

## MULTI-TRANS FOR MUGS

## 1-PAPER-SYSTEM



### PRINT SETTINGS FOR OKI WHITE TONER PRINTERS

- **Paper & Print:** Transparency, Multi-Purpose Tray
- **White Toner Density:** +3  
(Calibration at the printer panel)
- **Image Mode:** mirror image



### PRINT SETTINGS FOR OKI Pro8432WT

- **Paper & Print:** User Type 1, Multi-Purpose Tray
- **White Toner Density:** +3  
(Calibration at the printer panel)
- **Color Paper Settings:** +2  
(Set at the printer panel)



### PRINT SETTINGS FOR CMYK PRINTERS

Only for light colored mugs

- **Paper & Print:** Transparency (Film/Foil) or similar



### TRANSFER PROCESS

- Preheat your mug press before use.
- Position & fix the printed image to the mug using a heat resistant tape.
- Put the mug in the press.
- Press by using the settings below.
- **IMPORTANT: The timer of the mug press should not start until the mug has reached the set temperature.**  
If your press does not do this automatically, increase the press time to 4 minutes!
- Cool the mug down by dipping into cold water.  
Make sure the transfer media is soft before peeling.
- **ATTENTION:** At this point, the mug is very hot. Take precautions when moving the mug.



### SETTINGS MUG PRESS

MUG	MUG PRESS
WHITE & COLORED MUGS	140°C / 284°F • 180 sec • <b>high pressure</b>



### TIPS & TRICKS

- The light marks that may appear after the application process, can be easily removed with Isopropanol.
- Using the Mug Press Silicone Pad helps distribute the heat evenly around the whole mug & transfer. The pressing parameters can vary by using a silicone pad.
- If you put the mug in the oven at 160°C / 320°F for 15 minutes the scratch resistance will be better.

Before starting a **mass production**, we recommend to make **transfer and washing test** with all materials.

## MULTI-TRANS FOR HARD SURFACES



### PRINT SETTINGS FOR OKI WHITE TONER PRINTERS:

- **Paper & Print:** Transparency, Multi-Purpose Tray
- **White Toner Density:** +3  
(Calibration at the printer panel)
- **Image Mode:** mirror image



### PRINT SETTINGS FOR OKI Pro8432WT:

- **Paper & Print:** User Type 1, Multi-Purpose Tray
- **White Toner Density:** +3  
(Calibration at the printer panel)
- **Color Paper Settings:** +2  
(Set at the printer panel)



### PRINT SETTINGS FOR CMYK PRINTERS:

Only for light colored mugs

- **Paper & Print:** Transparency (Film/Foil) or similar



### TRANSFER PROCESS

- Set the temperature of the transfer press to 200°C / 390°F.
- Place the substrate on the lower plate.
- Place the transfer paper on the substrate and cover both with the a silicone pad with 5mm thickness.
- Place the sensor of the digital thermometer between the transfer paper and the substrate.  
(Relevant is the temperature on the surface of the substrate which is shown through the digital thermometer.  
The printing time depends on the size (mass) of the substrate.)
- Open the transfer press when the below mentioned temperature is achieved and peel off the transfer paper as indicated below.
- **ATTENTION:** At this point, the material is very hot. Take precautions when moving it.



### SETTINGS HEAT PRESS

SURFACE	AUTOMATIC HEAT PRESS	PREHEATING	OPENING AT	PEELING	FIXING
ALUMINIUM	4-5 bar (55-70 PSI)		120°C (250°F)	Warm or cold	60 sec.
ADHESIVE FILM	4-5 bar (55-70 PSI)		130°C (265°F)	Let cool down for 5-10 sec.	
CHROMOLUX BINDER	3-4 bar (40-60 PSI)	10 seconds	100-110°C (210-230°F)	Warm or cold	
CERAMIC TILE	4-5 bar (55-70 PSI)		130°C (265°F)	Warm or cold	60 sec.
WOOD	3 bar (40 PSI)	20 seconds	130°C (266°F)	Immediately	60 sec.
MAGNETIC VINYL	4-5 bar (55-70 PSI)		110-120°C (230-250°F)	Warm or cold	60 sec.
ACRYLIC GLASS	4-5 bar (55-70 PSI)		100-105°C (210-220°F)	Let cool down for 5-10 sec.	
MIRROR	4-5 bar (55-70 PSI)		145°C (265°F)	Warm or cold	
MOUSE PAD	4-5 bar (55-70 PSI)		110°C (230°F)	Warm or cold	

Before starting a mass production, we recommend to make transfer and washing test with all materials.