



## Ceramic, Marble, Porcelain & Glass Tiles Transferring Instructions

### Supplies Needed

- Sublimatable Tiles
- Sublimation transfer
- Thermal Rubber Mat and/or Heat Resistant Felt Pads
- Heat Resistant Tape

**NOTE: 4-1/4 X 4-1/4 & 6X6 Dal Tile brand ceramic tiles require slightly higher temperature of 425 degrees (face down method) in order to accomplish uniform color transfer.**

**This is because of the new wider pattern design on the back of the tile.**

### **Gluing Tips:**

*When gluing into wood frames or boxes a wide variety of silicone adhesives may be used.*

*When gluing glass or ceramic tiles into metal frames we recommend 100% silicone aquarium sealant.*

### Step 1: Adjust Heat Press

Heat Press Temperature: **400° F**  
Dwell Time: **Varies – see attached Chart**  
Pressure: **Medium – Firm, depending on the tile. See attached Chart**

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

### Step 2: Design & Print Your Transfer

Design your transfer based on the tile size. If you are designing a full-bleed image, we recommend designing the transfer so that it is at least 1/8" larger than each tile, all the way around.

### Step 3: Transfer the Image

There are two basic transfer methods for tile – face-down using a Heat Resistant Felt Pad (Method 1), or face-up using a Thermal Rubber Mat (Method 2). The method that is best for you may depend on the tile, the press, and your personal preference. **Important Note: 4x4 Tiles (U.S. only) require Method 2 below.**

#### Method 3.1: Tile Face-Down

This method requires use of a **Heat Resistant Felt Pad**. Important Note: 4x4 Tiles (U.S. with spacers only) we recommend Method 2 below or increasing temperature to **430°**.

1. Set heat press to **400° F** for **ceramic** or **425° F** for **marble**.
2. Your transfer paper should be at least 1/8" larger than the tile, all the way around.
3. Place **Heat Resistant Felt Pad** on heat press platen. For best results, we recommend **two sheets** of Heat Resistant Felt Pads.
4. Place transfer on felt pad, face-up.
5. Place tile face-down on the transfer. You will be heating through the back of the tile.
  
6. Close the heat press. **Refer to the attached Chart for time and pressure.** The pressure is very important, larger tiles and marble tiles can easily break with too much pressure.

### **Method 3.2: Tile Face-Up**

This method requires use of a **Thermal Rubber Mat**.

1. Set heat press to **400° F** for **ceramic** or **425° F** for **marble**.
2. Your transfer paper should be large enough to wrap it around the tile so you can tape it into place.
3. Tape transfer around tile using **Heat Resistant Tape**.
4. Place tile on heat press platen, face-up.
5. Lay **Thermal Rubber Mat** over tile. For best results, we recommend our grey Thermal Rubber Mats. They are smoother and more heat-conductive than other rubber mats on the market.
6. Close the heat press. Refer to the attached Chart for time and pressure. The pressure is very important – larger tiles can easily break with too much pressure.

### **Tips & Troubleshooting**

- Measure your tile *before* you design your transfer. Tile sizes are standard to the tile industry, not the printing industry. So the sizes listed may not be the actual tile size. For example, there are three different variations of 6x8" tile, each one is a slightly different size.
- If you are designing a **full bleed image** your printed area should be at least 1/10" larger than the tile. If your tile is 6x6", your printed transfer should be 6.1x6.1", etc. If your image is not a full bleed, print registration marks slightly larger than the size of the tile.
- The tile should be centered under the main pressure point of your heat press platen.
- When pressing multiple tiles at once, we recommend leaving at least 1" space between each tile.
- When gluing these tiles into wood or metal frames we recommend 100% silicone aquarium sealant

## Tile Time Chart Ceramic, Marble & Porcelain

Tile Size	Press Time Method 1 (face-down) Ceramic	Press Time Method 1 (face-down) Marble & Porcelain	Press Time Method 2 (face-up) Ceramic	Press Time Method 2 (face-up) Marble & Porcelain
1" – 3"	3.5 – 4 min	5.5 – 6 min	3 – 3.5 min	5 – 5.5 min
3" – 4"	4 – 4.5 min	6 – 6.5 min	3.5 – 4 min	5.5 – 6 min
4" – 5.5"	4.5 – 5.5 min	6.5 – 7.5 min	4 – 5 min	6 – 7 min
<b>Dal Tile 4"</b>	<b>5.5 – 6 min @ 425° F</b>			
<b>Dal Tile 6"</b>	<b>6 – 6.5 min @ 425° F</b>			
5.5" – 7"	5.5 – 6 min	7.5 – 8 min	5 – 5.5 min	7 – 7.5 min
7" – 10"	6 – 7 min	8 – 9 min	5.5 – 6.5 min	7.5 – 8.5 min
10" – 12"	7 – 8 min	9 – 10 min	6.5 – 7.5 min	8.5 – 9.5 min
12" – 16"	8 – 9 min	10 – 11 min	7.5 – 8.5 min	9.5 – 10.5 min

### Pressure Guidelines

- All tiles up to 6" x 6" should have firm pressure.
- Marble tiles and tiles that are 6" x 8" or larger require only medium to light pressure. Too much pressure can break these tiles.
- Marble tiles have natural cracks in them. Be extra cautious with the pressure. **Light pressure is fine for Marble tile.**

# Glass Tile Transferring Instructions

For best results, we recommend HR2000™ high-release transfer paper for Glass Tiles

## Supplies Needed

- Glass Tiles
- Transfer paper
- Heat Tape
- Heat resistant felt pads or 1 Thermal Rubber mat
- Heat Gloves or Oven Mitts

## Step 1: Adjust Heat Press

Heat Press Temperature: **390-400° F**  
Dwell Times: **3.5 -4 minutes depending on size and thickness.**  
Pressure: **Medium - Firm**

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

## Step 2: Design & Print Your Transfer

Design and print your sublimation transfer in the usual way. Sublimatable glass tiles will accept a full-bleed design.

## Step 3: Transfer the Image

Sublimatable Glass Tiles can be pressed either face-down using Heat Resistant Felt Pads, or face-up using a Thermal Rubber Mat.

### Method 3.1: Tile Face-Down

1. Place two Heat Resistant Felt Pads on your press bed.
2. Place your transfer face-up on the felt pads.
3. Place the glass tile **face-down** on the transfer.
4. Using **Medium to Firm** pressure, press at **390-400° F**, for **3.5 – 4 minutes**.
5. Skip to Step 4: Cooling

### Method 3.2: Tile Face-Up

1. Place the glass tile **face-up** on your heat press platen.
2. Place your transfer face-down on the glass tile. Tape it into place using Heat Resistant Tape.
3. Cover the tile and transfer with a Thermal Rubber Mat.
4. Using **Medium to Firm** pressure, press at **390-400° F**, for **3 – 4 minutes**.
5. Go to Step 4: Cooling

## Step 4: Cooling

Carefully remove tiles from press. Although these are tempered glass tiles and are able to withstand temperature changes, for best results, allow the tiles to cool slowly; **do not immerse Glass Tiles in water!** We recommend using a heat sync tray and fan to cool tiles and other glass objects.

## Transfer Tips & Techniques

- If you notice any paper sticking, reduce the temperature or dwell time (reduce one variable at a time). If that does not help, please call Customer Support for assistance.
- Tempered Glass is glass that has been specially-treated to be both shatter- and temperature-resistant. When struck or dropped, tempered glass will fracture into small, relatively harmless fragments. It can normally withstand temperatures of 200-300° F.
- Tempered Glass cannot be drilled or cut. If you have an application that requires drilling or cutting, ask us about coating on Annealed Glass (Plate Glass).
- Our standard 2" tiles (only) are not tempered.

## Customer Support

For support on these or any of our products, please call our toll-free number for assistance: 877.795.1500. You may also write to us at [support@laserreproductions.com](mailto:support@laserreproductions.com)