

Aluminum Ornament Inserts

JOHNSON PLASTICS
PLUS

ALUMINUM ORNAMENT INSERTS - Sublimation

SUB101 | SUB102 | SUB103 | SUB104 | SUB105 | SUB106 | SUB107



GENERAL SUBLIMATION PROCESS

Recommended Equipment & Accessories

- Sublimation Printer
- Standard Flat Heat Press- Swing-away style press recommended
- Heat Tape
- Teflon sheet or Blowout paper
- Optional: Spray adhesive (for double-side printing)

Recommended Settings	
Time	45-55 seconds
Temperature	360-370°F
Pressure	Medium
Sublimating both sides at the same time	Increase press time to 100-110 seconds

General Sublimation Instructions

- Preheat the heat press to 360-370°F. Set the time to 45-55 sec., set pressure to medium.
- Remove protective masking from both sides of the aluminum insert.

Single-side Printing

- Place product blank face down onto the printed transfer. Secure the product blank to the transfer paper with heat tape.
- Place blowout paper or Teflon sheet onto the heat press platen.
- Place the product 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 product. Remove the transfer paper and discard.

Double-side Printing

- Spray a very light coating of spray adhesive onto both of the printed images of the transfer papers. Allow 30 sec.-1 min. to dry.
- Place the blank metal insert face down onto one of the printed images on the first transfer paper. Press the blank lightly to get the surface to cling to the adhesive.
- Place the printed image on the second sprayed transfer paper down onto the remaining second face of the blank metal insert, with the image facing the blank metal surface. Press the paper lightly to get the surface to cling to the adhesive.
- Place blowout paper or Teflon sheet onto the heat press platen.
- Place the metal insert with both attached transfers onto the sheet.
- 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 metal insert. Remove the transfer papers and discard.
- If cleanup is needed, use a clean cloth dampened with isopropyl alcohol and wipe off both sides of the sublimated metal insert to remove and remaining adhesive residue.
- Place the metal insert into the insert slot within the ornament and assemble the ornament.
 - Some ornaments may have a plastic covering that is laying within the metal insert slot, which may need to be removed first before placing the metal insert into the space. The plastic covering that

is removed should then be placed over top of the inserted metal piece and pressed into place to encase the metal insert in the ornament.

Tips and Tricks

- For best image placement, utilize the product template found on the product page on JPPlus.com.
 - Ensure that the sprayed adhesive on the image of the transfer papers is very light and is given a small amount of time (30-60 sec.) to dry slightly, so that it is tacky but not wet.
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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 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 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.

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

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