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**Sports Fabrics with Permanent PSA Backing**  
***Recommended Application Instructions***

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*Applicable to sports twill, diamond twill, sports felt, metallic twill, and combinations of them in multiple layers with permanent pressure sensitive 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. On blade cutters for rolls, cut in TRUE image, NOT mirror, down to the mylar carrier but not through it.

**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.

**Remove the mylar backing**, hand press 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**

<b>1 layer design</b>	<b>15 seconds</b>
<b>2 layer design</b>	<b>20 seconds</b>
<b>3 layer design</b>	<b>25 seconds</b>
<b>4 layer design</b>	<b>30 seconds</b>

**w/ Metallic Twill or Felt**

**350 deg.F, Firm pressure**

<b>1 layer design</b>	<b>20 seconds</b>
<b>2 layer design</b>	<b>25 seconds</b>
<b>3 layer design</b>	<b>30 seconds</b>
<b>4 layer design</b>	<b>35 seconds</b>

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.**