

# PENNPly®

a single layer of PennPly® adhesive to re-apply or re-use an emblem on a new shirt.



**CLEAR/NATURAL**



**PENNBOND®  
ADHESIVE BACKING**



**RAPID LEAD TIMES**



**INDUSTRIAL  
LAUNDERABLE**

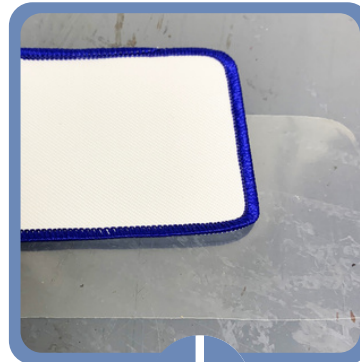


**Bottom Heat (EMBROIDERED)  
Top Heat (PRINTED/INKJET)  
Industrial Settings (RUI)**



**QUANTITY:  
1 BAG = 100 PIECES**

ITEM	DESCRIPTION	PRICE
MTPLY-2909	<b>BN</b> PENNPly LAMINATE URETHANE 1.125x3	<b>\$3.50/bag</b>
MTPLY-6383	<b>BA</b> PENNPly LAMINATE URETHANE 1.875x3.25	<b>\$3.50/bag</b>
MTPLY-645	<b>BD</b> PENNPly LAMINATE URETHANE 2.5x4.5	<b>\$4.50/bag</b>
MTPLY-672	<b>BR</b> PENNPly LAMINATE URETHANE 2x4	<b>\$4.50/bag</b>
MTPLY-748	<b>BB</b> PENNPly LAMINATE URETHANE 1.125x3	<b>\$3.50/bag</b>
MTPLY-751	<b>BK</b> PENNPly LAMINATE URETHANE 1.375x3.75	<b>\$3.50/bag</b>



## CHOOSE/ORDER

Determine your desired PennPly® Backing based on emblem size.

## PLACE PENNPly®

Take emblem and single layer of PennPly® film; Align them together.

## ATTACH EMBLEM

Place emblem with PennPly® backing on desired apparel location.

## HEAT SEAL

Heat Seal according to emblem specifications (see reverse).



ssales@pennemblem.com



800-845-8028



www.pennemblem.com



800-775-7366



# 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

\*for PennPly® and PennBloc® - Industrial Backing only and must use Industrial Heat Seal Settings as per below\*

### 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.

## INDUSTRIAL HEAT SEAL SETTINGS

 TOP (SPONGE)	 BOTTOM (TEFLON)	 PRESSURE	 CYCLE TIME
<b>405°F</b> (207°C)	<b>405°F</b> (207°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	
2" x 4"	40-60 PSI on gauge	2" x 4"	40-60 PSI on gauge
3" x 5"	55-60 PSI on gauge	3" x 5"	55-60 PSI on gauge
4" x 6"	60-80 PSI on gauge	4" x 6"	60-80 PSI on gauge
3.5" x 5"	60-80 PSI on gauge	6" x 8"	75-95 PSI on gauge

