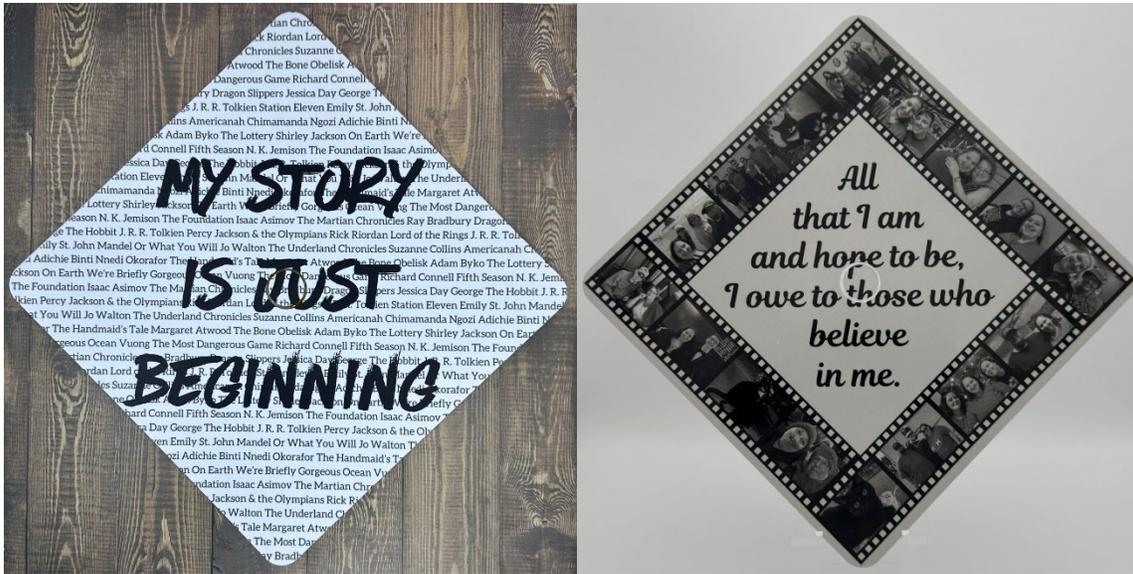


Bold Board Graduation Cap

JOHNSON PLASTICS
PLUS

BOLD BOARD GRADUATION CAP - Sublimation

GRADTOP-1 | GRADTOP-5



GENERAL SUBLIMATION PROCESS

Included with Purchase

- 6-Adhesive Hook & Loop Dots
- 1-9"x9" Bold Board Topper
- 1-Center Button Cover

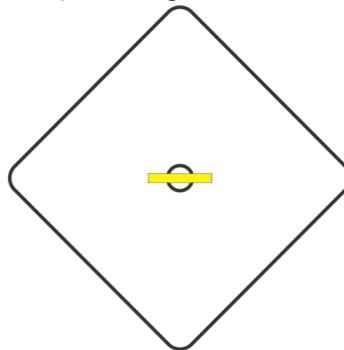
Recommended Equipment & Accessories

- Sublimation Printer
- Standard Flat Heat Press- Swing-away style press recommended
- Heat Tape and/or medium tack spray adhesive
- Teflon sheet or Blowout paper

Recommended Settings	
Time	60-70 seconds
Temperature	320-330°F
Pressure	Light

General Sublimation Instructions

- Create your design utilizing the included template.
 - Always allow for a slight overhang of the design (or bleed area) so that it will print flush with the edge of the topper.
- Place the center button cover in the very center of the hole in the topper and secure it in place from the reverse side using a piece of heat tape. See figure below:



- Preheat the heat press to 320-330°F. Set the time to 60-70 sec., set pressure to light.
- For best results, apply a light coating of medium tack spray adhesive to the printed side of the transfer paper.
 - If spray adhesive is not available, heat tape may also be used to secure the edges of the topper to the transfer paper. For best results, only adhere a small edge of the heat tape to the edges of the topper to help prevent or minimize tape lines.
- Apply the topper (taped side up) onto the printed sublimation transfer. Make sure the topper is perfectly centered on the printed image.
- Place blowout paper or Teflon sheet onto the heat press platen.
- Place the topper blank with attached transfer onto the sheet, with transfer on top.
- Place another piece of blowout paper or Teflon sheet on top of the transfer sheet.
- Close and press for recommended time.

- When finished, open heat press and remove the topper. Remove the transfer paper and discard.
- Your Bold Board Topper is double-sided and can be printed on both sides. To print the second side, repeat the steps above.

Note:

Your kit will include samples of topper material to test your process prior to fabricating the final Topper.

Tips and Tricks

- For best image placement, utilize the product template found on the product page on JPPlus.com.
 - After the heat press has heated to the press temperature, close and press the heat press empty for at least 3-5 minutes to allow the bottom platen to heat up.
 - Heating the bottom platen often helps balance the transfer of heat from the top heat platen to the product blank, ensuring a more successful transfer of the sublimation image to the product surface.
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Troubleshooting

- The image came out light and/or faded.
 - The time setting may need to be increased.
 - The temperature setting may need to be increased.
 - The pressure setting on the press or wrap may be too light and need to be increased for better contact between the sublimation transfer paper and the surface of the product.
 - The press or oven may not be heating at the temperature set on the display.
 - The sublimated image may have been printed on the wrong side of the sublimation paper.
- The image colors are dull on the sublimated product.
 - The press/heat time may need to be decreased.
 - The press/heat temperature may need to be decreased.
 - The print settings may need to be adjusted. Also check that the proper paper type and/or color profile is selected before printing the image.
 - The colors will come out slightly dull if the product does not have a white backing behind the sublimation/polyester layer.
- The image colors are not correct on the sublimated product.
 - The print settings may need to be adjusted. Also check that the proper paper type and/or color profile is selected before printing the image.
 - Convert the colors used in the image to RGB color mode in the design/layout software before printing.
 - If spot colors are used in the image (common for logos), convert the spot colors to RGB color mode in the design/layout software before printing.

- The colors will appear differently on the product surface if the product does not have a white backing behind the sublimation/polyester layer.
 - The sublimation paper is brown and sticking to the product.
 - The press/heat time may need to be decreased.
 - The press/heat temperature may need to be decreased.
 - The pressure setting may need to be decreased.
 - Use of a different sublimation paper brand or type may be needed for the particular product.
 - The sublimated image appears blurry or fuzzy.
 - The pressure setting may need to be increased.
 - The sublimation transfer paper may need to be secured to the product to prevent the paper from moving.
 - The sublimatable coating on the product may be defective.
 - The sublimation blank sticks to the top of the heat press when it is opened.
 - Place an additional piece of blowout paper or Teflon sheet on top of the sublimation blank and/or transfer paper before closing the press. This will help protect the surface of the product or transfer sheet, as well as prevent the vacuum effect that can cause the item to stick to the top platen when first opening the press.
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Templates and Images

- Visit jplusplus.com to find the product page for this item. The product template may be found under the Tech Docs and Downloads area of the page.
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To order more of this product, see similar products and much more, please visit Jplusplus.com.

For additional product support and troubleshooting, please contact JPPlus Advanced Support Team:

- Phone: 419-500-4877
- Email: ast@jplusplus.com
- Schedule an appointment: jplusplusadvancedsupport.setmore.com/