

## Aluminum & Stainless Steel Water Bottles



### ALUMINUM AND STAINLESS STEEL WATER BOTTLES- Sublimation

XP8210 | XP8211 | XP8220 | XP8221



## GENERAL MUG PRESS PROCESS

### Recommended Equipment & Accessories

- Sublimation Printer
- Mug Press
- Heat Tape
- Heat Gloves
- Clean cloth and isopropyl alcohol
- Bucket of room temperature water for cooling

<b>Recommended Settings - Constant Temperature Mug Press (Single Side Printing)</b>	
Time	350-360°F
Temperature	90-110 seconds
Pressure	Light/moderate

<b>Recommended Settings- Constant Temperature Mug Press (Full Wrap-Around Printing)</b>	
Time	50-60 seconds (Press 1 of 2), 30-40 seconds (Press 2 of 2)
Temperature	350-360°F
Pressure	Light/moderate

#### **General Sublimation Instructions - Constant Temperature Mug Press (Single Side Printing)**

- Preheat the press to 350-360°F. Set the time to 90-110 sec., set pressure to light/moderate.
- Remove plastic lid before heating.
  - IMPORTANT: Keep plastic portion of bottle away from heating element.
- Wipe down the bottle with a soft cloth misted with isopropyl alcohol.
- Print and apply the image transfer to the bottle. Secure the transfer to the bottle using heat tape.
  - For best results, utilize the product template found on product pages for the Aluminum/St. Steel Tumblers on JPPlus.com.
- Place the bottle into the mug press. Close and press for recommended time.
- When finished, remove the bottle from press. Carefully remove the transfer paper from the bottle and discard. Set the bottle aside to cool.
  - Optional: Submerge the bottle with transfer still attached into room-temperature water to cool.
- Once cooled, remove transfer paper from the bottle and discard.

#### **General Sublimation Instructions - Constant Temperature Mug Press (Full Wrap-Around Printing)**

- Preheat the mug press to 350-360°F. Set the time to 50-60 sec., set pressure to light/moderate.
- Wipe down the bottle with a soft cloth misted with isopropyl alcohol.
- Print and apply transfer to the bottle using heat tape.
  - For best results, utilize the product template found on product pages for the Aluminum/St. Steel Tumblers on JPPlus.com.
- Wrap the printed image around the outside of the bottle. Ensure that the wrapped image is tightly fitted on the entire surface of the bottle. Secure ends of the paper with heat tape.

- It is recommended that the taped ends of the transfer paper are face up, in between the opening of the heating element attachment.
- Close the press and start the timer.
- When finished pressing, open the press. Using heat-resistant gloves or an oven mitt, carefully rotate the bottle 180 degrees.
- Close the press and heat the bottle again for an additional 30-40 seconds.
- When finished, open the press. Using heat-resistant gloves or an oven mitt, carefully remove the bottle from the press.
- Carefully remove the transfer paper from the bottle. Set the bottle aside to cool.
  - Optional: Submerge the bottle into a bucket of room-temperature water for faster cooling time. Once cooled, remove transfer paper from the bottle and discard.

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### Tips and Tricks

- For best image placement, utilize the product template found on the product page on JPPlus.com.
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## GENERAL CONVECTION OVEN PROCESS

### Recommended Equipment & Accessories

- Sublimation Printer
- Convection Oven
- Heat Shrink Sleeves or Quick Release Wrap
- Heat Gun
- Heat Gloves
- Bucket of room temperature water

Recommended Settings- Convection Oven	
Time	4-4.5 minutes
Temperature	350-360°F
Pressure	Medium/moderate

### General Sublimation Instructions - Convection Oven

- Preheat oven to 350-360°F while preparing your bottle.
- Print and place transfer face down onto the bottle. Secure transfer with heat tape.

- If using Shrink Sleeves: Slide heat shrink sleeve over top of the transfer paper. Use a heat gun to shrink the sleeve onto the bottle.
    - To help hold the transfer paper in place on the bottle, first shrink the wrap onto the taped ends of the transfer paper, then shrink the rest of the sleeve around the transfer paper.
    - Shrink one end of the sleeve first to help secure the transfer position on the bottle.
  - If using Quick Release Wrap: Wrap the bottle and close by clasp metal ends.
    - The Quick Release Wrap may need to be adjusted in order to fit tight around the sides of the bottle.
  - Once oven is preheated, place bottle in the oven and heat for the recommended time.
  - When finished, carefully remove the bottle from the oven using heat gloves.
  - Carefully remove the shrink sleeve or silicone wrap.
  - Remove the transfer paper from the bottle and discard. Set bottle aside to cool.
    - Optional: Submerge the bottle with transfer still attached into room-temperature water to cool. Once cooled, remove transfer paper from bottle and discard.
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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.
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### **Tips and Tricks**

- For best image placement, utilize the product template found on the product page on JPPlus.com.
  - When using two sleeves, overlap towards the center of the tumbler before shrinking to ensure even pressure across the entire graphic.
  - When heating multiple tumblers, additional heating time may be required.
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### **Templates and Images**

- Visit [jpplus.com](http://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.
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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/>