



## HEAT SEAL PARAMETERS FOR EXPRESSPRINT T7 LABEL TAPE

### BONDING CONDITIONS FOR EXPRESS PRINT T7 LABEL TAPE:

#### Temperature:

Upper platen (with Teflon): 380°F.

Lower platen (with silicone sponge): 380° F.

Time: 10 seconds

#### Pressure: (for both of above conditions):

The goal is to achieve a net pressure of 20 to 25 psi *inter-platen*. Note that this is the pressure *between the platens, not at the gauge*. The pressure setting required at the gauge to produce a given pressure at the platen will depend on the size of the machine's air cylinder and on the platen (i.e. iron) being used. Recommended settings for some of the more popular models/configurations are as follows:

Texas Automation DES-32/DES-42 with 4" x 6" platens:	Set to 60 to 80 p.s.i. gauge.
Texas Automation DES-32/DES-42 with 3" x 5" platens:	Set to 55 to 65 p.s.i. gauge.
Texas Automation DES-32D/ES-42 with 2" x 4" platens:	Set to 25 to 30 p.s.i. gauge.
Penn Wizard with 4" x 6" platens:	Set to 55 to 60 p.s.i. gauge.
Natmar EasySeal with 4" x 6" platens:	Set to 55 to 60 p.s.i. gauge.
Natmar EasySeal with 3" x 4" platens:	Set to 30 to 35 p.s.i. gauge.
Thermopatch LS-11/LS-12 with 4" x 5" platens:	Set to 50 to 60 p.s.i. gauge.

If your machine is not listed above, please contact Penn Emblem for guidance.

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