

## SUBLIMATABLE STEEL TUMBLERS w/ LID & STRAW

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

### Mug Press Process

#### Recommended Equipment

- Sublimation Printer
- Mug Press
- Bucket of room temperature water for cooling

#### Recommended Settings- Constant temp. mug press

- **Time:** 50-60 seconds
- **Temperature:** 360-375° F
- **Pressure:** Medium/Moderate

#### General Sublimation Instructions- Constant temp. mug press

- Preheat the press to 360-375° F. Set the time to 50-60 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.
  - Tip: For best image placement, utilize the product template found on the product page on JPPlus.com.
- Place the product into the mug press. Close and press for recommended time.
- When finished, remove the product from press and submerge in room-temperature water to cool.



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### Recommended Settings- Variable temp. mug press

- **Time:** 30-40 seconds
- **Idle Temperature:** 250° F
- **Press Temperature:** 360-375° F
- **Pressure:** Medium/Moderate

### General Sublimation Instructions- Variable temp. mug press

- Preheat the press to 250° F idle temp., and 360-375° F press temp. Set the time to 30-40 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.
  - Tip: For best image placement, utilize the product template found on the product page on JPPlus.com.
- Place the product into the mug press. Close and press for recommended time.
- When finished, remove the product from press and submerge in room-temperature water to cool.

## Convection Oven Process

### Settings

- Time: 6-7 minutes
- Temperature: 320-330° F
- Pressure: Moderate

### Equipment

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

### General Sublimation Instructions- Convection Oven

- Preheat oven to 320-330°F while preparing your product.
- Print and place transfer face down on product. Secure transfer with heat tape.
- If 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 product.
- When transferring an edge-to-edge graphic, two sleeves can be used on the tumblers.
  - When using two sleeves, overlap towards the center of the tumbler before shrinking to ensure even pressure across the entire graphic.
- 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.
  - When heating multiple tumblers, additional heating time may be required.
- Submerge the product in water immediately after removing from oven to cool. Remove wrapping after the product has cooled.



## Heat Transfer Process

### Equipment

- Heat Transfer Printer
- Hard Surface Heat Transfer paper with paper instructions
- Mug Press

### General Heat Transfer Instructions

- Follow Heat Transfer paper instructions for best image transfer results.
- Preheat mug press to 310° F (or recommended temp.) while preparing the product.
- Print the transfer onto the Hard Surface transfer paper.
- Position the printed transfer onto the product and secure using heat tape.
- Place the product into the mug press. Close and press for recommended time and pressure.
  - Refer to transfer paper instructions.
- When finished, open the mug press and remove the product. Peel transfer warm/hot or as stated in transfer paper directions. Discard the transfer paper.
- Set the product aside to cool.

### Note:

These recommendations are offered through our in-house testing and product knowledge. Minor adjustments may be needed to achieve optimal results.



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