
Sports Fabrics with Heat Seal Backing

Recommended Application Instructions

Applicable to sports twill, diamond twill, sports brite metallic, and sports felt with heat seal adhesive backing.

Cutting

Cut with flat bed blade, waterjet, or laser cutter.

Cutter settings vary depending on manufacturer. To determine the proper settings, test cut some scrap material.

On blade cutters, use a sharp 60 deg. blade.

It is recommended that edges be embroidery stitched to prevent fraying and lifting with wear, especially when washed.

Heat Sealing Heat transfer to cotton, polyester, cotton/polyester blends, polyester mesh and other non-silicone treated materials.

At the start of heat seal operations warm the bottom foam padded platten by resting the hot top plate on it for about 1 minute.

Preheat the garment to stabilize size and remove moisture.

Lay the cut design in the desired position and cover with a **clean** release sheet.

Heat seal at: **340 deg.F , Medium to Firm pressure.**

The dwell time depends on the number of layers (ie colors) in the design.

1 layer design	10 seconds
2 layer design	15 seconds
3 layer design	25 seconds
4 layer design	30 seconds
5 layer design	35 seconds

Remove the cover sheet hot. It may have some residue on it after heat sealing. After it cools, the residue can be wiped away.