



## HARIRON Sublimation Logo Making Instruction

Thank you for purchasing HARIRON Sublix series.

This procedure is based on the HARIRON sublimation logo making know-how.

This instruction manual was created in order for the user to understand the proper operation procedure of Sublix processing.

Enjoy the beautiful logos made with the HARIRON Sublix Series.



- Sublix processing needs a delicate operation.  
We recommend using it in an environment with low in dust and moisture, especially during sublimation process.
- Do not stack the garments while they are hot. The sublimation dye of the logo may migrate another item.
- Please note that leaving the sublimation transfer paper and Sublix logo in layers may cause migrating.  
When stacking the finished logos in layers, sandwich them between release paper to avoid migrating.

### STEP 1 Print the Sublimation Transfer Sheet

Equipment: Dye Sublimation printer  
Material: Sublimation transfer paper

- Make the logo data with graphic editing software.  
Make the pattern in mirror image.
- Set sublimation paper in the sublimation printer and print the data.
- Allow the printed sublimation transfer sheet to dry for about 6 hours.  
We recommend waiting until the next day to press.



#### Point ▶

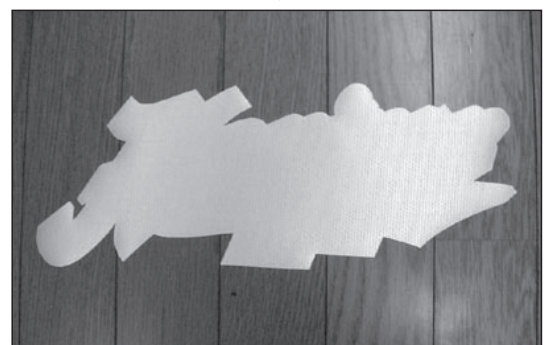
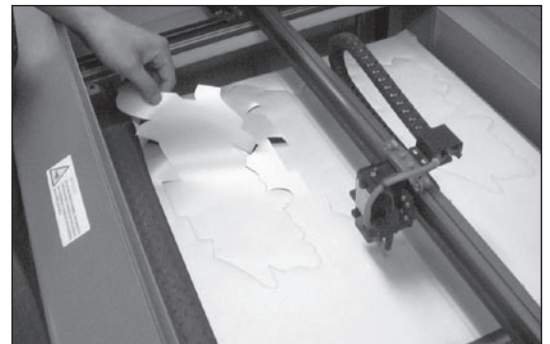
When making the logo data

When you make the logo data, create "Bleed" or "Guideline".  
See Step 3- for more details.

### STEP 2 Cut Out the Sublix Logo Mark

Equipment: Laser Cutter or Heat-pen Cutter  
Material: HARIRON Sublix Sheet

- Set the surface of Sublix sheet up in the laser cutter.  
Cut out around the entire shape.
- Sublix sheet is a white, 100% polyester fabric.  
The cut edge may turn yellow by laser.  
Set blow and vacuum higher than usual and use a needle plate.
- Sublix sheet can generally be cut like other our heat transfer textile.  
Test the cutting method ahead of time.



#### Point ▶

When cutting with a heat-pen cutter

Cut it from the laminated film side if you use a heat cutter.  
(This reduces the bleeding of glue in the sublimation transfer).  
Cut it from the wrong side in reverse.  
Test the cutting method ahead of time.

## STEP 3 Make a Sublix Logo: Part 1 [Sublimation transfer]

Equipment: Heat pressing mashine  
Material: Release paper+Low tack adhesive spray

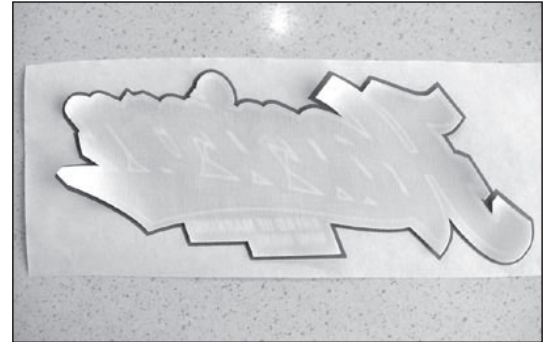
### 1 Apply spray adhesive

- Apply spray adhesive on the surface of the logo made in STEP2. Spray the adhesive to it lightly from a distance of about 20cm. Do not spray too much as the surface of the logo will get too sticky.
- Let it dry for about one full minute after spraying.
- Low tack adhesive spray is recommended.



### 2 Attach the logo to the sublimation transfer sheet

- Attach the logo made in STEP2 on the sublimation transfer sheet made in STEP1.
- Place them according to the "Bleed" and "Guideline", taking care not to place the pattern out of the "Bleed" or on top of the "Guideline".



### Point ▶

Make easy-to-apply data. \*Perform during the data creation of the image for transfer sheet printing.

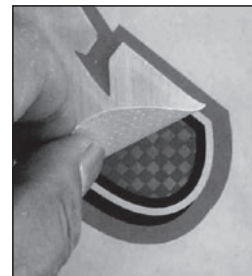
#### Bleed

Set the Bleed for 1~2mm outside of the cutting line of the logo when the outer edge of the design is a color other than white.

#### Guideline

Make the Guideline at 1~2mm outside of the cutting line of the logo when the outer edge of the design is white.

#### Bleed

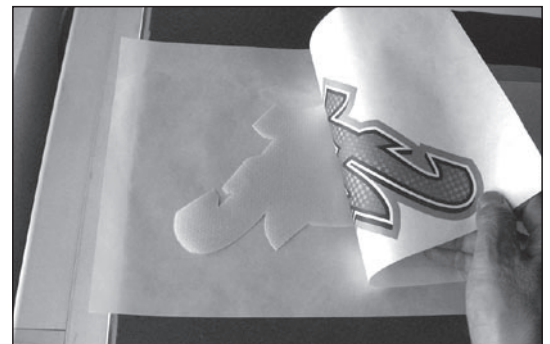


#### Guideline



### 3 Set the logo in the pressing machine.

- Place the smooth surface of the release paper up. Place the logo aligned in making the transfer paper side up. Cover it with a release paper.



# STEP 3

## Make Sublix Logo: Part 2 [Sublimation transfer]

Equipment: Heat pressing machine  
Material: Release paper

### 4 Pressing operation

- Turn each dial of the pressing machine to the sublimation transfer setting and press the sheet.
- Ensure adequate ventilation while pressing.



### Point ▶

Sublimation transfer settings

Temperature: 200°C	Pressure: Depending on the sheet type	Time: 60 seconds
--------------------	--	------------------

\* For details on the pressure, see the document "HARIRON COLOR SAMPLE BOOK".

### Point ▶

Do not lifting release paper after pressing

Hold both edges of the sheet to prevent it from being pulled up when the heat plate of the machine lifts after pressing.

If the sublimation transfer sheet is pulled up in this way it may cause displacement or blurring of the pattern.



### 5 Remove the sublimation transfer sheet from the release paper

- Peel the release paper with the logo from the under plate. Place it on a flat surface and tear off the sublimation transfer sheet from it while it is still warm.



- Tear off the release paper on the back side after it cools completely. Do not reuse the release paper.



## STEP 4 Apply the Logo to a Garment [Pressing]

Equipment: Heat pressing machine  
Material: Release paper (included with Sublix sheet)

### 1 Blank pressing and layout of the logo

- Set a garment on the pressing machine and press it to remove any moisture and wrinkles. Put the logo made in STEP3 in place.



- Cover the logo with release paper



### 2 Pressing

- Turn each dial of the pressing machine to the sublimation transfer setting and push the press button to press.
- Remove the garment from the pressing machine. Place it on a flat surface to cool.



### Point ▶

#### Pressing setting

Temperature: 165°C	Pressure: 300g/cm <sup>2</sup>	Time: 30 seconds
--------------------	--------------------------------	------------------

\* Set 150°C for Sublix Blade heat seal type.

### Finished

- Sublix sheet is for pressure bonding. Stitch-bonding process is not needed. If desired, stitch-bonding is possible after the pressure-bonding.
- Sublix Cloth is for stitch bonding. Please stitch around the logo after heat pressing. Without the stitch, there is a possibility of fraying.
- Sublix Fine is for heat pressing. Do not combine with embroidery.

For further details, please visit our web site and Youtube channel!

AHEAD OF MARKING NEW WAVE  
**HARIRON**

<http://www.hariron.co.jp/e/>

**You** 

 **HARIRON**

<https://www.youtube.com/channel/UCPSvDAzcdKGpck4dhf6HqfA>

HARIRON SUBLIX 4

**HARIRON CO., LTD**

Tokyo Head office : 〒130-0011 3-27-8, Ishiwara, Sumida-ward, Tokyo  
TEL +81-03-3625-1771 FAX +81-03-3622-1662