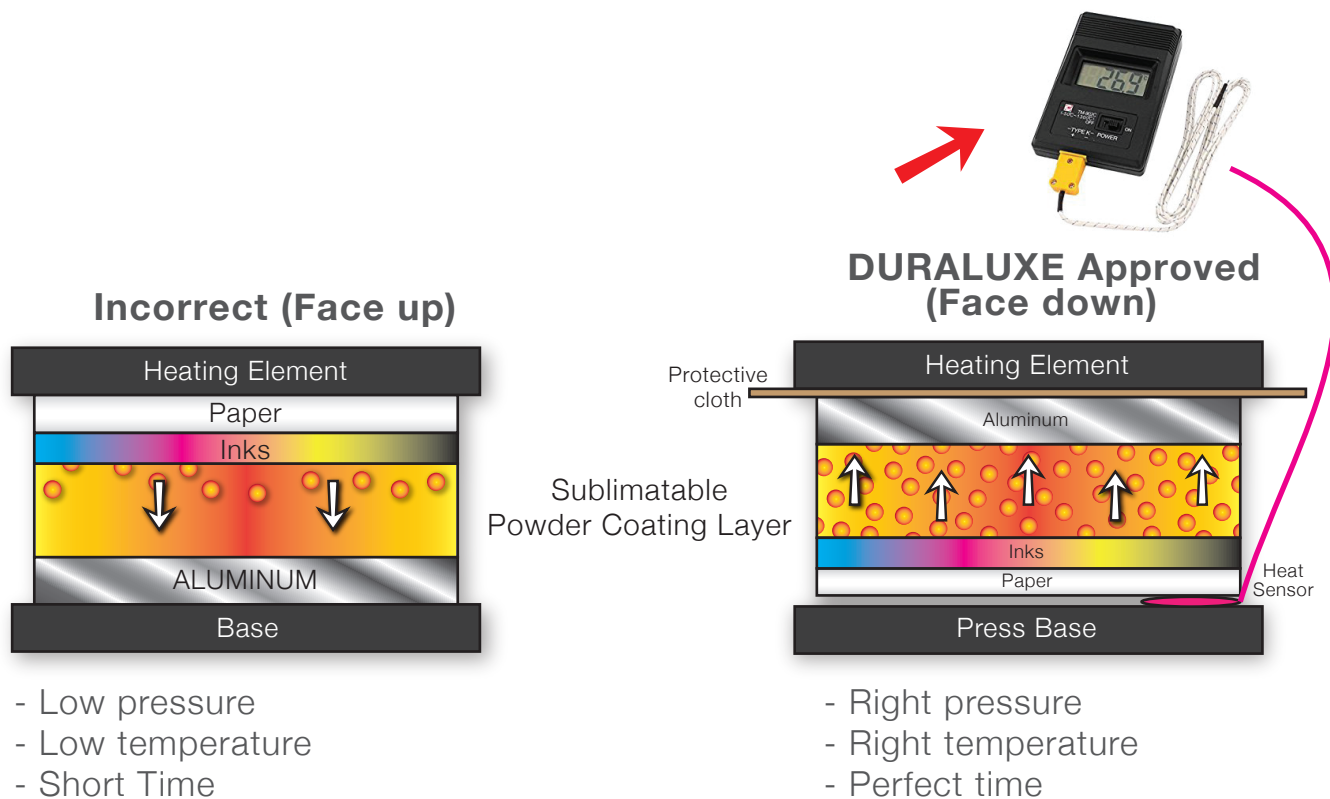
These are the steps to follow:

- Place sublimation paper face up on smooth clean surface.
- Position your Duraluxe panel face down onto the sublimation paper & align properly.
- Wrap sublimation paper on the back of Duraluxe panel and fix it with masking tape.
- Position sublimation paper and panel onto the press with Duraluxe panel face down.

## SUBLIMATABLE POWDER COATING LAYER

The diagrams below are a representation of correct and incorrect way to sublimate.

To be sure the surface of the panel has reached the desired temperature of 205°C / 401°F use a Thermo Couple probe placed between the press' base and the paper.



### *Time, Temperature, and Mechanical Pressure.*

Based on Decoral's 25 years of experience in outdoor architectural decorations, the perfect settings for an optimal sublimation of Duraluxe panels are: 205°C/401°F, for 140 - 160 seconds, with a pressure of 105 Psi.

Note: This pressure is based on 70 gram paper. The use of heavier paper will require you to lower your pressure. 140 gram will be 60Psi.

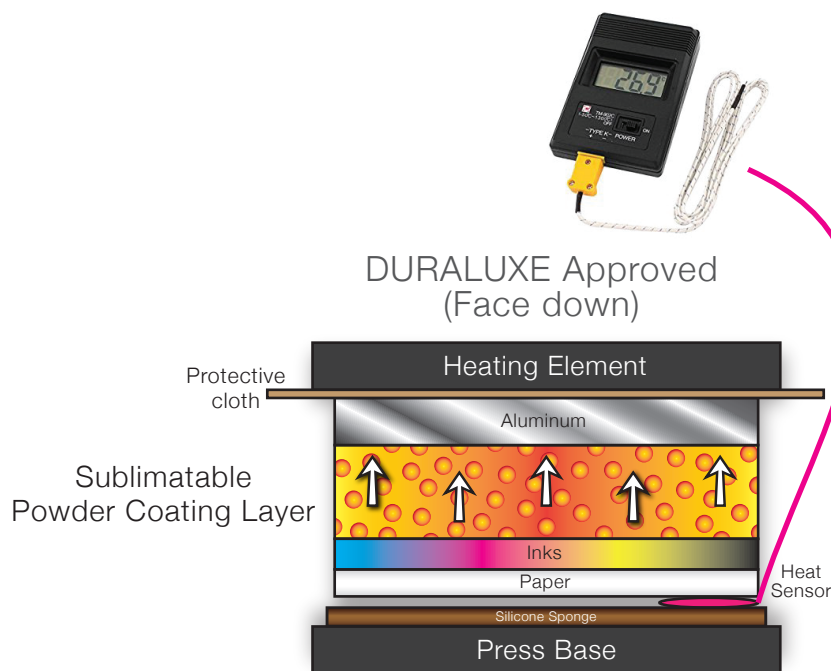
## LETS DECORATE (FOR SALT LAKE ONLY)

The SaltLake Duraluxe Panels have an exclusive textured surface that resembles Utah's Salt Lake. Because of its texture, SaltLake requires the usage of a 1/4" silicon sponge when you press to sublimate. The sponge will allow the paper to contour to the unique texture of Salt Lake, giving you the proper ink penetration, uniform consistency and the best result.

Place the silicon sponge on the base of your press, then the Duraluxe panel with paper. The sublimatable side faces down on the silicone sponge.

The diagram below is a representation of the correct way to sublimate onto the SaltLake finish.

To be sure the surface of the panel has reached the desired temperature of 205°C / 401°F use a Thermo Couple probe placed between the silicone sponge' base & the paper.

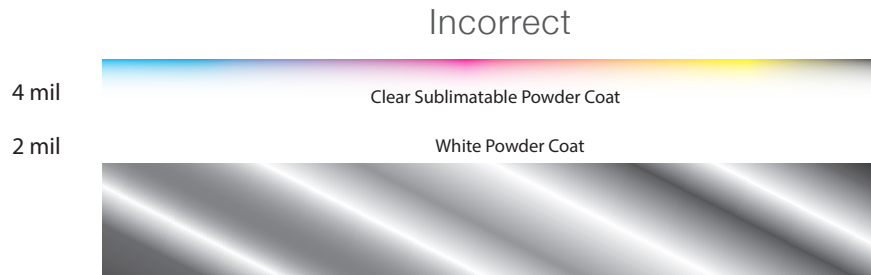


### *Time, Temperature, and Mechanical Pressure.*

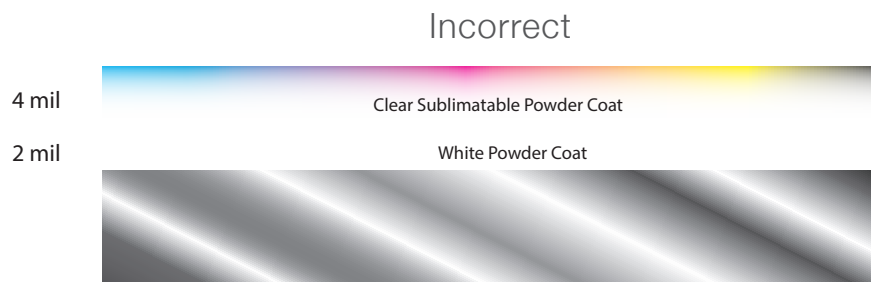
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## INKS' PENETRATION ACCORDING TO TEMPERATURE



Duraluxe panel decorated at **160°C/320°F** Ink penetration depth = 1 mil



Duraluxe panel decorated at **180°C/356°F** Ink penetration depth = 2 mil



Duraluxe panel decorated at **205°C/401°F** Ink penetration depth = 4 mil

