

# PENNEDGE® SUBLIMATED (IG)

## PRODUCT SPECIFICATIONS

ColorPrint® Dye Sublimated emblems are the perfect match for your highly detailed design. Using the sublimation process, designs are full color and the ideal photo finish image recreation for promotional products, branding, garments, hats, bags and more! Choose from 16 million colors to complete your vision. These emblems are economical, durable, removable, and reusable.



### DIMENSIONS

**Minimum Size:**  
1.0" x 1.75" (2.5 x 4.4cm)

**Maximum Size:**  
10.5" x 16.5"



### LETTERING

The text within a design should not be less than **2mm in height (9pt font size)**. Smaller text may need to be altered.



### FABRIC COLOR/THREADS

**Fabric:**  
PennBrite® patented product that brings dye sublimated colors high definition effect.

**Thread:**  
100% Polyester for Embroidery Thread



### BACKING TYPE

**Heat Seal**

**Velcro**

**Pressure Sensitive (Stick-On)**

**Industrial (PennBond®)**

*Note: can be sewn-on as well*



### WASH CARE

**Home Laundry**

**Industrial Laundry**



### BORDER/EDGE STYLES

**Stitched Border**



### ORDERING GUIDELINES

#### Artwork & Setup Fees:

An emailed sketch card or scan of your finished emblem is included with the order for no additional cost.

#### Order Quantities:

No Minimum

#### Order Process:

During the ordering process, the following information is required to proceed with your request:

- Vector Artwork
- Order Quantity
- Size
- Colors (if known)
- Application Method
- Garment Type



### ARTWORK/TURNAROUND

#### Accepted Graphic File Types:

.cdr, .ai, .eps, .pdf .jpg, .png, .psd,

**\*Vector Art Preferred**

Most orders will ship in **3-7 business days.**



### PAYMENT METHODS

**Visa, Mastercard, American Express, Discover, Wire/ACH Checks.**

*If you would like to be set up with payment terms, please contact Customer Support for assistance.*



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# HEAT SEAL MACHINE APPLICATION



## APPLICATION METHODS: SEW-ON, HEAT SEAL, OR PRESSURE SENSITIVE (STICK-ON)

The manner in which emblems can be attached to garments or other textile products relates directly to the *TYPE OF BACKING* used in the manufacturing process, the *EMBLEM SIZE*, and the *TYPE OF MATERIALS* that the emblems will be attached to. Almost all emblems can be sewn on, and when it comes to heat seal application, smaller emblems are easier to work with. The chart below outlines the application options relative to backing types.

BACKING TYPE	SEW-ON	HAND APPLY	HAND IRON	HEAT SEAL
VELCRO®	yes	yes	no	loop side only
STICK ON	possible	yes	no	no
INDUSTRIAL	yes	no	no	yes
LOW-MELT	yes	no	no	yes

## HEAT SEAL TIPS:

### THICKER FABRICS:

May require longer cycle times beyond the ranges.

### TREATED FABRICS:

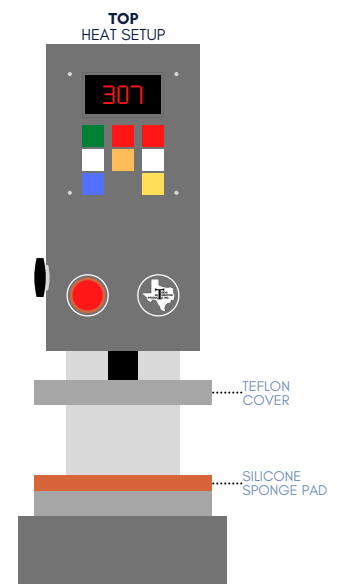
If finished with coatings, sizing, or repellants, may not allow for proper heat seal bonding.

### SPECIAL FABRICS:

*Leather, Suede, Nylon, Synthetics, Nylon-Shell, Interlinings, Rubberized Coatings, or Reflective Fabrics* may react poorly to heat seal temperatures depending on thickness, weave, texture, and weight. It is recommended that these fabrics be tested first, with possible heat seal time and temperature adjustments. In many cases, it may be better to have emblems sewn on to these types of materials.

HEAT SEAL SETTINGS				
	TOP (SPONGE)	BOTTOM (TEFLON)	PRESSURE	CYCLE TIME
INDUSTRIAL	<b>405°F</b> (207°C)	<b>405°F</b> (207°C)	<b>60-80 PSI</b> ON GAUGE	<b>12-14</b> SECONDS
LOW-MELT	<b>340°F</b> (171°C)	<b>340°F</b> (171°C)	<b>60-80 PSI</b> ON GAUGE	<b>12-14</b> SECONDS

PRESSURE SETTINGS (BASED ON PLATEN SIZE)					
TEXAS AUTOMATION HEAT SEAL MACHINE 3" CYLINDER			NATMAR HEAT SEAL MACHINE 4" CYLINDER		
<b>2" x 4"</b>	<b>40-60 PSI</b> on gauge		<b>2" x 4"</b>	<b>40-60 PSI</b> on gauge	
<b>3" x 5"</b>	<b>55-60 PSI</b> on gauge		<b>3" x 5"</b>	<b>55-60 PSI</b> on gauge	
<b>4" x 6"</b>	<b>60-80 PSI</b> on gauge		<b>4" x 6"</b>	<b>60-80 PSI</b> on gauge	
<b>3.5" x 5"</b>	<b>60-80 PSI</b> on gauge		<b>6" x 8"</b>	<b>75-95 PSI</b> on gauge	



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