

# SUBLIMATION HEAT PRESS GUIDE

The following chart should serve only as a starting place. Producing quality end products is a matter of suitable substrates, a calibrated heat press, smart color management, following manufacturer guidelines, testing and practice! If you are having difficulty or the substrate is not listed below, contact your reseller or the substrate manufacturer for their specific recommendations.

Surface	Time	Temp	Pressure	Tips
Ceramic Mugs	150-200 sec	350-400 F 177-204 C	40 psi Medium	Time varies with press. Press into silicon pad. Mugs should be cooled down after transfer paper is removed either in a bucket of warm water or using a cooling plate.
Stainless Steel Tumblers	60-90 sec	365 F 185 C	40 psi Medium	Time varies with press. If you are doing a full wrap, press for 60-90 sec. then rotate your tumbler 180 degrees and press a second time for 60-90 sec.
Polyester Fabric	35-45 sec	400-410 F 204-210 C	40 psi Medium	Pre-press shirt for 3-5 seconds to eliminate moisture. Tack spray transfer and use blow-out sheet to avoid ghosting
Vapor Apparel	45-55 sec	380-390 F 193-199 C	40 psi Medium	See vaporapparel.com for tips on reducing press lines.
Polyester with Foam Backing (Koozie/mousepad)	45 sec	400 F 204 C	40 psi Medium	Look for a tight knit and high white point for more brilliant color.
Metal/Chromalux (Unisub brand)	60 sec	400 F 204 C	40 psi Medium	Use blow-out paper. Remove plastic coating before pressing.
Metal (Other brands)	45 sec	375-400 F 190-204 C	40 psi Medium	Time varies with metal manufacturer (always consult manufacturer for correct time and temp). Place absorbent sheet on bottom of heat press. Then, place product transfer side DOWN on top of the absorbent sheet.
Unisub Products	60 sec	400 F 204 C	40 psi Medium	Remove plastic coating. Tear transfer paper away immediately after pressing.
Glass or Ceramic Tiles	300-720 sec	400 F 204 C	40 psi Medium	Time varies depending on tile type and size. Always consult manufacturer. Press tiles from back (transfer side down). Press into silicon pad.
Fire Retardant Plastic	40-75 sec	350-400 F 177-204C	40 psi Medium	Remove plastic coating. Tear transfer paper away immediately after pressing
Hardboard	60 sec	400 F 204 C	40 psi Medium	Remove plastic coating and press with the transfer paper on top. Remove immediately after pressing unless the surface is textured. Then wait for substrate to cool and then remove the transfer paper.

Surface	Time	Temp	Pressure	Tips
Glass	180-240 sec	360-400F 182-204 C	40 psi Medium	Be careful not to put too much pressure on the glass. This can shatter it. Wear protective gear. Always check with the substrate manufacturer for pressure and heat settings.
Felt	60 sec	400 F 204 C	30-40 psi light/medium	Felt can curl as it cools. Place a heavy object on the substrate immediately after pressing and allow to cool while compressed.
Marble	120 sec	390 F 199 C	40 psi Medium	Peel transfer paper while hot. If the marble has attachable cork or material, wait for the substrate to fully cool before attaching.
Siser EasySubli	15-30 sec	310 F 154 C	40 psi Medium	Make sure to remove the backing before pressing. You can press with a mask if needed. Peel mask immediately after pressing. Do not wash for at least 24 hours
Polyester Linen	55-65 sec	385-425 F 196-218 C	40 psi Medium	Peel transfer while hot. Press with substrate facing up and transfer paper on top
Wood	60 sec	400 F 204 C	40 psi Medium	Remove any plastic coating. Press with the transfer on top.