SubliJet IQ Heat Transfer Instructions

Because you can print on a variety of surfaces, you need to take all variables of the surface into account when selecting time, temperature and pressure. Some of the variables are:

- thickness of surface
- how fast the surface absorbs heat
- coatings used on the material to create a receptive surface for sublimation inks (ceramics, metals, etc.)
- accuracy of heat press (time, temperature, and pressure)

The time, temperature and pressure listed below are only guidelines. Check with your supplier for specific heat transfer instructions.

Due to the differences in heat presses and the various materials you will be printing on, it is not possible to give absolute figures. You should experiment to find your own preferred settings.

SURFACE	TIME	TEMP	PRESSURE	REMARKS
SoftL'ink	35 seconds	400° F	medium/40 psi	Press for 5 secs to eliminate moisture. Use Teflon sheet between sides of shirt to prevent "blow through"
Polyester/ Mousepads	45 seconds	400° F	medium/40 psi	
Ceramic	150 - 210 seconds	350° - 400° F	medium/40 psi	Time varies with press. Use tile mat when pressing onto ceramic tiles.
UniSub Metal	60 seconds	400° F	medium/40 psi	Remove plastic. Use absorbent sheet.
Other Metal (White, Gold, Silver)*	60 seconds	375° - 400° F	medium/40 psi	Remove plastic. Place absorbent sheet on bottom plate of heat press. Then place transfer paper face up on top of the absorbent. Next place substrate facedown on top of the transfer paper. Hot Peel.
UniSub Products	75 - 85 seconds	400° F	medium/40 psi	Remove plastic.
FR Plastic	75 – 80 seconds	400° F	medium/40 psi	Remove plastic.

***Please note that temperature settings can vary based on the brand of metal. Check with your reseller to determine what heat transfer parameters are best for the brand of metal you've purchased.**

SubliJet IQ - Additional Tips and Troubleshooting

Tips for Polyester Fabric

Maintain appropriate heat press times.

- Shortened pressing time will result in good surface color but the sublimation dyes will not completely penetrate the polyester fibers. This leaves the dyes more susceptible to wash out.
- Longer pressing times will cause the dye molecules to penetrate deeper into the fiber creating a washed out look. For guidelines on transfer times see the section entitled *Heat Transfer Instructions.*

Maintain appropriate heat press temperatures

- The correct temperature setting is vital for achieving desired results. Higher temperatures can damage the polyester fibers to the point that they cannot properly "hold" the dyes. For guidelines on transfer temperatures see the section entitled *Heat Transfer Instruction.*

Maintain appropriate pressure

- Too much pressure on the heat press may cause the dyes to penetrate too deeply into the fabric causing a washed out look. For guidelines on transfer pressure see the section entitled *Heat Transfer Instructions.*

Tips for Metal

- To obtain the best results when printing onto metal, place the transfer between the metal and an absorbent cloth or fresh, non-textured paper towel. This will absorb any dyes that pass back through the paper and any moisture released during the transfer process. If you have problems with inconsistently filled areas, this may alleviate the problem.

Tips for Ceramic Tiles and Mugs

- When transferring onto ceramic tiles and mugs, immediately peel the paper off of the ceramic after removing it from the heat press. Once the paper has been removed, cool the ceramic by submerging it in cool water, or run water over it from a faucet. If paper residue remains on the surface of the ceramic, clean with citrus cleaner. If you experience a significant paper-sticking problem, call your SubliJet reseller for assistance.

Tips for Hanes SoftL'ink® Shirts

- The presence of moisture in your fabric can lead to bleeding of the image. Remove moisture by pre-pressing your shirt for 10 seconds. Use Teflon sheets between the front and back of the shirt to prevent the inks from penetrating to the other side of the shirt. If dye residue from your heat press is being deposited on your shirts at any time, heat press a paper towel or similar absorbent material to remove residual dye.
- Using a lint brush before pressing can greatly reduce lint or debris on the shirt.
- The addition of moisture to the sublimation process can cause unwanted results. Under normal circumstances, the small amount of moisture that can accumulate in your paper is absorbed directly into the transfer substrate; however hard substrates like metal and ceramic are unable to absorb excess moisture. Some of problems that are attributed to moisture include:
    - color shifting (colors lose accuracy)
    - bleeding of the image
    - uneven transfer of solid filled areas

- **To avoid these moisture problems**
    - Keep the paper in a dry place.
    - If you suspect moisture, set the paper on your press for a few seconds. Do not press it; just expose it to the warmth. The heat radiating from the press should help evaporate most of the moisture.
    - To eliminate moisture in fabric, press the fabric for 10 seconds before transferring an image.
    - Use an absorbent cloth or fresh, non-textured paper towel behind the transfer sheet to absorb the moisture.