

Puzzle Transferring Instructions

Read these instructions completely before you begin.

Supplies Needed

- Sublimation Puzzle
- Heat Resistant Tape
- Heavy Cardboard



Step 1: Adjust the Heat Press

Temperature: **385° - 400° F**
Dwell Time: **45 seconds – 1 minute**
Pressure: **Firm**

Note: These instructions, including transfer times and temperatures, are based on the inks, paper, presses, ovens and products we use. Your inks, papers, etc. may require adjustments in your time/temp settings.

Step 2: Design and Print Your Transfers

1. Prepare your artwork and size the transfer with consideration to the size of the puzzle.
2. We recommend sizing the transfer so that it is .15" *larger than* the puzzle. This allows for a good bleed off the edges of the puzzle.
3. **Mirror Image:** The image must be printed in reverse so that it is right-reading once pressed onto the puzzle. Most printers refer to this as "Flip Horizontal" or "Mirror".

Step 3: Transfer the Image

Note: Test one puzzle before you run production. If you have any problems or questions, stop pressing immediately and call for support.

1. Place the transfer, face-up on the table.
2. Place the puzzle, face-down on the transfer and center it accordingly. (Fig. 1). This is only to register the image. The puzzles must be pressed face-up only.
3. Use heat resistant tape to tape the transfer to the puzzle. **Important:** Do not use spray adhesive on the puzzle or dampen the back of the transfer!
4. Carefully flip the puzzle over (so transfer is on top), and place it on the press. **Tip:** If your image has white space, try placing a piece of cardboard under the puzzle while pressing. This helps cushion the puzzle, prevents gassing of ink, and improves print quality along the edges of any white pieces.



(Fig. 1)

5. Using **Firm** pressure, press for **45 seconds to 1 minute** at **385° – 400° F**.
Important: Do not overheat puzzles! Over-exposure to heat can lead to peeling!
6. Remove puzzle from press *immediately*. Do not let the puzzle sit on or near the hot press.
7. Remove the transfer immediately, but leave any heat tape in place on the back of the puzzle. (Fig. 2)
8. Let the puzzle cool completely before trying to remove any remaining heat tape from the back of the puzzle. If you try to remove the tape while the puzzle is still hot, the tape may rip the back of the puzzle.
9. Gently remove heat tape.



(Fig. 2)

Tips & Troubleshooting

- For best results, place a piece of cardboard under the puzzle while pressing. This can increase the print quality along the edge of each piece and reduce gassing of ink.

Customer Support

For support on these or any of our products, call our toll-free number for assistance: **877.795.1500**. You may also write to us at Support@LaserReproductions.com.