

## SUBLIMATABLE HD PANELS

### Printing

When using SubliJet refer to the Sawgrass Print Manager Manual or if using Epson or another brand of ink use the instruction manual provided from the vendor you purchased your ink from. All images should be MIRRORED unless specified below.

### Important

When the image is printed, it may look dull on the paper—this is normal. Trim the image to make it easier to position on your item. Secure your image to the object with heat tape to keep it from slipping or shifting. Protective plastic sheet on the metal must be peeled off before use with sublimation.

### Heat Press Setup

Before pressing, test the pressure on a blank piece. The pressure should be light. Ensure that your press has reached the appropriate temperature before pressing.

Protect your heat press with silicon sheets underneath your substrate and on top of your substrate. **DO NOT ALLOW ANY PART OF THE METAL EDGES TO BE IN DIRECT CONTACT WITH YOUR HEAT PLATEN.**

### Pressing

#### OVERVIEW

**Press Temperature: 400°F, time varies for different sizes (refer to page 2)**  
**Please refer to chart on 2nd page for specific time for your size of metal.**  
**Maximum Pressure, Cold peel recommended**

#### DETAILS

- 1.) Remove plastic cover from metal
- 2.) **Place two sheets of paper on the base of the heat press. (important)**
- 3.) Place silicon sheet on top of rubber base.
- 4.) Place imaged sublimation paper face up in press and hover the press over it for 10-20 seconds to remove any moisture. (recommended)
- 5.) Remove imaged sublimation paper from heat press. And place on a table
- 6.) With the imaged paper face up on the table, place metal on top of paper with printable side of metal face down. Tape both metal and paper together with heat tape.
- 7.) **Flip metal and paper over and place in heat press with paper on top.**
- 8.) **Cover with polyester fabric, paper, tissue paper, or any thin absorbent material to absorb any residual moisture(important)**
- 9.) Press at 400°F for the appropriate amount of time; using maximum pressure
- 10.) Remove polyester fabric, let cool before removing the paper.

Note: Recommended cooling on cold surface for 120-180 seconds (2-3mins).

**IMPORTANT:** be careful not to let the paper shift across the surface of the object, or you may create a "ghost" image.

**WARNING:** Metal is extremely hot after pressing, DO NOT handle with bare hands.

**NOTE:** Extra care should be taken when handling the metal hot. The metal is vulnerable to damage while it is hot. Do not use a teflon sheet when pressing

### For Technical Support and to Re-Order

Tel: 1-800-565-5686 | Fax: 1-800-565-5622 | [www.jotoimagingsupplies.com](http://www.jotoimagingsupplies.com)  
Blaine WA, Las Vegas NV, Nashville TN, Coquitlam BC, Toronto ON

## SPECIFIC TIMES FOR METALS

Sizes	Temperature	Standard 16" x 20" Heat Press	30 "x 40" Press or larger
4" x 4" - 5" x 5"	400°F	65 secs (1:05)	50 secs
5" x 7" - 6" x 6"	400°F	70 secs (1:10)	60 secs (1:00)
8" x 8" - 8" x 10"	400°F	85 secs (1:25)	75 secs (1:15)
11" x 14"	400°F	105 secs (1:45)	80 secs (1:20)
5" x 10" - 10" x 10"	400°F	85 secs (1:25)	70-75 secs (1:10-1:15)
5" x 17" - 8" x 12"	400°F	85 secs (1:25)	70-75 secs (1:10-1:15)
11" x 11" - 12" x 12"	400°F	90 secs (1:30)	70-75 secs (1:10-1:15)
11" x 17"	400°F	100-105 secs (1:40-1:45)	75-80 secs (1:15-1:20)
9" x 21" - 12" x 18"	400°F	105-110 secs (1:45-1:50)	75-80 secs (1:15-1:20)
10" x 18" - 15" x 15"	400°F	110 secs (1:50)	75-80 secs (1:15-1:20)
16" x 20"	400°F	N/A	85 secs (1:25)
20" x 20"	400°F	N/A	80-85 secs (1:20-1:25)
20" x 24"	400°F	N/A	85 secs (1:25)
24" x 24"	400°F	N/A	85 secs (1:25)
20" x 30"	400°F	N/A	85 secs (1:25)
24" x 26"	400°F	N/A	85 secs (1:25)
24" x 30"	400°F	N/A	85 secs (1:25)
16" x 32"	400°F	N/A	85 secs (1:25)
18" x 36"	400°F	N/A	85 secs (1:25)
24" x 36"	400°F	N/A	85 secs (1:25)
30" x 30"	400°F	N/A	85-90 secs (1:25-1:30)
30" x 40"	400°F	N/A	90-95 secs (1:30-1:35)
32" x 40"	400°F	N/A	90-95 secs (1:30-1:35)
36" x 36"	400°F	N/A	90-95 secs (1:30-1:35)
38" x 58"	400°F	N/A	90-95 secs (1:30-1:35)
48" x 48"	400°F	N/A	95 secs (1:35)
40" x 60"	400°F	N/A	120 secs (2:00)
48" x 96"	400°F	N/A	150 secs (2:30)

Times are suggested starting points. Some tweaking may be required by the user

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## TIPS AND TRICKS

### Troubleshooting

**Reducing Chipped Edges** - HD Panels are vulnerable to chipping and damage if they are handled while hot. Letting the metal cool after pressing will reduce chipping as the metal is not being handled while hot. We have found that the paper does not stick to the metal when peeled cold and image quality is not affected.

**Uneven Print** - If printing is uneven, we recommend using a nomex pad when pressing ilumipix™. We have found that using a nomex pad will distribute the pressure and heat more evenly. Additionally, using a nomex pad will help minimize edge chipping on the metal.

**Ink Blowout** - This is due to moisture in the paper. If this occurs, place the printed sublimation paper on the press face up and let the heat platen hover above it for 15-30 seconds before pressing to the metal. Additionally, please ensure you are using a pella sheet or polyester fabric when pressing to absorb any excess moisture during the pressing stage.

### Finish Appears Semi Matte or Mottled

If this occurs, there are two reasons that this is happening:

- 1.) Applying too little pressure while pressing the metal will alter the finish. ilumipix™ requires heavy pressure only.
- 2.) Applying too much heat to the metal may affect the coating. If you get a mottled finish after pressing, try reducing the temperature and up the press time. Our recommended temperatures and times are required as not all heat presses are the same.



**Damaged Mottled Finish**

a guide. Some tweaking may be

### Sides are not sublimating

This occurs when pressing large sized metal face down. Please ensure you are pressing the metal face up. This will prevent the sides from not sublimating.

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