

# EMBROIDERED PATCHES SPEC 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** - This backing is commonly used on wearables and applied with a heat press.

**Pressure Sensitive** - This sticker backing is commonly used on hard goods.

### 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.

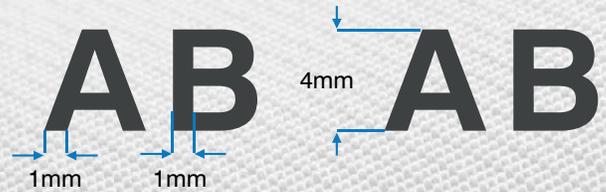
## PRODUCTION TIME

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

Embroidered emblems will withstand at least 52 domestic washing machine cycles.

## SHELF LIFE

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

## APPLICATION INSTRUCTIONS

### PRESSURE-SENSITIVE

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.

### GARMENTS

1. Mount the garment. Make sure the garment is wrinkle-free.
2. Place the emblem with the adhesive facing down. There should only be one layer of fabric between the emblem and the platen.
3. Activate the Heat Press. Let the cycle finish. If the machine is manual, make sure to pull the lever as soon as the machine beeps.
4. Check the integrity of the emblem. There should be a strong bond with the fabric. Check emblem is straight and on right location.

Low Melt Temperature	320°F Bottom Heat
Low Melt Pressure	Medium (50 - 60 Psi)
Industrial Temperature	400° F
Industrial Temperature	Medium High (60 - 80 Psi)
Dwell Time (Low Melt & Industrial)	10 - 12 Seconds

### HATS

1. Pre-heat mold 10-15 times, 12 seconds each time. This is done only once without the hat mounted so the silicone rubber pad stays hot throughout the application process.
  2. Mount the hat with the headband inside of the cap pulled out. Depending on the location, the hat must be mounted using the 'stretcher' located on the bottom of the heat press. Make sure there is no space between the mold and hat. Pre-heat the hat for 25 seconds.
  3. Place emblem on hat using thermal tape.
- Pull down lever to activate the press. When press beeps, pull up lever quickly. Check the integrity of the emblem. There should be a strong bond with the fabric. Check emblem is straight and on right location.

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 the World Emblem YouTube Channel for step by step instructions for applying our apparel decorations.*

