

## **Tip Sheet 104 2-sided aluminum Keepsake Boxes:**

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The assembly of the Wood Keepsake Box is easiest when done as follows. You will need a Phillips screw driver. Any powered drill or screw driving guns electric or battery operated are not recommended.

- ◆ Remove the protective film from **BOTH** sides of the aluminum and sublimate one side of the aluminum. Since this is a two sided item, great care should be taken such that no residual inks come in contact with the back side of the aluminum during sublimation. Use craft paper or copy paper, tissue paper is too thin and will not protect the aluminum from ink. It is advised to use a minimal amount of bleed on your artwork. We recommend a 45 sec. hold time @ 400° F for 2-sided Unisub™ aluminum.
- ◆ Please exercise extreme caution when removing the aluminum from your heat press. Using an oven mitt or rag when removing any items from your heat press is recommended.
- ◆ Allow the aluminum to cool to approximate room temperature.
- ◆ Sublimate the second side of the aluminum as above.

### **! ATTENTION !:**

- The second side image may need to be rotated 180° to the first side. If you plan to open the box like the cover of a book (right-to-left) do not rotate the image. If the box will be opened bottom-to-top you must rotate the image.
- As above one must use extreme caution to keep ink from the opposite side of the aluminum.
- ◆ Remove the wooden plug from the edge of the lid. The plug can be easily pushed out from the inside of the frame using a small flat screw driver, a putty knife or some other flat object. Insert the flat object into the thin slot along the inside edge of the lid. The plug is not screwed into place so it can be removed very easily. Note the orientation of the plug so it can be reinserted in the same orientation.
- ◆ Slide the sublimated aluminum into the slot and replace the plug. Use the screw provided and a #1 Phillips screw driver to install the screw.
- ◆ Using the 6 pads provided:
  - Cover the screw head used to hold the plug in place with one.
  - Place one on the left inside edge of the lid on the opposite side of the screw.
  - Place the remaining four on the bottom four corners of the box.
- ◆ The aluminum insert can be changed by removing the pad, removing the screw and pushing the plug out with the aluminum insert that is in the lid.

### **2-SIDED SIMULTANEOUS SUBLIMATION**

Due to the high conductive properties of the aluminum, it is possible to sublimate both sides at the same time. Following are two options both of which will require pressing at 400° F for 60 seconds.

#### ➤ Spray Mount

Cut out the two images very close to the size of the insert. Spray a light film of 3M Spray Mount (or similar) on both transfers. Peel the protective film from both sides of the aluminum insert. Stick the two transfers to opposites sides of the aluminum insert. Be sure to rotate one transfer 180° if necessary. After sublimation you will need to clean the adhesive residue from both sides of the insert with acetone (nail polish remover) or similar.

#### ➤ Paper Fold

Orient the graphics on the transfer such that the two images are touching edge to edge along the same edge that the box is hinged. Print the transfer, cut it out, fold the transfer along the similar edge and slip the aluminum insert into the fold. Depending on the end use, you may need to rotate one of the images 180° before printing.