

HEAT SEALING BEST PRACTICE

Basically the heat seal procedure comprises three essential elements of time, temperature and pressure. These elements need varying for different fabrics, products etc. The tips and hints below will help you to achieve perfect results every time.

DON'T FORGET THAT J&A WILL BE ONLY TOO HAPPY TO GIVE ADVICE AND TEST FABRICS/GARMENTS FOR YOU

DIFFERENT TYPES OF BADGES/TRANSFERS

The correct heat seal parameters for each type of decoration supplied by J&A (International) Ltd are given on the product packaging and on the 'Heat Seal Parameters' chart available on request from J&A. A version correct at time of printing is shown on pages 6 & 7.

The parameters quoted above are guidelines which are satisfactory for most fabrics but do please read the points below and bear in mind they may occasionally dictate that parameters are set outside usual ranges. J&A (International) Ltd accept no liability for goods damaged by the heat sealing process.

DIFFERENT FABRIC TYPES

Differing fabrics require differing heat seal parameters to ensure good adhesion of the decoration and prevent marking/damaging the fabric/garment. J&A (International) Ltd have built up an extensive data-base of optimum parameters for various fabrics and will be pleased to advise and recommend settings.

FABRIC THICKNESS

Principally, the thicker the fabric, the longer the dwell time required. There is no exact formula to determine the time required - simply experiment with the particular fabric you are using as to what dwell works best.

OPENING OUT GARMENTS

Wherever possible, only heat seal onto one thickness of fabric. This, for example, entails opening out garments and putting only either the front or back, as appropriate, over the base plate.

FABRIC FINISHES

Modern fabrics can be coated or finished with a variety of different chemicals to achieve different fabric properties and performances. Most do not affect the strength of adhesion of J&A heat seal products. On the rare occasions that the adhesion is not as strong as would be expected and fabric coatings are suspected as the cause, try heating the area of fabric to be decorated using the heat seal machine before applying the badge or transfer as this can evaporate away or "burn off" the finish in this area.

ADHESIVE SHOWING ROUND

EDGE OF TRANSFERS

This can sometimes be seen when applying transfers to darker garments. In such cases the visible adhesive can be greatly reduced by removing the transfer release-paper in the normal manner after heatsealing and then sealing the transfer again for about 5 seconds.

'DELICATE' FABRICS

Some fabrics with a low melt point can show an imprint of the heat plates after heat sealing. This effect can be reduced / eliminated by, prior to sealing, covering the transfer and whole area of the garment that will be touched by the top plate with a sheet of silicone paper. Also reduce temperature to lowest possible for the type of product used.

GARMENT SEAMS, STUDS ETC

Wherever possible, make sure that any raised or thick parts of the garment, such as seams, buttons, studs etc fall outside of the heat area as shown below. Such factors entail reduced pressure and unsatisfactory adhesion which is not always immediately apparent.

CORRECT POSITION



INCORRECT POSITION





J&A (International) Limited

Heat Sealing Hints and Tips

- Check the machine temperature and timer on a daily basis.
- Wherever possible do not cover the base pad with anything other than the garment to be heat-sealed.
- Check Teflon for dirt and worn areas. Clean on a regular basis to remove any excess adhesive. If applicable replace Teflon where necessary.
- Check the silicone rubber base pad has no indentations or worn areas as this can affect the pressure when applying, possibly affecting the longevity of the transfer. Replace base pad when required.
- If using a swing head machine, leave the machine head positioned above the base pad when not in use. This will maintain heat in the head and base pad.
- Ensure garments are opened before heat-sealing, and heat-seal through fewer layers as possible.
- Try and ensure that the heat-seal area is as flat as possible and try not to capture any seams, zips, studs, etc within the heat-seal area. Use rubber to raise an area for heat sealing if obstructions cannot be avoided.
- Be sure to follow the application instruction on the product packaging carefully.
- Avoid heat-sealing over or close to flaps or pockets as this can affect the pressure.
- Many modern garments maybe coated or finished in many different ways. We recommend that testing for the best combination of heat-seal parameters before applying the decoration is good practice to ensure correct adhesion. For example, you may need to provide a pre hit of approximately 3 seconds to the garment before attempting to apply the transfer. This pre-hit should remove any coating on the garment which may affect the adhesion.
- If you experience a vacuum affect with the polyester backing when you lift the head of the heat seal machine, putting a piece of paper in between the head of the machine and the transfer before application will stop this from happening.
- Housekeeping – wherever possible keep the product together and in its original packaging whilst in use or storage. Storage - store in a cool dry place.
- For our hot release products, a quick peel of the backing is required, like ripping off a plaster.
- If the logo includes small lettering, it is advised the you do not remove the backing near this, instead peel the backing from an area/corner away from the lettering.