

CONDÉ

5600 Commerce Blvd East
Mobile, AL 36619
1-800-826-6332
251-633-5704

PRODUCT INSTRUCTIONS

MUG PRESS: Swirl, USA and Ceramic Mugs and
Glass Mugs

Substrate	Temperature	Prepress	Press Time	Pressure
MUG11SW, MUG15SW, MUG11, MUGK11, MUG11US, MUG02, MUG15US, MUG01, MUG15, MUGK15, MUG11SW, MUG15SW, DECO-MUGY, DECO-MUGK, DECO-MUGC, DECO-MUGM, DECO-MUGG, DECO-MUGY-CH, DECO-MUGK- CH, DECO-MUGC-CH, DECO-MUGM-CH, DECO- MUGG-CH, DECO-MUG15K, DECO-MUG15C, DECO-M	400°F		3.5-8 minutes see below	Medium to Heavy

Additional Items: Heat Tape, ProSpray, Green Pad

Recommended Paper: DyeTrans Multi-Purpose

PowerDriver Setting: Ceramic Mug or Glass Mug use Power Driver: Unisub Products

Step-by-step:

All instructions are geared to the George Knight Heat Presses, these use the DK3 Mug Press or mug attachment for the DC16 Combo press.

Glass Mugs Require: 1/8" green rubber pad (P/N# HCR-1849)

MUG11US: 11 oz = 3.5 minutes

MUG15US: 15oz = 4 minutes

MUG02 = 4 minutes

ALL OTHER Ceramic Mugs:

10/11 oz = 4.5-5 minutes (10oz. ceramic mug will not image all the way to the top)

15 oz = 5.5-6 minutes

ALL Glass Mugs: 8 Minutes

All Swirl Mugs require heavy pressure, pull the transfer tightly against the mug. 11oz = 5 minutes, 15oz = 6 minutes

1) Print the transfer. Note that the typical imaging area is 1.25" in from the handle and .25" from the top and bottom sides of the mug. Beyond that, follow our directions for top to bottom transfers.

2) Trim the transfer to just over the size of the mug.

3) Lightly mist transfer with DyeTrans Pro Spray and let dry 15-20 seconds.

4) Carefully place the transfer on the mug, smooth wrinkles. Wrap the mug with protective plain white paper. Do not allow paper to extend well above or below the top and bottom of mug. This part of the paper may wrinkle and the wrinkles will imprint onto the mug. But DO cover the entire mug with plain paper or you may "caramelize" the coating and it will turn brown or yellow. To

imprint closely to handle, use the green pad, wrap loosely at the handle bulge, this will allow more complete imaging.

5) Press with Temp/Time/Pressure settings listed above.

6) Cool ceramic mugs in room temperature water. Do not dunk glass mugs.

7) Remove any paper residue with a soft wet cloth or dish sponge.

Notes on the George Knight® DK3 Mug Press:

The mug being pressed must be placed with the handle exactly in the middle of the opening, otherwise, the squeezing motions will snap off the handle when the mug is clamped.

Only what the mug press pad covers will sublimates. Also, if you try to image on or below the bottom of the mug and the mug is tapered, it may not sublimates correctly.

The black mug with the white imaging panel has a tolerance of plus or minus 1/8". It is very important to keep this in mind when making your designs for this particular mug.

To do a perfect mug with imaging as far as possible to the top-to-bottom and around to the handle:

1) Pro Spray

2) 1/16" green rubber pad @ 9-3/8" x 4-1/8".

3) Geo Knight press extender. You can tell if the press has the extender if the threads on the tightening mechanism are silver instead of black. This technique will allow full top-to-bottom transfer and 1/4" imaging from the handle.

NOTE: Using the Latte Mug template can be tricky, here's video: [Using the Rotation Tool for latte Mug Templates](#)

Updated: May 2, 2013

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PRODUCT INSTRUCTIONS

DYEWRAP: Coin Banks, Ceramic Mugs and Steins, Aluminum and Stainless Water Bottles, Stainless Steel Mugs and Ceramic Shot Glasses
Using an Oven Wrap

Substrate	Temperature	Prepress	Press Time	Pressure
PB01W, PH11, DECO-LMUG, DECO-MUG, DECO-SHOT, LMUG14, LUVMUG, MUG01/02, MUG11US/SW, MUG15US/SW, MUGK11, MUGK15, RH-LMUG14, RH-MUG11, SHOT0, STEIN, MUG14/18/22/25SS, WB002/3, WB600	400°F		6-18 minutes	

Additional Items:

Recommended Paper: DyeTrans Multi-Purpose

PowerDriver Setting: each mug is noted

Step-by-step:

Note: 10oz ceramic and glass mugs are not suitable for imaging in an oven.
STEIN28G is not suitable for top to bottom imaging.

All Steins: Careful not to use too much pressure, it can wrinkle your transfer, use a protective cover sheet but do not reuse that sheet, it will have ink on it after one use.

Remove the water bottle lids before sublimating.

Note: The area of the travel mug beyond the white patch is sublimatable, so any bleed beyond this area will transfer onto the mug.

Coin Banks, Ceramic Mugs and Steins (all except STEIN16/K, STEIN01 and Funnel Mugs) Using DYEWRAP-10; PowerDriver: Ceramic = 15 minutes

STEIN16 and STEIN16K = 15 - 17 minutes (time will vary by oven used and type of image)

Ceramic Latte Funnel Mugs using DYEWRAP02; PowerDriver: Ceramic = 15 minutes

12oz. Stainless steel mugs using DYEWRAP-10 (MUG18SS, with removable plastic insert); PowerDriver: Silver Metal = 8 minutes

Aluminum Water bottles using DYEWRAP-68; PowerDriver: White Metal or Silver Metal = 6-8 minutes

Stainless Water bottles using DYEWRAP-68; PowerDriver: White Metal or Silver Metal = 6 minutes

Shot glasses using DYEWRAP01 (Will not fit SHOTGLASS04); PowerDriver: Ceramic = 15 minutes - Use Heavy Pressure

TANK22: 16-18 minutes; Note Maximum panel size is 4" wide x 3" high; allow for slight curve of tankard

1) Print the transfer. Note that the typical imaging area is 1.25" in from the handle and .25" from the top and bottom sides of the mug. Beyond that, follow our directions for top to bottom transfers.

2) Trim the transfer to just over the size of the mug.

3) Lightly mist transfer with DyeTrans Pro Spray and let dry 15-20 seconds.

4) Carefully place the transfer on the mug, smooth wrinkles. Wrap the mug with protective plain white paper. Do not allow paper to extend well above or below the top and bottom of mug. This part of the paper may wrinkle and the wrinkles will imprint onto the mug. But DO cover the entire mug with plain paper or you may "caramelize" the coating and it will turn brown or yellow. To imprint closely to handle, use the green pad, wrap loosely at the handle bulge, this will allow more complete imaging.

5) Press with Temp/Time/Pressure settings listed above.

6) Cool ceramic mugs in room temperature water. Do not dunk glass mugs.

7) Remove any paper residue with a soft wet cloth or dish sponge.

Pro Spray is recommended over heat tape.

Tighten dyewrap to finger tight, then give it two more turns.

Place the base of the stein in the oven closest to the heat source.

STEIN16 and STEIN16K seem to work better when the backside of the transfer is lightly

moistened with a wet finger (very lightly).

Be sure to wrap the entire area of the substrate with protective paper, There will be a discoloration of the substrate should the wrap come into contact with it.

Wraps should last for 300 or more impressions. To ensure the proper lifecycle, please closely follow these instructions.

Dye Wrap Notes:

Be sure to wrap the entire area of the substrate with protective paper, There will be a discoloration of the substrate should the wrap come into contact with it.

Wraps should last for 300 or more impressions. To ensure the proper lifecycle, please closely follow these instructions.

Wraps will fail due to improper torque applied to the fastener. You can ensure appropriate torque, time-after-time, through the use of a mechanized nut driver with an adjustable torque clutch. These devices are relatively inexpensive, \$20.00 and up, and easy to use. We recommend the Sears Craftsman 4.8V Pistol cordless screwdriver.

To calibrate the nut driver's torque, simply finger tighten the nut on the wrap, then tighten further, using a maximum of 2 turns, with an ordinary wrench. Adjust the clutch setting on the nut driver to 1 and begin tightening the nut while cycling upward through the torque settings until the nut actually turns. At this point, set the clutch to 1 number less than the current setting and you're finished.

Another necessary step is to employ a double-redundant mug wrap system, at a minimum, and a triple-redundant system, ideally. That is, if mugs are being imaged back-to-back in a production run, then you need a matching quantity of cool mug wraps to swap in for subsequent runs. So, if you're running 72 banks at a time, you will need at least 144 total wraps to do the job. It is easier to do this with a triple-redundant system, as the term "cool" is less subjective than with a double-redundant system. Having three-times the necessary wraps is absolutely the best way to preserve them over time.

When a hot wrap is fastened to a bank it causes the material to irreversibly stretch. As the material expands it puts undo force on the glue bindings, which will eventually come loose. Further, it is a bad idea to subject the image to transient heat before transfer.

Should your wrap come apart at a glue binding, you can resecure it with automotive heat-resistant gasket glue. Beware of the rather lengthy setting time of 1 week for the repair to fully cure.

The fastener will permanently seize if it is not lubricated properly. Lubrication of the threaded shaft is required before you use it for the first time and periodically thereafter. We recommend heat-resistant bearing grease with a colored (usually white, red or green) tracer. The colored tracer provides a visual verification that the grease is still intact.

Clamp or clip on wraps must always have a layer of talcum powder on them to prevent any binding with the surface of the substrate. Properly talcing these wraps also will extend their life.

To retalc a wrap, clean both sides with a soft clean rag and a general purpose cleaner. Be sure to remove any larger portions of debris by hand before cleaning the rubber. After the rubber has dried, apply talcum powder to both sides using a clean dry cloth. Shake off any excess amount of powder. Repeat the process at anytime you notice the wrap is dirty, sticking to the substrate or not providing good transfer results.

If wraps are stored in an environment with other wraps, there always is the chance that the wrap hardware will damage the rubber on these other wraps. The best way to prevent this is to store the wraps rolled up neatly in a box or unrolled flat on a table or shelf.

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PRODUCT INSTRUCTIONS

Stainless Steel Water Bottles

Substrate	Temperature	Prepress	Press Time	Pressure
WB002 and WB003	400°F		4-6 minutes	Medium to Heavy; PSI for Auto Presses: 40-80

Additional Items: Heat Tape, ProSpray, Green Pad

Recommended Paper: DyeTrans Multi-Purpose, ONLY

PowerDriver Setting: White Metal or Silver Metal

Step-by-step:

All instructions are geared to dyewraps or the George Knight Heat Presses, these use the DK3 Mug Press or mug attachment for the DC16 Combo press.

4 Minutes - if you use a Mug Press

6 Minutes - if you use an oven

Green Rubber Pad Needed: HCR-18610

- 1) Remove the cap from the top of the bottle.
- 2) Apply image to be transferred face down onto the bottle. You may use either Pro Spray or heat tape to secure the transfer to the bottle. Just be sure not to let the heat platen or the rubber on the wrap overlay the tape.
- 3) Cover entire imaging area with protective paper.
- 4) Wrap the bottle with rubber or dyewrap. Note that the rubber pad is slightly longer than the imaging area of the bottle. This is so you can easily position the bottle in the press in that you have more area to "pinch" the rubber while positioning it in the press.
- 5) Press

Updated: November 7, 2012

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PRODUCT INSTRUCTIONS

PolySub™ Plastic Mugs

Substrate	Temperature	Prepress	Press Time	Pressure
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PolySub™ Plastic Mugs	375 - 390°F	4-12 minutes	Medium; PSI for Automatic Presses: 40
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Additional Items: Heat Tape, ProSpray

Recommended Paper: DyeTrans Multi-Purpose

PowerDriver Setting: Unisub products

Step-by-step:

All instructions are geared to the George Knight Heat Presses, these use the DK3 Mug Press or mug attachment for the DC16 Combo press.

POLYMUG11 use ATS02 Aluminum Support Tube

POLYMUG15T use ATS03 Aluminum Support Tube

Using a George Knight DK3 Mug Press:

390° Low to Medium Pressure Press for 4 Minutes

Using a Convection or Conventional Oven with Mug Wrap:

375° Medium Pressure Press for 12 Minutes Using DYEWRAP-10

- 1) Print image reversed; Securely tape it to the mug.
- 2) Insert aluminum support tube
- 3) Press; Remove immediately
- 4) Remove tube while mug is still hot
- 5) Dip the mug in cold water to stop the sublimation process.
- 6) Remove the transfer.

The lid for the travel mug may appear loose on the blank substrate. The mug shrinks slightly after sublimation for a correct fit of the lid.

Should an image span the centerline crease in the mug it will create a white line through it.

Mugs should be dipped in water immediately after removal from the press. Be sure to remove the metal insert first. This procedure is necessary to prevent the image from ghosting and yielding a fuzzy imprint.

Updated: April 30, 2012

CONDÉ

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PRODUCT INSTRUCTIONS

DyeTrans® Ceramic Color Changing Morph

Mugs

Substrate	Temperature	Prepress	Press Time	Pressure
DyeTrans® Morph Mugs	375°F		6-15 minutes	Medium

Additional Items: Heat Tape, ProSpray

Recommended Paper: TexPrint

PowerDriver Setting: Ceramic

Step-by-step:

All instructions are geared to the George Knight Heat Presses, these use the DK3 Mug Press or mug attachment for the DC16 Combo press.

6 Minutes in a press

(Requires a Mug Press That Steadily Holds the Temperature At 375° F)

15 Minutes in an oven using DYEWRAP-10

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- 2) Lightly mist transfer with DyeTrans Pro Spray.
- 3) Place the transfer on the Morph Mug, smooth wrinkles.
- 4) Wrap the Morph Mug with protective paper. Be sure to wrap protective paper all the way to the handle, as contact with the edge of the press head will cause the coating to scratch off.
- 5) Press with Temp/Time/Pressure settings listed above.
- 6) Cool mug in room temperature water. Remove transfer after mug has cooled.
- 7) Remove any paper residue with a soft wet cloth or sponge.

The key to achieving success with Morph Mugs is pressure. Too much pressure alters the morph effect; not enough may produce a washed-out transfer.

The image for any of the mugs needs to be about .25" from the top and bottom of the mug and 1.25" from the handle.

You always will be able to see the image dimly on the darkened morph mug. It will reveal the image brightly as the mug is filled with hot liquid and turns white.

Updated: April 30, 2012

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PRODUCT INSTRUCTIONS

Ceramic Steins, Glass Steins

Substrate	Temperature	Prepress	Press Time	Pressure
Ceramic Steins and Glass Steins	400 - 425°F		8-15 minutes	Medium; PSI for Automatic Presses: 40

Additional Items: Heat Tape, ProSpray

Recommended Paper: DyeTrans Multi-Purpose

PowerDriver Setting: Ceramic Mug use Unisub Products

Step-by-step:

All instructions are geared to the George Knight Heat Presses, these use the DK3 Mug Press or mug attachment for the DC16 Combo press.

All Steins: Careful not to use too much pressure, it can wrinkle your transfer, use a protective cover sheet but do not reuse that sheet, it will have ink on it after one use.

16oz. Ceramic Stein Without Gold Rim (pn: STEIN) Use PowerDriver: Ceramic.....400°.....8 Minutes with mug press -- 12 Minutes in oven using DYEWRAP-10

16oz. Ceramic Stein Without Gold Rim (pn: STEIN16/K) Not suitable for use in a heat press STEIN16 and STEIN16K = 15 - 17 minutes (time will vary by oven used and type of image)in oven using DYEWRAP-10

28oz. Ceramic Stein With Gold Rim (pn: STEIN28G) Use PowerDriver: Ceramic.....425°.....Not suitable for use in a heat press --- 15 Minutes in oven using DYEWRAP03

NOTE: STEIN28G is not suitable for top to bottom imaging.

STEIN01 PowerDriver: Unisub Products.....400°.....8-10 Minutes Press (Not suitable for oven imaging. Must use a mug press)

Other Glass Steins Use PowerDriver: Unisub Products.....400°.....8 Minutes Press -- 13 Minutes in an oven using DYEWRAP-10

Coin Banks, Ceramic mugs and steins (all except Funnel Mugs, includes STEIN22WT-CH) Using DYEWRAP-10; PowerDriver: Ceramic = 15 minutes

- 1) Print the transfer.
- 2) Trim the transfer to just under the size of the mug.
- 3) Lightly mist transfer with DyeTrans Pro Spray.
- 4) Place the transfer on the mug, smooth wrinkles.
- 5) Wrap the mug with protective paper. Portions of the mug that come into direct contact with the rubber heat platen will yellow.
- 6) Press.
- 7) Remove the transfer, then allow the substrate to cool. It is recommended you accelerate the cooling process on all but the glass steins by submersing ceramic mugs in room temperature water for about 3 minutes. DO NOT DIP GLASS MUGS or STEINS IN WATER.
- 8) Remove any paper residue with a soft wet cloth or dish sponge.

Your image for any of the mugs needs to be about .25" from the top and bottom of the mug and 1.25" from the handle

Updated: May 2, 2013

CONDÉ

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PRODUCT INSTRUCTIONS

Stainless Steel Travel Mug Sublimation Instructions with a Press

Substrate	Temperature	Prepress	Press Time	Pressure
MUG14SS, MUG18SS, MUG22SS, MUG25SS	400°F		1-2.5 minutes	Light to Medium

Additional Items: Heat Tape

Recommended Paper: DyeTrans Multi-Purpose or TexPrint

PowerDriver Setting: Silver or White Metal

Step-by-step:

Note: The imprintable area on these mugs tends to vary by a slight amount, so be sure to confirm measurements when you line up your artwork.

Requires a Mug Press That Steadily Holds the Temperature At 400° F

All instructions are geared to the George Knight Heat Presses, these use the DK3 Mug Press or mug attachment for the DC16 Combo

Note: The area of the travel mug beyond the white patch is sublimatable, so any bleed beyond this area will transfer onto the mug.

All white mugs, with white patch or all clear - MUG14SS, MUG22SS, MUG25SS - 400° 1 Minute Medium

MUG18SS - Mug with with removable plastic Interior* 400° 2.5 Minutes in a press Light

*Note: Be careful not to press so hard that the mug becomes deformed when the press is closed.

*Note: ATS01 aluminum support tube is no longer used with this travel mug.

Notes For Mugs With A Plastic Insert:

- 1) Remove plastic insert prior to pressing.
- 2) Plastic insert is dishwasher safe.
- 4) Stainless steel shell may be submersed in water to accelerate cooling.

Notes For Mugs Without A Plastic Insert:

a) Not dishwasher safe – hand wash only. Allow water to fully drain from the hole in the bottom of the mug prior to storing or using the product. Shipped with the lids attached. Should a lid not fit after imprinting then the mug press pressure was too high.

b) Also, if lids become separated from the original mug to which they were attached, you may find them not to fit. Should this occur, try other lids until you find the proper mate. Heavy pressure will cause damage to the mug's handle anchor points allowing water to seep into the air-insulating cavity via cracks in these areas. This problem also can occur if the product has been washed in a dishwasher. A hole has been drilled into the bottom of the mug to allow the water to drain. However, even under the best of circumstances, water may still find its way through the handle anchor points or the hole in the bottom of the mug.

c) Perform heat press imaging only. Placing a mug into an oven will cause the plastic pieces to melt.

d) Allow the mug to cool in open air -- do not “dunk” them in water. You can accelerate the cooling process through the use of a fan blowing across the surface of the mug or by laying them down on a Cool Plate.

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PRODUCT INSTRUCTIONS

Aluminum Water Bottle Sublimation Instructions

Substrate	Temperature	Prepress	Press Time	Pressure
WB600W-CH and WB600S-CH	400°F		3.5 Minutes	Light; PSI: 20

Additional Items: Heat Tape, Green Pad

Recommended Paper: DyeTrans or TexPrint

PowerDriver Setting: Silver Metal or White Metal

Step-by-step:

1) Remove lid-attached plastics will melt during imprinting.

2) Pro Spray or heat tape transfer to bottle.

3) Put heat conductive rubber (HCR-18610*) around transfer and bottle, making sure transfer is not misplaced.

4) Press.(Do not use too much pressure, bottle can dent).

* HCR-18610 is actually longer than the bottle, this is so you can grab the rubber when putting it into the press.

Updated: October 19, 2011

CONDÉ

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PRODUCT INSTRUCTIONS

Notes on DyeWraps

Substrate	Temperature	Prepress	Press Time	Pressure
DYEW RAP01, DYEW RAP-10, DYEW RAP02, DYEW RAP03, DYEW RAP-68, DYEW RAP04, DYEW RAP05, DYEW RAP06, DYEW RAP-173, DYEW RAP07	385° - 400°F	.	.	Light

Additional Items:

Recommended Paper: .

PowerDriver Setting: .

Step-by-step:

Notes on DyeWraps

Be sure to wrap the entire area of the substrate with protective paper, There will be a discoloration of the substrate should the wrap come into contact with it.

Wraps should last for 300 or more impressions. To ensure the proper lifecycle, please closely follow these instructions.

Wraps will fail due to improper torque applied to the fastener. You can ensure appropriate torque, time-after-time, through the use of a mechanized nut driver with an adjustable torque clutch. These devices are relatively inexpensive, \$20.00 and up, and easy to use. We recommend the Sears Craftsman 4.8V Pistol cordless screwdriver.

To calibrate the nut driver's torque, simply finger tighten the nut on the wrap, then tighten further, using a maximum of 2 turns, with an ordinary wrench. Adjust the clutch setting on the nut driver to 1 and begin tightening the nut while cycling upward through the torque settings until the nut actually turns. At this point, set the clutch to 1 number less than the current setting and you're finished.

Another necessary step is to employ a double-redundant mug wrap system, at a minimum, and a triple-redundant system, ideally. That is, if mugs are being imaged back-to-back in a production run, then you need a matching quantity of cool mug wraps to swap in for subsequent runs. So, if you're running 72 banks at a time, you will need at least 144 total wraps to do the job. It is easier to do this with a triple-redundant system, as the term "cool" is less subjective than with a double-redundant system. Having three-times the necessary wraps is absolutely the best way to preserve them over time.

When a hot wrap is fastened to a bank it causes the material to irreversibly stretch. As the material expands it puts undo force on the glue bindings, which will eventually come loose. Further, it is a bad idea to subject the image to transient heat before transfer.

Should your wrap come apart at a glue binding, you can resecure it with automotive heat-resistant gasket glue. Beware of the rather lengthy setting time of 1 week for the repair to fully cure.

The fastener will permanently seize if it is not lubricated properly. Lubrication of the threaded shaft is required before you use it for the first time and periodically thereafter. We recommend heat-resistant bearing grease with a colored (usually white, red or green) tracer. The colored tracer provides a visual verification that the grease is still intact.

Clamp or clip on wraps must always have a layer of talcum powder on them to prevent any binding with the surface of the substrate. Properly talcing these wraps also will extend their life.

To retalc a wrap, clean both sides with a soft clean rag and a general purpose cleaner. Be sure to remove any larger portions of debris by hand before cleaning the rubber. After the rubber has dried, apply talcum powder to both sides using a clean dry cloth. Shake off any excess amount of powder. Repeat the process at anytime you notice the wrap is dirty, sticking to the substrate or not providing good transfer results.

If wraps are stored in an environment with other wraps, there always is the chance that the wrap hardware will damage the rubber on these other wraps. The best way to prevent this is to store the wraps rolled up neatly in a box or unrolled flat on a table or shelf.

Updated: December 6, 2012

CONDÉ

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PRODUCT INSTRUCTIONS

Notes on DyeWraps

Substrate	Temperature	Prepress	Press Time	Pressure
DYEWRAPO1, DYEWRAPO10, DYEWRAPO2, DYEWRAPO3, DYEWRAPO68, DYEWRAPO4, DYEWRAPO5, DYEWRAPO6, DYEWRAPO173, DYEWRAPO7	385° - 400°F		see each item	Light

Additional Items:

Recommended Paper: DyeTrans Multi-Purpose, TexPrint-R

PowerDriver Setting: N/A

Step-by-step:

Notes on DyeWraps

Be sure to wrap the entire area of the substrate with protective paper, There will be a discoloration of the substrate should the wrap come into contact with it.

Wraps should last for 300 or more impressions. To ensure the proper lifecycle, please closely follow these instructions.

Wraps will fail due to improper torque applied to the fastener. You can ensure appropriate torque, time-after-time, through the use of a mechanized nut driver with an adjustable torque clutch. These devices are relatively inexpensive, \$20.00 and up, and easy to use. We recommend the Sears Craftsman 4.8V Pistol cordless screwdriver.

To calibrate the nut driver's torque, simply finger tighten the nut on the wrap, then tighten further, using a maximum of 2 turns, with an ordinary wrench. Adjust the clutch setting on the nut driver to 1 and begin tightening the nut while cycling upward through the torque settings until the nut actually turns. At this point, set the clutch to 1 number less than the current setting and you're finished.

Another necessary step is to employ a double-redundant mug wrap system, at a minimum, and a triple-redundant system, ideally. That is, if mugs are being imaged back-to-back in a production run, then you need a matching quantity of cool mug wraps to swap in for subsequent runs. So, if you're running 72 banks at a time, you will need at least 144 total wraps to do the job. It is easier to do this with a triple-redundant system, as the term "cool" is less subjective than with a double-redundant system. Having three-times the necessary wraps is absolutely the best way to preserve them over time.

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The fastener will permanently seize if it is not lubricated properly. Lubrication of the threaded shaft is required before you use it for the first time and periodically thereafter. We recommend heat-resistant bearing grease with a colored (usually white, red or green) tracer. The colored tracer provides a visual verification that the grease is still intact.

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remove any larger portions of debris by hand before cleaning the rubber. After the rubber has dried, apply talcum powder to both sides using a clean dry cloth. Shake off any excess amount of powder. Repeat the process at anytime you notice the wrap is dirty, sticking to the substrate or not providing good transfer results.

If wraps are stored in an environment with other wraps, there always is the chance that the wrap hardware will damage the rubber on these other wraps. The best way to prevent this is to store the wraps rolled up neatly in a box or unrolled flat on a table or shelf.

Updated: August 22, 2013

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PRODUCT INSTRUCTIONS

Notes on DyeWraps

Substrate	Temperature	Prepress	Press Time	Pressure
DYEW RAP01, DYEW RAP-10, DYEW RAP02, DYEW RAP03, DYEW RAP-68, DYEW RAP04, DYEW RAP05, DYEW RAP06, DYEW RAP-173, DYEW RAP07	385° - 400°F		See each item	Light

Additional Items: ProSpray
Recommended Paper: DyeTrans Multi-Purpose, TexPrint-R
PowerDriver Setting:

Step-by-step:

Notes on DyeWraps
Be sure to wrap the entire area of the substrate with protective paper, There will be a discoloration of the substrate should the wrap come into contact with it.

Wraps should last for 300 or more impressions. To ensure the proper lifecycle, please closely follow these instructions.

Wraps will fail due to improper torque applied to the fastener. You can ensure appropriate torque, time-after-time, through the use of a mechanized nut driver with an adjustable torque clutch. These devices are relatively inexpensive, \$20.00 and up, and easy to use. We recommend the Sears Craftsman 4.8V Pistol cordless screwdriver.

To calibrate the nut driver's torque, simply finger tighten the nut on the wrap, then tighten further, using a maximum of 2 turns, with an ordinary wrench. Adjust the clutch setting on the nut driver to 1 and begin tightening the nut while cycling upward through the torque settings until the nut actually turns. At this point, set the clutch to 1 number less than the current setting and you're finished.

Another necessary step is to employ a double-redundant mug wrap system, at a minimum, and a triple-redundant system, ideally. That is, if mugs are being imaged back-to-back in a production run, then you need a matching quantity of cool mug wraps to swap in for subsequent runs. So, if you're running 72 banks at a time, you will need at least 144 total wraps to do the job. It is easier to do this with a triple-redundant system, as the term "cool" is less subjective than with a double-redundant system. Having three-times the necessary wraps is absolutely the best way to preserve them over time.

When a hot wrap is fastened to a bank it causes the material to irreversibly stretch. As the material expands it puts undo force on the glue bindings, which will eventually come loose. Further, it is a bad idea to subject the image to transient heat before transfer.

Should your wrap come apart at a glue binding, you can resecure it with automotive heat-resistant gasket glue. Beware of the rather lengthy setting time of 1 week for the repair to fully cure.

The fastener will permanently seize if it is not lubricated properly. Lubrication of the threaded shaft is required before you use it for the first time and periodically thereafter. We recommend heat-resistant bearing grease with a colored (usually white, red or green) tracer. The colored tracer provides a visual verification that the grease is still intact.

Clamp or clip on wraps must always have a layer of talcum powder on them to prevent any binding with the surface of the substrate. Properly talcing these wraps also will extend their life.

To retalc a wrap, clean both sides with a soft clean rag and a general purpose cleaner. Be sure to remove any larger portions of debris by hand before cleaning the rubber. After the rubber has dried, apply talcum powder to both sides using a clean dry cloth. Shake off any excess amount of powder. Repeat the process at anytime you notice the wrap is dirty, sticking to the substrate or not providing good transfer results.

If wraps are stored in an environment with other wraps, there always is the chance that the wrap hardware will damage the rubber on these other wraps. The best way to prevent this is to store the wraps rolled up neatly in a box or unrolled flat on a table or shelf.

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