



1.

PREPARING HEAT PRESS

When the machine is turned on, the operator must wait until the platens hit the desired temperature. The temperature should be checked with a thermometer to ensure the heat press is well calibrated.

There should be a silicone rubber pad placed on the top platen and a Teflon sheet on the bottom platen. The silicone rubber pad is not necessary, it can be replaced with a single Teflon sheet.

2.

SETTING TEMPERATURE, TIME, AND PRESSURE PARAMETERS

Based on the characteristics of the material being processed, the operator must adjust the temperature, time and pressure parameters; these parameters are already established (See Fig. 1).

3.

POSITIONING OF EMBLEM PRIOR TO APPLICATION

The operator must ensure that when placing the emblem, the garment must be wrinkle-free, there must only be one layer of fabric between the emblem and the bottom platen (buttons or zippers should not be on the platen), the emblem must be straight and with the adhesive facing down towards the garment.

4.

APPLICATION OF EMBLEM

To start the application process, the operator must place the rubber 'cookie' on top of the emblem, activate the heat press (please follow the manufacturer's instructions and safety guidelines). Once the cycle has finished, the operator must wait for the top platen to come up on its own. It is important to know that in case of any extraordinary situation or bad placement of the emblem, the operator can immediately stop the press by pressing the emergency stop button.

5.

QC OF APPLICATION

To ensure that the emblem is well adhered to the fabric, the emblem should be pulled upwards when the material has cooled down. Performing this operation when the material is still hot may cause it to detach easily.

Fig. 1

TOP PLATEN TEMP.	BOTTOM PLATEN TEMP.	TIME	PRESSURE
400° F	400° F	10 - 12 seconds	60 - 80 psi

IMPORTANT:

It is recommended to use two sets of cookies for light and dark colors garments, this will prevent any color migration from the dark garments to the light colored garments when using only one cookie.

Another alternative is cleaning the cookie each time the customer applies on light colored garments; to clean the cookie, they just have to press it a few times (2-4 times) without any fabric.



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Have a pair of pliers ready.

2.

SETTING TEMPERATURE, TIME, AND PRESSURE PARAMETERS

Based on the characteristics of the material being processed, the operator must adjust the temperature, time and pressure parameters; these parameters are already established (See Fig. 1).

3.

POSITIONING OF GARMENT PRIOR TO REMOVAL

The operator must ensure the emblem on the garment is on the middle of the bottom platen.

4.

REMOVAL OF EMBLEM

To start the removal process, the operator must place the rubber 'cookie' on top of the applied emblem, activate the heat press (please follow the manufacturer's instructions and safety guidelines). Once the cycle has finished, the operator must quickly use a pair of tweezers, grab the border of the emblem and pull it away from the garment. After the removal, the garment can then be removed from the heat press.

Fig. 1

TOP PLATEN TEMP.	BOTTOM PLATEN TEMP.	TIME	PRESSURE
400° F	400° F	10 - 12 seconds	60 - 80 psi