

# Porcelain Ornaments

**JOHNSON**PLASTICS  
PLUS

## PORCELAIN ORNAMENTS - Sublimation

SUB4100 | SUB4101 | SUB4102 | SUB4103 | SUB4104 | SUB4105 | SUB4108



## GENERAL SUBLIMATION PROCESS

### Recommended Equipment & Accessories

- Sublimation Printer
- Standard Flat Heat Press- Swing-away style press recommended
- Silicon pad (see charts below)
- Optional: Nomex felt pad
- Heat Tape
- Heat glove or old leather glove
- Teflon sheet or Blowout paper

<b>W/ WHITE SILICON PAD (recommended)</b>	
Time	2 minutes 55 seconds, 3 minutes 5 seconds
Temperature	390-400°F
Pressure	medium- heavy

<b>1/16" THICK GREEN SILICON PAD</b>	
Time	3 minutes, 25 seconds- 3 minutes, 35 seconds
Temperature	390-400°F
Pressure	medium- heavy

<b>1/8" THICK GREEN SILICON PAD</b>	
Time	4 minutes, 25 seconds- 4 minutes 35 seconds
Temperature	390-400°F
Pressure	medium- heavy

### **General Sublimation Instructions**

- Preheat the heat press to 390-400°F. Set the time and temperature according to the recommended settings for the pad type used. Set pressure to medium- heavy.
- Remove protective masking and place the ornament blank face down onto the printed transfer. Secure the ornament blank to the transfer paper with heat tape.
- Place blowout paper or Teflon sheet onto the bottom heat press platen.
  - For extra protection against cracking, place a Nomex felt pad onto the bottom platen and then place the blowout paper on top of the felt pad.
    - The press pressure will need to be adjusted to compensate for the felt pad.
- Place the ornament blank with attached transfer onto the blowout sheet, with transfer on top.
- Place another piece of blowout paper or Teflon sheet on top of the transfer sheet.
- Place the silicon pad on top of the blowout paper.
  - The press pressure setting may need to be adjusted slightly to compensate for the silicon pad.
- Close and press for recommended time.
- When finished, open heat press and remove the ornament. Remove the transfer paper and discard.
- Place the ornament on a table to cool.
  - Any paper residue left on an ornament can be cleaned off with alcohol AFTER the ornament is completely cool.
  - Dipping the ornament into water to speed the cooling process is NOT recommended.

---

### Tips and Tricks

- For best image placement, utilize the product template found on the product page on JPPlus.com.
- It is recommended that designs be created that do not come within approximately 1/4" of the outer edge of the ornament.
- Do not place more than one ornament on the same sheet of paper.

---

### 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 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 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.
-

### **Templates and Images**

- Visit [jpplus.com](https://jpplus.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.
- 

**To order more of this product, see similar products and much more, please visit [jpplus.com](https://jpplus.com).**

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

- Phone: 419-500-4877
- Email: [ast@jpplus.com](mailto:ast@jpplus.com)
- Schedule an appointment: <https://jpplusadvancedsupport.setmore.com/>