
N400 (5mil)

Recommended Application Instructions

N400 is a heat seal adhesive on a release paper carrier.

It is a permanent adhesive to hold lettering/ designs to clothing. It is not recommended for finer fabrics, because its thickness may be too much and strike through to the top of finer fabric designs.

Note: Many fabrics will fray at edges with wear and washing, even with permanent adhesive unless lazer cut or embroidery sewn.

Heat Sealing to Back of Fabrics

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

Place the N400 on the backside of the fabric with its adhesive side against the fabric (ie the paper carrier is up).

Heat seal at 325 deg.F for 5 seconds at medium pressure.

Note: Press settings may vary. Always pre-test on scrap material.

After cooling, the paper carrier can be removed, however, it removes much easier if it is allowed to cure for a few hours. This cure time can be reduced to about 10 minutes by warming to 125 to 150 deg.F.

Note: If the adhesive has a bubbly, rough look after heat sealing, this is an indication that the release paper has adsorbed too much moisture from the air. Predrying the N400 with some heat may be necessary in this case.

Application to Garment

Preheat the garment

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

Heat seal at **340 deg.F** for **12 seconds** at medium to firm pressure.

Note: On heavier fabric designs and multiple layer designs, longer times are required, up to 50 seconds in some cases. Please test on scrap material to determine whether the bond is good.

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