

UNISUB/CHROMALUXE TECH TIPS

FRP, HARDBOARD, MDF, PHENOLIC, & ALUMINUM

Temperature and Dwell Times for Unisub Materials

A temperature of 400° F is recommended for all products. Use moderate to heavy pressure—it should require some effort to close your heat press. Time and temperature may vary depending on your heat press and the thickness of the blank material. Dwell times can be increased or reduced in 5-10 second increments until you find the time that results in the clearest image. The times shown below will provide a general starting point. REMOVE protective masking prior to fabrication and all Unisub products are fabricated FACE UP, (transfer paper on top).

| Unisub Material | Time |
|---|---------------|
| FR Plastic (name badges, bag tags) | 60-70 Seconds |
| FR Plastic for outdoor use (license plates) | 80-90 Seconds |
| Hardboard (clipboards, coasters) | 60-70 Seconds |
| MDF (plaques, paperweights) | 80-90 Seconds |
| Phenolic | 55-65 Seconds |
| Aluminum | 60-80 Seconds |

Time should be adjusted up or down based on the size of the product and/or the number of items being done simultaneously.

*Laboratory research has shown that using a longer dwell time can extend outdoor life. While these sublimatable products feature UV absorbers to extend outdoor life, they are not intended for permanent outdoor use. Fading will occur over time depending on the brand of sublimation ink used and outdoor environment. Contact your sublimation ink manufacturer for data on expected outdoor life.