



GUIDELINES FOR USING HEAT SEAL / IRON-ON FILM IN EMBROIDERY APPLICATIONS

Several factors should be considered in the selection of adhesive film. Use the following guidelines to obtain the best performance from your heatseal!!

ADHESIVE FILM

• **Nylon:** which shows superior resistance to any deterioration of the bond's strength due to dry cleaning. It also performs better when trimming either with a hot knife or click knife, allowing you to create appliques, crests, badges and emblems. The Nylon adhesive performs excellent results with most fabrics, operating at an application temperature of approx. 220°C. Light to moderate pressure is required with good flexibility. It is excellent for dry cleaning resistance, home laundry resistance and commercial laundry resistance. Available in 300mm x 90m rolls or a minimum order of 5 metres.

RECOMMENDATIONS FOR APPLYING ADHESIVE FILM TO EMBROIDERY:

It is as important to laminate the adhesive film onto the back of the emblem properly, as it is to select the appropriate adhesive. The most important aspect of laminating the adhesive film to the emblem is to carefully control the depth of penetration of the adhesive into the emblems. If the adhesive is driven too far into the back of the emblem, there may not be enough film remaining at the bonding interface (glue line) to obtain a proper bond to the garment. In order to control the degree of adhesive film penetration, both the temperature and pressure settings on the application equipment must be carefully controlled. For most adhesives, temperature settings of 180° to 220°C and gauge pressures at 2.75-3.5 bar are recommended for applying the adhesive to the embroidery. Applying the adhesive to the emblem requires less dwell time and temperature than is needed to bond the emblem to the garment.

It is sometimes difficult to measure the degree of adhesive penetration, without destroying the emblem. Steps can be taken to reduce the chance of over penetration:

1. The glue line temperature, between the emblem and the release paper carrier, should be determined before applying the emblem.
2. A visual inspection of the emblem after lamination can often spot signs of over penetration. If the embroidery threads appear to be poking through the adhesive, it is likely the adhesive is driven in too far. When the adhesive has been applied properly, the laminated material should have a smooth surface with no sign of the threads above the adhesive film.
3. The adhesive should be cooled completely before the release paper is removed. This prevents adhesive being pulled off the emblem while it is still molten, or soft.

This report has been compiled by Tajima Australia . These guidelines are intended to provide a starting point in determining the best conditions for the use of Tajima HEATSEL. Washing ability, drycleanability and bond strength test results may vary significantly with the different methods employed as well as types of heatseal equipment and fabrics used.

For Further information on this Product please contact Tajima Australia Pty Ltd on (03)9484 5898.

www.tajimaaustralia.com.au