
Sports Fabrics with Permanent Backing
Recommended Application Instructions

Applicable to sports twill, diamond twill, sports felt, metallic twill, and combinations of them in multiple layers with permanent adhesive backing.

Cutting

To prevent the edges from fraying with wear, they must be laser cut.

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.

Heat Sealing

Heat transfer to cotton, polyester, cotton/polyester blends, polyester mesh and other non-silicone treated materials. NOT suitable for nylon.

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 by heat sealing for at least 10 seconds. Use a **clean** release cover sheet.

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

Heat seal at:

w/o Metallic Twill or Felt

340 deg.F, Firm pressure

1 layer design	15 seconds
2 layer design	20 seconds
3 layer design	25 seconds
4 layer design	30 seconds

w/ Metallic Twill or Felt

350 deg.F, Firm pressure

1 layer design	20 seconds
2 layer design	25 seconds
3 layer design	30 seconds
4 layer design	35 seconds

Remove the cover sheet hot. It will probably have some residue on it after heat sealing. After it cools, **the residue must be wiped away before reusing the sheet.**