

SUBLIMATED PATCHES SPEC SHEET



GENERAL INFORMATION

Description:

World Emblem also offers a Perfect Print® Sublimation System, allowing you the ability to manufacture your own emblems. Through a secure online catalog, you can produce emblems on-demand and at a fraction of the cost of outsourcing the production. The Perfect Print® Sublimation System includes a printer, software, templates, paper, ink and blanks.

Patches are also available with a thick merrow border to allow patches to be easily sewn onto apparel.

EMBLEM SIZE LIMITS

Max - 13.5" X 8" (+/-1mm) Min - 1" X 1" (+/-1mm)

COLOR

Perfect Print® allow unlimited colors. You can digitally print photorealistic images and even match PMS colors.

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).

WASHING INFORMATION

Sublimated 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.

