

# HARD SURFACE PAPERS INSTRUCTION GUIDE

• CL Hard Surface I | CL Hard Surface II | CL Crystal •

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## PAROPY CL HARD SURFACE I

### OVERVIEW

#### DESCRIPTION

Paropy CL Hard Surface I is for imaging to hard substrates with a smooth surface in full color using a laser printer or copier and heat press.

Print Mirror imaged and heat apply.

This paper is a self trimming, toner release only, leaving only the image you print. Using our instructions, most imaged substrates will have scratch resistance protection.

Due to the varying instructions for the different substrates that this paper can apply to, please refer to the detailed instructions for the specific substrate you plan to image onto.

#### Recommended Materials

White or Light Colored  
Metal  
Plastic  
Unisub Metals  
Coated Wood (Lacquered)  
Ceramic Tiles  
Ceramic Mugs  
Some types of Cardboard

#### Accessories Required

Computer, Color Laser Printer,  
Heat Press. Foam Heat Pad, Felt pad  
(optional)

#### Printable side

The printable side (white glossy coated side) It is also the adhesive side

#### Pressure Settings

Heavy Pressure is required for the image to completely adhere to the hard substrate.

#### Image Design

This paper works best with a full bleed image. When designing your image, ensure that you bleed your image at least 0.5 inches more than the substrate.

#### Peeling

Depending on the substrate you are imaging, the peel could be cool or hot. Please read instructions for substrate carefully.

#### Care Instructions

After imaging, do not put in direct sunlight. Store at room temperature.

#### Storage

CL Hard Surface I has an indefinite shelf life when stored at room temperature. Keep away from direct heat, sunlight and humidity.



## PAROPY CL HARD SURFACE II

### OVERVIEW

#### DESCRIPTION

Paropy CL Hard Surface II is for imaging to hard substrates with a porous surface in full color using a laser printer or copier and heat press.

Print Mirror imaged and heat apply.

The paper will leave a thin transparent microfilm around all areas of the surface which helps to protect the surface from scratches. The original texture of the surface will be maintained when imaged. Ideal for awards and trophy applications!

Due to the varying instructions for the different substrates that this paper can apply to, please refer to the detailed instructions for the specific substrate you plan to image onto.

#### Recommended Materials

Light Colored  
Wood, Leather  
Glass, Crystal, Acrylic  
Lacquer finished wood is not recommended

#### Accessories Required

Computer, Color Laser Printer, Heat Press. Foam Heat Pad

#### Printable side

The printable side (white glossy coated side) It is also the adhesive side

#### Pressure Settings

Using high pressure will allow the texture of the substrate to show through more. However this is not recommended for Glass, Crystal, or Acrylic.

#### Picking Substrates

When picking substrates, ensure that there is minimal warping when heat is applied. After pressing, we recommend to put a heavy heat resistant paper weight on all areas of the substrate to prevent warping.

#### Image Design

This paper works best with a full bleed image. When designing your image, ensure that you bleed your image at least 0.5 inches more than the substrate.

#### Peeling

It is recommended to peel the back off cold. This will prevent any excess film from sticking onto the surface.

#### Care Instructions

After imaging, do not put in direct sunlight. Store at room temperature.

#### Storage

CL Hard Surface II has an indefinite shelf life when stored at room temperature. Keep away from direct heat, sunlight and humidity.



## PAROPY CL CRYSTAL

### OVERVIEW

#### DESCRIPTION

Paropy CL Crystal is for imaging crystal, glass, and acrylic in full color using a laser printer or copier and heat press.

Due to the specially formulated coating that has been applied to the paper, it will allow the paper to stick onto the glass, crystal, acrylic substrate with ease. The printable side is also the adhesive side. Images produced will look exactly the same as it came out of the printer, because the paper is essentially attached to the substrate.

Due to the varying instructions for the different substrates that this paper can apply to, please refer to the detailed instructions for the specific substrate you plan to image onto.

#### Recommended Materials

Transparent or Tempered  
Crystal  
Glass  
Acrylic

#### Accessories Required

Computer, Color Laser Printer,  
Heat Press. Foam Heat Pad

#### Printable side

The printable side (white matte coated side) It is also the adhesive side

#### Pressure Settings

This paper does not need a high pressure for the paper to stick onto the glass. Light pressure will be enough.

#### Picking Substrates

When picking substrates, ensure that there is minimal warping when heat is applied. After pressing, we recommend to put a heavy heat resistant paper weight on all areas of the substrate to prevent warping.

#### Image Design

This paper works best with a full bleed image. When designing your image, ensure that you bleed your image at least 0.5 inches more than the substrate so that it is easier to cut the excess paper off after.

#### Peeling

No peeling is required. The paper will stick to the substrate. When the glass cools, Trim excess paper from around the object.

#### Care Instructions

After imaging, do not put in direct sunlight. Store at room temperature.

#### Storage

CL Crystal has an indefinite shelf life when stored at room temperature. Keep away from direct heat, sunlight and humidity.



## ACRYLIC

### INSTRUCTIONS

#### CL Crystal

Paper Mode: Heavy to Label 1  
Print Mode: Right Reading  
Temperature: 320F  
Time: 45 sec  
Trim: Cool  
Pressure: Light

#### CL Hard Surface I

Paper Mode: Color to Label 1  
Print mode Mirror Image  
Temperature: 300F  
Time: 60 seconds  
Peel: Cool  
Pressure: Heavy

#### CL Hard Surface II

Paper Mode: Heavy to Label 1  
Print Mode: Mirror Image  
Temperature: 300F  
Time: 50 seconds  
Peel: Cool  
Pressure: Heavy

CL Hard Surface I: For OKI 6100  
& 6150 print in Glossy mode

#### Acrylic

Any white or light colored acrylic

#### Materials Required:

Heat Press, Laser Printer, Felt Heat Pad, Acrylic substrate

#### CL Crystal

- 1.) Insert into bypass tray and print right reading
- 2.) Print image in heavy to label 1 mode, right reading.
- 3.) Place substrate with backside face up
- 4.) Place imaged paper with image side face down
- 5.) Place foam pad on top
- 6.) Press at 320F for 45 seconds
- 7.) Wait for substrate to cool and trim excess paper around object

Note: Use extremely light pressure when using CL Crystal. Excessive pressure will result in an unclear image.

#### CL Hard Surface I

- 1.) Insert into bypass tray and print mirror imaged.
- 2.) Print image in color to label 1 mode, mirror image
- 3.) Place substrate with image side face up
- 4.) Place imaged paper with image face down
- 5.) Place foam pad on top
- 6.) Press at 300F for 60 seconds.
- 7.) Wait for substrate to cool and peel backing off cool.

#### CL Hard Surface II

- 1.) Insert into bypass tray and print mirror imaged.
- 2.) Print image in heavy to label 1 mode, mirror image
- 3.) Place substrate with image side face up
- 4.) Place imaged paper with image face down
- 5.) Place foam pad on top
- 6.) Press at 300F for 60 seconds.
- 7.) Wait for substrate to cool and peel backing off cool.

## CARDBOARD PUZZLES

### INSTRUCTIONS

#### CL Hard Surface 1

Paper Mode: Heavy to Label 1

Print Mode: Right Reading

Temperature: 300F

Time: 60 sec

Peel: Hot

Pressure: Heavy

CL Hard Surface II

Not Applicable

CL Crystal

Not Applicable

CL Hard Surface I: For OKI 6100  
& 6150 print in Glossy mode

#### Cardboard Puzzles

Any white or light colored cardboard puzzle.

#### Materials Required:

Heat Press, Laser Printer, Foam Heat Pad, Cardboard Puzzle

#### CL Hard Surface I:

- 1.) Insert into bypass tray and print mirror imaged.
- 2.) Print image in Color to Label 1 mode depending on your printer
- 3.) Place substrate with image side face up
- 4.) Place imaged paper with image face down onto substrate
- 5.) Place foam heat pad on top of substrate
- 6.) Press at 300F for 60 seconds. Use Heavy Pressure. Peel hot.

## CERAMIC MUGS

### INSTRUCTIONS

#### CL Hard Surface I

##### *11oz Mugs*

Paper Mode: Color to Label 1

Print Mode: Mirror Image

Temperature: 360F

Time: 150 sec

Peel: Cool

Pressure: Heavy

##### *15oz Mugs*

Paper Mode: Color to Label 1

Print Mode: Mirror Image

Temperature: 360F

Time: 175 sec

Peel: Cool

Pressure: Heavy

##### *Curing Step*

Glazing Unit

Level: 5

Curing Time: 60-85 sec

Oven

Temperature: 350F

Time: 8-10 mins

CL Hard Surface I: For OKI 6100  
& 6150 print in Glossy mode

#### Coated Ceramic Mugs

##### Mug Press without idle time

Any white or light colored coated ceramic mugs

##### Materials Required:

Mug Press, Laser Printer, Foam Heat Pad, Coated Ceramic Mug, Curing Unit

##### CL Hard Surface I:

- 1.) Insert into bypass tray and print mirror imaged.
- 2.) Print image in Color to Label 1 mode depending on your printer
- 3.) Wrap imaged paper with image facing the mug
- 4.) Secure the imaged paper onto mug with heat tape
- 5.) Wrap foam pad around mug and place into mug press.
- 6.) Adjust pressure accordingly. Ensure pressure is heavy
- 7a.) For 11oz mugs, close mug press and press at 360F for 150 sec
- 7b.) For 15oz mugs, close mug press and press at 360F for 175 sec.
- 8.) Let Mug cool and dunk into cold water. Then peel paper off.

Note: Not enough pressure will result in incomplete image transfer

**Curing** - This step is required for the mug to become scratch resistant

##### Option 1: Glazing Unit

- 1.) Ensure the mug is at room temperature
- 2.) Place mug on curing unit.
- 3.) Set curing level to 5
- 4a.) For 11oz mug, cure for 60 seconds
- 4b.) For 15oz mug, cure for 75-85 seconds

##### Option 2: Oven

- 1.) Ensure the mug is at room temperature
- 2.) Place mug on in oven.
- 3.) Set temperature to 350F
- 4a.) For 11oz mug, cure for 8-10 mins
- 4b.) For 15oz mug, cure for 8-10 mins

## CERAMIC MUGS

### INSTRUCTIONS

#### CL Hard Surface I

##### *11oz Mugs*

Paper Mode: Color to Label 1

Print Mode: Mirror Image

Idle Temp: 300F

Press Temp:: 360F

Time: 100 sec

Peel: Cool

Pressure: Heavy

##### *15oz Mugs*

Paper Mode: Color to Label 1

Print Mode: Mirror Image

Temperature: 360F

Time: 125 sec

Peel: Cool

Pressure: Heavy

##### *Curing Step*

Glazing Unit

Level: 5

Curing Time: 60-85 sec

##### Oven

Temperature: 350F

Time: 8-10 mins

CL Hard Surface I: For OKI 6100  
& 6150 print in Glossy mode

#### Coated Ceramic Mugs

##### Mug Press with idle time

Any white or light colored coated ceramic mugs

##### Materials Required:

Mug Press, Laser Printer, Foam Heat Pad, Coated Ceramic Mug

##### CL Hard Surface I:

- 1.) Insert into bypass tray and print mirror imaged.
- 2.) Print image in Color to Label 1 mode depending on your printer
- 3.) Set Mug Press Idle temperature at 300F
- 3.) Wrap imaged paper with image facing the mug
- 4.) Secure the imaged paper onto mug with heat tape
- 5.) Wrap foam pad around mug and place into mug press.
- 6.) Adjust pressure accordingly. Ensure pressure is heavy
- 7.) Ensure that the mug press is at idle temperature 300F
- 8a.) For 11oz mugs, close mug press and press at 360F for 100 seconds
- 8b.) For 15oz mugs, close mug press and press at 360F for 125 seconds
- 9.) Let Mug cool and dunk into cold water. Then peel paper off.

Note: Not enough pressure will result in incomplete image transfer

**Curing** - This step is required for the mug to become scratch resistant

##### Option 1: Glazing Unit

- 1.) Ensure the mug is at room temperature
- 2.) Place mug on curing unit.
- 3.) Set curing level to 5
- 4a.) For 11oz mug, cure for 60 seconds
- 4b.) For 15oz mug, cure for 75-85 seconds

##### Option 2: Oven

- 1.) Ensure the mug is at room temperature
- 2.) Place mug on in oven.
- 3.) Set temperature to 350F
- 4a.) For 11oz mug, cure for 8-10 mins
- 4b.) For 15oz mug, cure for 8-10 mins



## CERAMIC TILES

### INSTRUCTIONS

#### CL Hard Surface I

Paper Mode: Color to Label 1

Print Mode: Mirror Image

Temperature: 330F

Time: 300 sec

Peel: Cool

Pressure: Heavy

CL Hard Surface II

Not Applicable

CL Crystal

Not Applicable

#### Ceramic Tiles Full Bleed Image

Any white or light colored uncoated or coated Ceramic Tiles. These instructions are meant for a full bleed image.

##### Materials Required:

Heat Press, Laser Printer, Felt Heat Pad, Foam Heat Pad, Ceramic Tile

##### CL Hard Surface I:

- 1.) Insert into bypass tray and print mirror imaged.
- 2.) Print image in Color to Label 1 mode depending on your printer
- 3.) Place felt pad onto heat press
- 4.) Place imaged paper with image face up onto felt pad
- 5.) Place substrate on top of paper with image side face down
- 6.) Place Foam Heat Pad on top of substrate to protect heat press
- 7.) Press at 330F for 300 seconds. Use heavy pressure and peel cool.

Note: You can secure the paper and substrate with heat tape  
Note: Too much pressure and you will crack the tile, not enough pressure will cause beveled areas not to image completely

#### CL Hard Surface I

Paper Mode: Color to Label 1

Print Mode: Mirror Image

Temperature: 330F

Time: 180 sec

Peel: Cool

Pressure: Heavy

CL Hard Surface II

Not Applicable

CL Crystal

Not Applicable

#### Ceramic Tiles Non Full Bleed Image

Any white or light colored uncoated or coated Ceramic Tiles. These instructions have a shorter press time for non full bleed images only.

##### Materials Required:

Heat Press, Laser Printer, Foam Heat Pad, Ceramic Tile

##### CL Hard Surface I:

- 1.) Insert into bypass tray and print mirror imaged.
- 2.) Print image in Color to Label 1 mode depending on your printer
- 3.) Place substrate with image side face up
- 4.) Place imaged paper with image face down
- 5.) Place foam pad on top
- 6.) Press at 330F for 180 seconds using heavy pressure
- 7.) Wait for substrate to completely cool before peeling paper off.

Note: This instructions set is for images that do not bleed over to the side. The shorter time will allow for faster production of tiles that do not have full bleed images.

## CRYSTAL/GLASS

### INSTRUCTIONS

#### CL Crystal

Paper Mode: Heavy to Label 1

Print Mode: Right Reading

Temperature: 320F

Time: 45-60 sec

Trim: Cool

Pressure: Light

#### CL Hard Surface I

Paper Mode: Color to Label 1

Print Mode: Mirror Image

Temperature: 300F

Time: 60 seconds

Peel: Cool

Pressure: Heavy

#### CL Hard Surface II

Paper Mode: Heavy to Label 1

Print Mode: Mirror Image

Temperature: 300F

Time: 50 seconds

Peel: Cool

Pressure: Heavy

CL Hard Surface I: For OKI 6100  
& 6150 print in Glossy mode

#### Crystal/Glass

Any transparent Crystal or Glass substrate.

#### Materials Required:

Heat Press, Laser Printer, Felt Heat Pad, Acrylic substrate

#### CL Crystal

- 1.) Insert into bypass tray and print right reading
- 2.) Print image in heavy to label 1 mode
- 3.) Place substrate with backside face up
- 4.) Place imaged paper with image side face down
- 5.) Place foam pad on top
- 6.) Press at 320F for 45-60 seconds

- 7.) Wait for substrate to cool and trim excess paper around object

Note: Use extremely light pressure when using CL Crystal. Excessive pressure will result in an unclear image.

#### CL Hard Surface I

- 1.) Insert into bypass tray and print mirror imaged.
- 2.) Print image in color to label 1 mode
- 3.) Place substrate with image side face up
- 4.) Place imaged paper with image face down
- 5.) Place foam pad on top
- 6.) Press at 300F for 60 seconds.
- 7.) Wait for substrate to cool and peel backing off cool.

#### CL Hard Surface II

- 1.) Insert into bypass tray and print mirror imaged.
- 2.) Print image in heavy to label 1 mode
- 3.) Place substrate with image side face up
- 4.) Place imaged paper with image face down
- 5.) Place foam pad on top
- 6.) Press at 300F for 60 seconds.
- 7.) Wait for substrate to cool and peel backing off cool.

## LEATHER/MAGNETS

### INSTRUCTIONS

#### CL Hard Surface II

Paper Mode: Heavy to Label 1

Print Mode: Mirror Image

Temperature: 300F

Time: 50 sec

Peel: Hot

Pressure: Heavy

CL Hard Surface I

Not Applicable

CL Crystal

Not Applicable

#### Leather

Any white or light colored leather fabric. Recommended to print on the smooth side of the leather.

#### Materials Required:

Heat Press, Laser Printer, Foam Heat Pad, Leather Fabric

#### CL Hard Surface II:

- 1.) Insert into bypass tray and print mirror imaged.
- 2.) Print image in Heavy to Label 1 mode depending on your printer
- 3.) Place substrate with image side face up
- 4.) Place imaged paper with image face down onto substrate
- 5.) Place foam heat pad on top of substrate
- 6.) Press at 300F for 50 seconds. Use Heavy Pressure. Peel hot.

#### CL Hard Surface I

Paper Mode: Color to Label 1

Print Mode: Mirror Image

Temperature: 300F

Time: 60 sec

Peel: Cool

Pressure: Heavy

CL Hard Surface II

Not Applicable

CL Crystal

Not Applicable

#### Uncoated Magnetic Sheeting

Any white or light colored uncoated magnetic sheeting.

#### Materials Required:

Heat Press, Laser Printer, Foam Heat Pad, Uncoated Magnets

#### CL Hard Surface I:

- 1.) Insert into bypass tray and print mirror imaged.
- 2.) Print image in Color to Label 1 mode depending on your printer
- 3.) Place substrate with image side face up
- 4.) Place imaged paper with image face down onto substrate
- 5.) Place foam heat pad on top of substrate
- 6.) Press at 300F for 60 seconds. Use Heavy Pressure. Peel cool.

Note: For CL Hard Surface I, in OKI 6100 & 6150 print in Glossy mode

## METAL

### INSTRUCTIONS

#### CL Hard Surface I

Paper Mode: Color to Label 1

Print Mode: Mirror Image

Temperature: 330F

Time: 90 sec

Peel: Cool

Pressure: Heavy

CL Hard Surface II

Not Applicable

CL Crystal

Not Applicable

#### Anodised Metal (Brass)

Any white or light colored uncoated metals. This includes, silver, gold, and white metals

##### Materials Required:

Heat Press, Laser Printer, Foam Heat Pad, Metal Substrate

##### CL Hard Surface I:

- 1.) Insert into bypass tray and print mirror imaged.
- 2.) Print image in color to Label 1 mode depending on your printer
- 3.) Place substrate with image side face up
- 4.) Place imaged paper with image face down onto substrate.
- 5.) Place foam heat pad on top
- 4.) Press at 330F for 90 seconds, use medium to heavy pressure
- 5.) Wait for substrate to cool and peel with even and smooth motion

Note: For CL Hard Surface I, in OKI 6100 & 6150 print in Glossy mode

#### CL Hard Surface I

Paper Mode: Color to Label 1

Print Mode: Mirror Image

Temperature: 330F

Time: 180 sec

Peel: Cool

Pressure: Heavy

CL Hard Surface II

Not Applicable

CL Crystal

Not Applicable

#### DynaSub/UNISUB Metals

Any white or light colored polyester coated metal. This includes silver, gold, and white metals

##### Materials Required:

Heat Press, Laser Printer, Foam Heat Pad, Metal Substrate

##### CL Hard Surface I:

- 1.) Insert into bypass tray and print mirror imaged.
- 2.) Print image in color to Label 1 mode depending on your printer
- 3.) Place substrate with image side face up
- 4.) Place imaged paper with image face down onto substrate.
- 5.) Place foam heat pad on top
- 6.) Press at 330F for 180 seconds, use medium to heavy pressure
- 7.) Wait for substrate to cool and peel with even and smooth motion

Note: For CL Hard Surface I, in OKI 6100 & 6150 print in Glossy mode

## WOOD

### INSTRUCTIONS

#### CL Hard Surface II

Paper Mode: Heavy to Label 1

Print Mode: Mirror Image

Temperature: 300F

Time: 50 sec

Peel: Hot

Pressure: Heavy

CL Hard Surface I

Not Applicable

CL Crystal

Not Applicable

#### Uncoated Wood

Any white or light colored uncoated wood. Wood substrates that are sensitive to heat and warp when heated are not recommended. Please test before commercial production.

#### Materials Required:

Heat Press, Laser Printer, Foam Heat Pad, Uncoated Wood

#### CL Hard Surface II:

- 1.) Insert into bypass tray and print mirror imaged.
- 2.) Print image in Heavy to Label 1 mode depending on your printer
- 3.) Place substrate with image side face up
- 4.) Place imaged paper with image face down onto substrate
- 5.) Place foam heat pad on top of substrate
- 6.) Press at 300F for 50 seconds. Use Heavy Pressure. Peel hot.

#### CL Hard Surface I

Paper Mode: Color to Label 1

Print Mode: Mirror Image

Temperature: 275F

Time: 120 sec

Peel: Cool

Pressure: Heavy

CL Hard Surface II

Not Applicable

CL Crystal

Not Applicable

#### Coated Wood (Lacquered)

Any white or light colored coated wood. Wood substrates that are sensitive to heat and warp when heated are not recommended. Not all coated wood surfaces will work, please thoroughly test before commercial production.

#### Materials Required:

Heat Press, Laser Printer, Foam Heat Pad, Ceramic Tile

#### CL Hard Surface I:

- 1.) Insert into bypass tray and print mirror imaged.
- 2.) Print image in Color to Label 1 mode depending on your printer
- 3.) Place substrate with image side face up
- 4.) Place imaged paper with image face down onto substrate
- 5.) Place foam heat pad on top of substrate
- 6.) Press at 275F for 120 seconds. Use heavy pressure. Peel cool.

Note: Do not press at higher temperatures as the coating on the wood may be heat sensitive and may cause bubbles to form.

## ALUMINUM BOTTLE

### INSTRUCTIONS

#### CL Hard Surface I

Paper Mode: Color to Label 1

Print Mode: Mirror Image

Temperature: 360F

Time: 200 sec

Peel: Cool

Pressure: Heavy

CL Hard Surface II

Not Applicable

CL Crystal  
Not Applicable

#### Aluminum Bottle

##### Mug Press without idle time

Any white or light colored Polyester Coated Aluminum Bottle.

##### Materials Required:

Mug Press, Laser Printer, Foam Heat Pad, Aluminum Bottle

##### CL Hard Surface I:

- 1.) Insert into bypass tray and print mirror imaged.
- 2.) Print image in Color to Label 1 mode depending on your printer
- 3.) Wrap imaged paper around bottle with image facing bottle.
- 4.) Wrap felt heat pad around bottle
- 5.) Place bottle in mug press
- 6.) Close mug press and press at 360F for 200 secs
- 7.) Let Bottle cool and dunk into cold water. Then peel paper off.

Note: Not enough pressure will result in incomplete image transfer  
No Glazing is required for scratch resistance.

#### CL Hard Surface I

Paper Mode: Color to Label 1

Print Mode: Mirror Image

Idle Temp: 300F

Press Temp: 360F

Time: 150 sec

Peel: Cool

Pressure: Heavy

CL Hard Surface II

Not Applicable

CL Crystal  
Not Applicable

#### Aluminum Bottle

##### Mug Press with idle time

Any white or light colored Polyester Coated Aluminum Bottle.

##### Materials Required:

Mug Press, Laser Printer, Foam Heat Pad, Aluminum Bottle

##### CL Hard Surface I:

- 1.) Insert into bypass tray and print mirror imaged.
- 2.) Print image in Color to Label 1 mode depending on your printer.
- 3.) Wrap imaged paper around bottle with image facing bottle.
- 4.) Set mug press to idle at 300F. Ensure that it is at idle temperature.
- 5.) Wrap Foam heat pad around bottle. Place bottle in mug press.
- 6.) Close mug press and press at 360F for 150 secs
- 7.) Let Bottle cool and dunk into cold water. Then peel paper off.

Note: Not enough pressure will result in incomplete image transfer  
No Glazing is required for scratch resistance.

## STAINLESS STEEL BOTTLE

### INSTRUCTIONS

#### CL Hard Surface I

Paper Mode: Color to Label 1

Print Mode: Mirror Image

Temperature: 360F

Time: 100 sec

Peel: Cool

Pressure: Heavy

#### *Curing Step*

Level: 3

Curing Time: 10-12 sec

CL Hard Surface II

Not Applicable

CL Crystal

Not Applicable

CL Hard Surface I: OKI 6100 &  
6150 print in Glossy mode

#### Stainless Steel Bottle

##### Mug Press without idle time

Any white or light colored Polyester Coated Stainless Steel Bottle.

##### Materials Required:

Mug Press, Laser Printer, Foam Heat Pad, Stainless Steel Bottle, Curing Unit

##### CL Hard Surface I:

- 1.) Insert into bypass tray and print mirror imaged.
- 2.) Print image in Color to Label 1 mode depending on your printer
- 3.) Wrap imaged paper around bottle with image facing bottle.
- 4.) Wrap felt heat pad around bottle
- 5.) Place bottle in mug press
- 6.) Close mug press and press at 360F for 100 secs
- 7.) Let Bottle cool and dunk into cold water. Then peel paper off.

Note: Not enough pressure will result in incomplete image transfer

##### Curing The Bottle

This step is required for the bottle to become scratch resistant.

- 1.) Ensure the bottle is at room temperature
- 2.) Place bottle on curing unit.
- 3.) Set curing unit to level to 3
- 4.) Cure for 10-12 seconds

Note: DO NOT GO OVER 12 SECONDS. Overcuring can cause the coating on the bottle to discolor and burn.

## STAINLESS STEEL BOTTLE

### INSTRUCTIONS

#### CL Hard Surface I

Paper Mode: Color to Label 1

Print Mode: Mirror Image

Idle Temp: 300F

Temperature: 360F

Time: 50 sec

Peel: Cool

Pressure: Heavy

#### *Curing Step*

Level: 3

Curing Time: 10-12 sec

CL Hard Surface II

Not Applicable

CL Crystal

Not Applicable

CL Hard Surface I: OKI 6100 &  
6150 print in Glossy mode

#### Stainless Steel Bottle

##### Mug Press with idle time

Any white or light colored Polyester Coated Stainless Steel Bottle.

##### Materials Required:

Mug Press, Laser Printer, Foam Heat Pad, Stainless Steel Bottle, Curing Unit

##### CL Hard Surface I:

- 1.) Insert into bypass tray and print mirror imaged.
- 2.) Print image in Color to Label 1 mode depending on your printer
- 3.) Wrap imaged paper around bottle with image facing bottle.
- 4.) Set mug press to idle at 300F. Ensure that it is at idle temperature.
- 5.) Wrap Foam heat pad around bottle. Place bottle in mug press
- 6.) Close mug press and press at 360F for 50 secs
- 7.) Let Bottle cool and dunk into cold water. Then peel paper off.

Note: Not enough pressure will result in incomplete image transfer

##### Curing The Bottle

This step is required for the bottle to become scratch resistant.

- 1.) Ensure the bottle is at room temperature
- 2.) Place bottle on curing unit.
- 3.) Set curing unit to level to 3
- 4.) Cure for 10-12 seconds

Note: DO NOT GO OVER 12 SECONDS. Overcuring can cause the coating on the bottle to discolor and burn.