



heat transfer presses • custom machinery

52 Perkins Street Brockton, MA. 02303-0766

WWW - <http://www.heatpress.com> Email - info@heatpress.com
(508) 588-0186 Fax (508) 587-5108

DK3 Mug Printing Tips

1. Do not overlap Transfer Paper or Cover Sheet past Top & Bottom Mug edges

Due to the non-straight nature of the shape of most mugs, it is common for the transfer paper to wrinkle as it nears the top & especially bottom rim of the mug. This can result in white lines and undesirable results towards the edges of the mug. This “unprinted white wrinkle line” is the most common defect in printing results. The more paper overlaps and hangs past the rim of the mug, the more likely this problem is to occur. Cut down the size of the transfer paper after printing so that the paper is well within the flat surface of the mug. Keep the edge of the transfer paper about 1/8” to 3/16” from the top edge of the mug and about 1/4” to 3/8” away from the bottom edge of the mug. This will prevent severe surface distortion of the paper, trying to conform and therefore wrinkle along a spherical inward curved surface versus the normal cylindrical surface of the mug elsewhere. Also – only use two small pieces of heat tape on each side of the mug handle to keep the transfer tightly in place.

2. For more difficult wrinkle & mug-shape issues, slightly mist/dampen the rims of transfer paper.

To further reduce paper wrinkling, and to print more aggressive “full bleed” images closer to the edge of the mug, slightly dampening the outside surface of the paper will help the paper conform to the mug. This “Paper Mache” method helps the paper Cast or Mold itself around the mug surface better. When dry, the paper is more rigid and prone to wrinkle when travelling around spherical surfaces. When dampened, the paper will Melt around the surface better. The water is long since dispersed before the transfer process begins, and the sublimation inks will not be affected. A spray bottle / mist-bottle or just swiping a few damp fingers around the edges quickly is all that’s necessary. No dunking, no long time consuming process. Just a quick dampening of the edges immediately before inserting the mug into the press.

3. Try the ProSpray method with transfer dampening instead of heat tape for full bleed printing.

For aggressive printing closer to the edges of the mug, try ProSpray. ProSpray is a heat transfer tackified mist that allows the user to apply the transfer paper to the mug without heat tape. It also helps “stick” the paper to the mug surface in problem areas. Follow suggestions and instructions for this method from the supplier of the heat transfer ProSpray product.

4. Printing 22oz German Beer Steins with braids

The large steins with the wide flanged bottom and roped braid at the top can be printed on the DK3. The temperature should be set for 400-F, and the time is about 8 to 10 minutes. This is due to the large density of the mass of this large item, especially at the base of the mug. Insert the mug into the press with the base facing right (toward the control box) and the top of the mug facing to the left. The entire bottom flanged section must of course hang out of the right side. The bottom braid must also hang out of the right side of the press. The top braid will not hang out of the left side of the press. The top braid will be at the far left side of the heater band, but will be pressed. This is OK. Set the pressure to a good Firm clamping so that the top braid sinks fully into the far left side of the heater band and the printing area of the mug is contacting fully with the green pad. Only heat tape the transfer on each side of the handle to keep the transfer tightly in place. The 22oz Steins are not flat, and therefore the dampening technique should be used along with very long printing times.