

EMBROIDERED PATCHES SPECIFICATION SHEET



GENERAL INFORMATION

DESCRIPTION

Embroidered patches are designed to give the high quality look of direct embroidery without the commitment. These patches are removable emblems with thin stitched borders. They can be applied in-house which save both time and money on freight. Patches are also available with a thick merrow border to allow patches to be easily sewn onto apparel. Because of the flexibility of this product, both in its design and production, the possibilities are endless.

EMBLEM SIZE LIMITS

Max - 18" X 11" (+/-1mm)

Min - 1" X 1" (+/-1mm)

COLOR

Embroidery: The design cannot have more than 15 different colors of thread.

BACKING

- Low Melt Heat Seal
- Industrial Heat Seal
- Pressure Sensitive

LIMITATIONS

Heat Seal: Since the product is applied with heat, it is not recommended for use on materials that may be heat sensitive (ex. some nylons, silk some plastics, leather, wool, fleece, etc.).

Pressure-Sensitive: The use of these emblems on surfaces that may contain an oil finish, such as silicon, Teflon™, rough fabrics, or outdoor goods is not recommended.

ELECTRONIC PROOF

A digital sample via email is available in 24 hours. Edits are allowed.

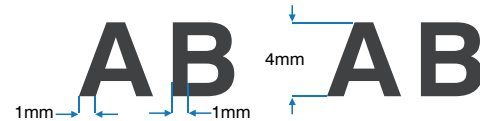
PRODUCTION TIME

Samples time 2 days plus shipping.

Production time 5 days plus shipping (additional day per 500 pieces).

MINIMUM SIZE TEXTS

Embroidered text cannot have a height smaller than 4mm and column width of 1mm.



WASHING INFORMATION

Machine wash inside-out using mild detergent. Patches with industrial heat seal backing will withstand 52 industrial wash cycles.

SHELF LIFE

One year shelf life before applying (room temperature controlled environment).

APPLICATION INSTRUCTIONS

PRESSURE-SENSITIVE ON HARD GOODS

Make sure the application area is thoroughly cleaned. We recommend the use of rubbing alcohol. Remove paper backing and press firmly on the desired location.

HEAT SEAL ON GARMENTS

1. Ensure the heat press is preheated.
2. Place the garment in the press. Make sure that the application location is wrinkle-free.
3. Place the patch onto the desired location on the garment. Thermal tape is optional.
4. Heat Seal with the settings shown below for either Low Melt Bottom Heat Press or Industrial Heat Press.
5. Remove the garment from the press and allow to cool.

LOW MELT BACKING

Bottom Temperature	320°F
Pressure	Medium (50 - 60 Psi)
Dwell Time	10 - 12 Seconds

INDUSTRIAL HEAT SEAL BACKING WITH RUBBER PAD

Top Temperature	400° F
Bottom Temperature	400° F
Pressure	Medium High (60 - 80 Psi)
Dwell Time	10 - 12 Seconds

HEAT SEAL ON HATS

1. Ensure the heat press is preheated.
2. Place the hat into the press and preheat for 25 seconds.
3. Place the patch on the hat in the desired location. Thermal tape is optional.
4. Press the patch on the hat with the settings shown below.
5. Remove the hat from the press and allow to cool.

Top Temperature	375 - 380°F
Pressure	Medium - High (60 - 80 Psi)
Dwell Time	25 Seconds

DISCLAIMER: World Emblem recommends testing the best combination of heat seal parameters before application. World Emblem is not liable for any damages to garments during the application process.

NOTE: Please check out [youtube.com/worldemblem](https://www.youtube.com/worldemblem) for step by step instructions for applying our apparel decorations.

