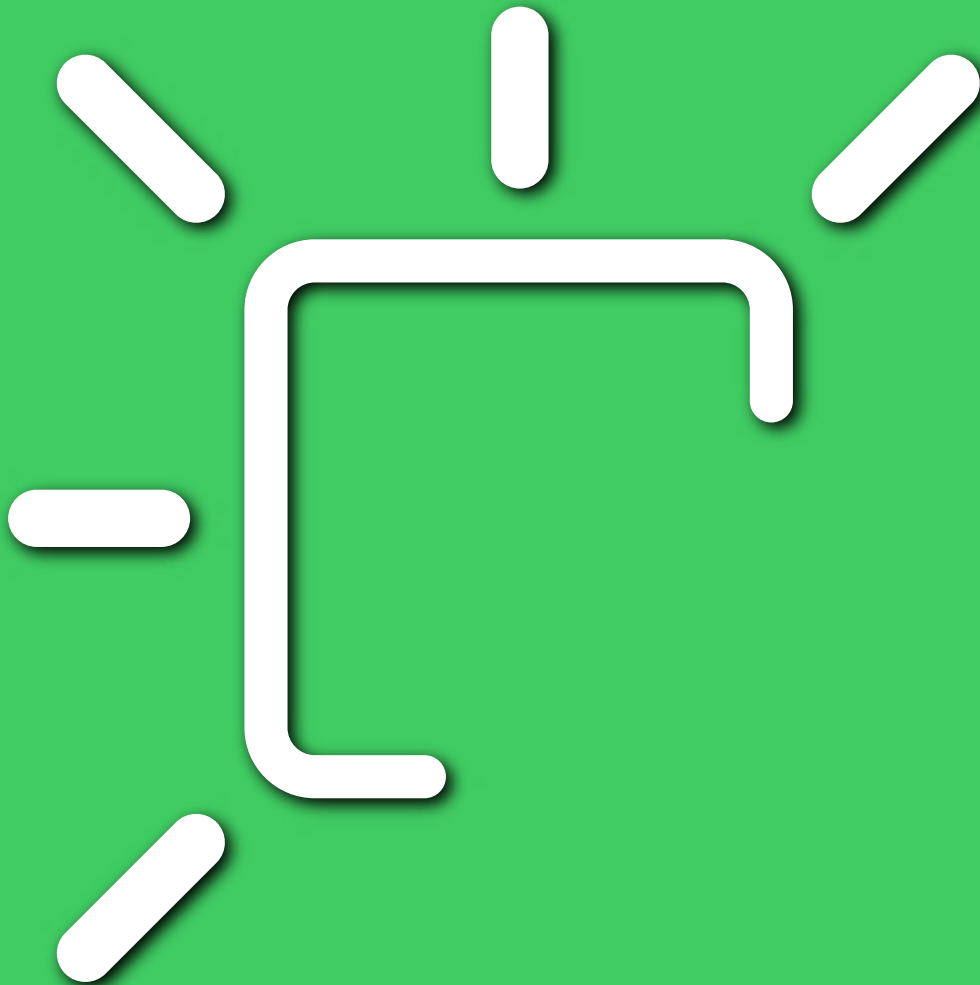




The Ultimate Sublimation Panels

GUIDELINES FOR PERFECTLY SUBLIMATED PANELS



## BEFORE YOU START

The surface of your Duraluxe panel has been coated with Decoral's superior powder. 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

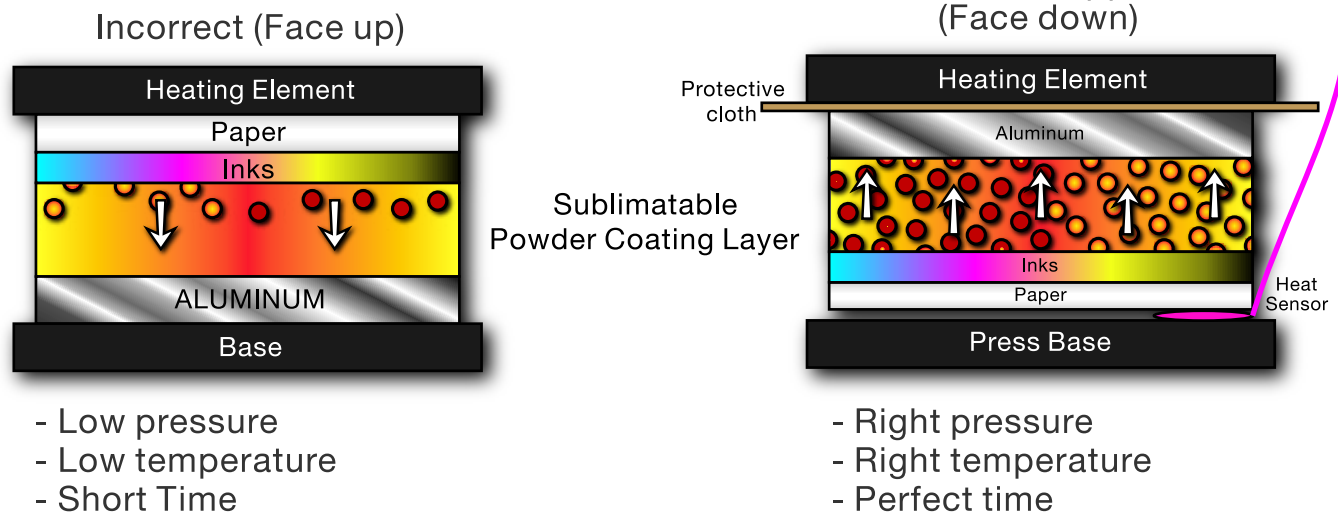
To achieve a perfectly decorated surface, Duraluxe strongly suggests to sublimate your panels face down and to use a cloth or paper between the heating element and the Duraluxe panel.

These are the steps to follow:

- place sublimatic paper face up on smooth clean surface
- position your Duraluxe panel face down onto the sublimatic paper and align properly
- wrap sublimatic paper on the back of Duraluxe panel and fix it with masking tape.
- position sublimatic paper and panel onto the press with Duraluxe panel face down.

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/400 F use a Thermo Couple probe placed between the press' base and the paper.



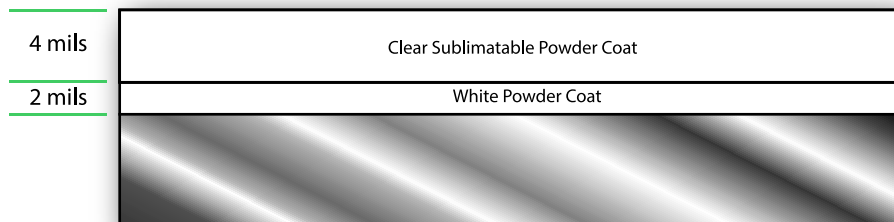
### *Time, Temperature, and Mechanical Pressure.*

Based on Decoral's 25 years of experience in outdoor architectural decorations, the perfect setting for an optimal sublimation of Duraluxe panels are:

**205°C/401°F, for 140 - 160 seconds, with a pressure of 105 Psi.**

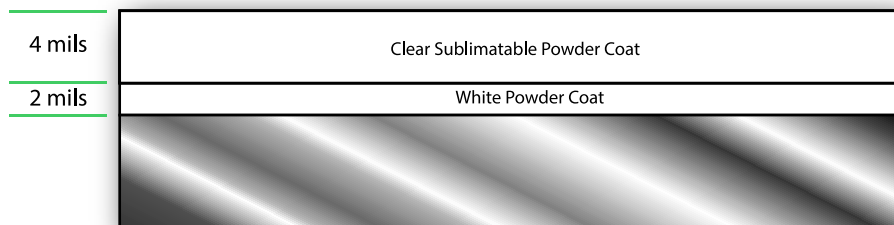
## INKS' PENETRATION ACCORDING TO TEMPERATURE

### Incorrect



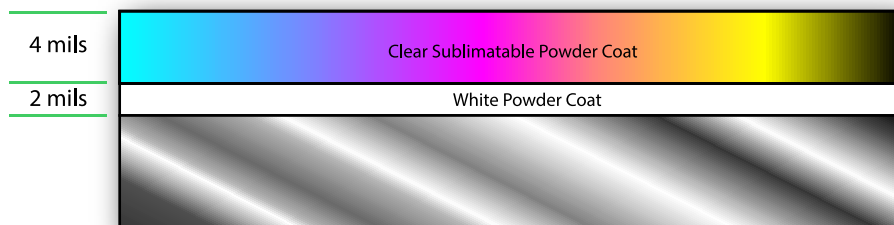
Duraluxe panel decorated at **160°C/320°F** Ink penetration depth = 1 mil

### Incorrect



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

### DURALUXE Approved



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