



# ExtremeBlanks™ [EB]

Technical Specifications  
rev. 2011-02a

## Product Details

### Emblem Dimensions:

See price guide for a list of standard, common and custom blank sizes.

- **Minimum** blank size is 1" x 2.25" (2.54cm x 5.72cm)
- **Maximum** blank size is 12" x 16" (30.48 cm x 40.64 cm)

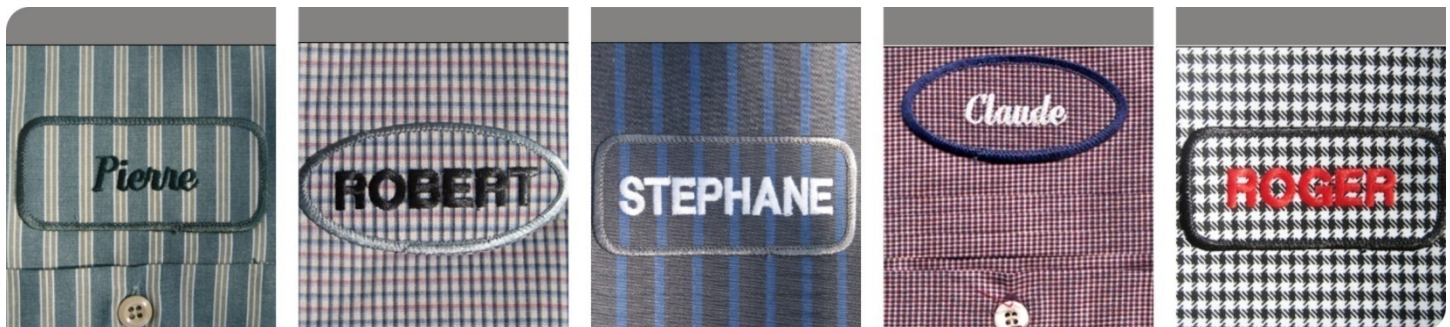
### Thread Type & Colours:

100% polyester. 120+ colours to choose from.

Emblemtex uses 100% polyester Madeira Polyneon™ thread to produce merrow borders on blanks. Choose one colour of thread for the merrowed border from over 120 standard colours, which can be found on the [Emblemtex Embroidered Emblem Thread Chart](#). Extra charges are applicable when using metallic or glow-in-the-dark threads.

### Custom Fabrics:

ExtremeBlanks™ are made with customer supplied materials for orders greater than 500 pieces. Extra charges may apply to track, convert, prepare and store these materials. Fabric must be at least 15" in width and preferably supplied in roll form. A Customer Service Representative will guide you through the evaluation process for custom materials, to determine required specifications and volumes relative to emblem size and order quantity.



### Border / Edge Styles:

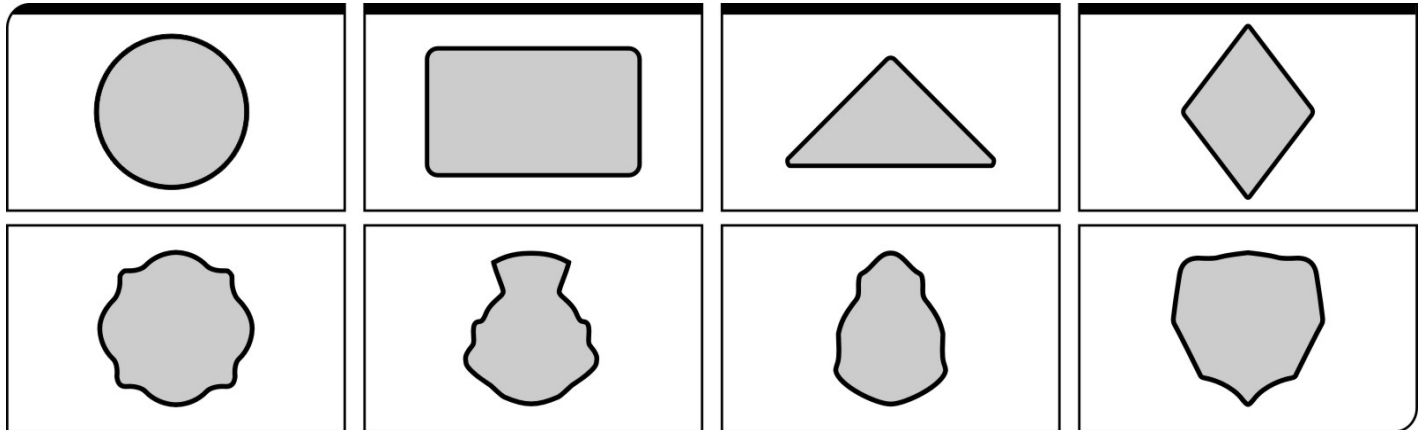
**Merrowed border.** Standard and common size Embroidered ExtremeBlanks™ are manufactured with merrowed borders, a separately stitched over-lock edge. Custom size blanks can be manufactured with or without merrowed borders, depending on the shape.



### Merrow Limitations:

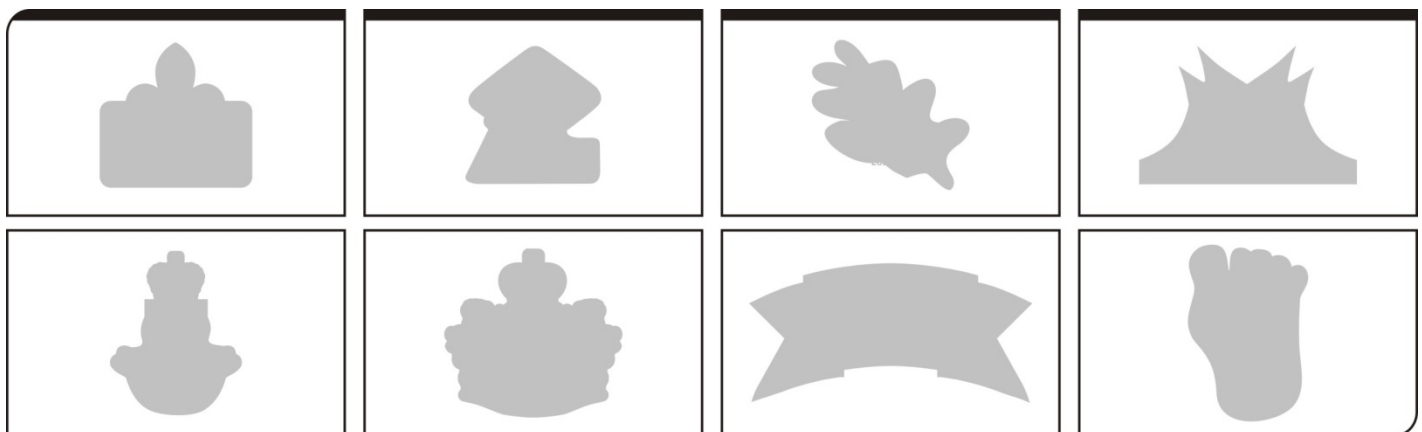
The ability to sew a merrowed border onto an emblem is directly related to the emblem shape. Odd, intricate shapes may not be suitable for merrow application.

### Shapes that can be merrowed.



### Shapes that cannot be merrowed.

Images are not to size.



### Backing Types:

**3 options.** Hi-melt glue • low-melt glue • non-woven material (no-glue)

Velcro®, pressure sensitive “stick-on” and soft magnet backings are not available for ExtremeBlanks™.

### Accessory Attachment Options:

Accessory options, such as button loops, snaps, rings, etc..., are not available for ExtremeBlanks™.

## Application & Wash Guidelines

### Application Methods:

**Sew-on or heat seal.** The manner in which embroidered blanks can be attached to garments or other textile products relates directly to the type of backing used in the manufacturing process, the size of the blanks and the types of materials that the emblems will be attached to. Almost all emblems can be sewn on, and when it comes to heat seal application, smaller emblems are easier to work with. The chart below outlines the application options relative to backing types.

backing type	sew on application	hand application	hand iron application	heat seal application	temperature	pressure	cycle time
hi-melt glue	yes	no	no	yes	385°F to 405°F (196°C to 207°C)	80 PSI *	15 to 20 seconds
low-melt glue	yes	no	no	yes	365°F to 385°F (185°C to 196°C)	80 PSI *	15 to 20 seconds
non-woven material (no glue)	yes	no	no	no			

\* These recommended settings are based on manually operated or air operated heat seal machines with top iron heat only.

### Heat Seal Notes & Tips:

- Emblems should be heat sealed to the garment using a complete cycle time on both the front side and the back side of the garment and emblem. Emblems with heavier embroidery may require longer heat seal application cycle times beyond the ranges noted above.
- **Thicker fabrics** may require longer cycle times beyond the ranges noted above.
- **Covering the emblem** with a sheet of Teflon® or paper towel prior to the heat seal cycle may help to reduce a “crushing” affect, and may help to protect the garment from scorching.
- **White materials** (knits or blends) may scorch if heat seal temperatures are too high. It is recommended that fabrics be tested first.
- **Pique knit and fleece** materials may be sensitive to heat and pressure, with the possibility of being crushed.
- **Rib-knit and stretch fabrics** may pucker or distort when emblems are heat sealed to them. It is recommended that these fabrics be tested first. For items such as toques and scarves, it is recommended to have emblems sewn on rather than heat sealed.
- **Terry knit materials** such as towels and bathrobes may not provide a smooth enough surface for proper heat seal application. It is recommended that emblems be sewn on to these types of products.
- **Treated fabrics** finished with coatings, sizing or repellants may not allow for proper heat seal bonding.
- Items made with leather, suede, nylon, synthetics, nylon-shell, interlinings, rubberized coatings and reflective fabrics, such as jackets and luggage, may react poorly to heat seal temperatures depending on thickness, weave, texture and weight. It is recommended that these fabrics be tested first, with possible heat seal time and temperature adjustments. In many cases, it may be better to have emblems sewn on to these materials.
- **Caps** can sometimes be difficult to work with for heat seal applications. To achieve a higher potential for heat seal application success on caps, it is recommended that emblems not be greater than 2-1/4” in height and 4” in width.

### Washing & Drying Guidelines:

backing type	wash / dry type			
	industrial*	commercial	dry clean	home*
hi-melt glue	sew on / heat seal	sew on / heat seal	sew on / heat seal	sew on / heat seal
low-melt glue	sew on	sew on	sew on / heat seal	sew on / heat seal
non-woven material (no glue)	sew on	sew on	sew on	sew on

\*It is recommended not to expose heat sealed emblems to wash conditions exceeding 200°F (95°C).

## Ordering Guidelines

### Artwork & Set-up Fees:

**No fees\***. Artwork is not required for standard and common blank sizes and shapes (see price guide). Emblemtek will provide artwork on new custom blank orders for customer Approval prior to production. There are no artwork or set-up fees.

### Order Quantities:

The minimum order quantity is **500 pieces**. Stock and hold programs and agreements are available.

### Pre-production Samples:

**Available \$**. Electronic (scan) or physical pre-production samples (single unit) are available for standard, common blank sizes and approved custom sizes. Samples fees are applicable, relative to blank size and custom design. See price guide for more information.

### Pricing:

**ExtremeBlanks™** are custom quoted based on size, shape, order quantity and complexities. A Customer Service Representative will guide you through the evaluation process for custom materials, to determine required specifications and volumes. Extra charges may apply to track, convert, prepare and store these materials.

### Delivery Times:

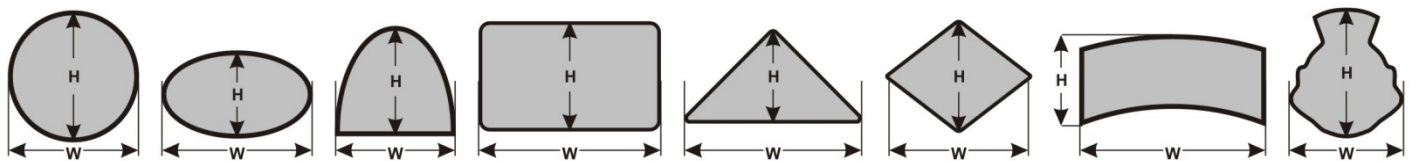
Delivery times are relative to blank size, order quantity and the use of special materials. See price guide for more information. Stock and hold programs and agreements are available.

### Ordering Guidelines:

**Order specifics**. There are specific details that we require in order to proceed with your order, such as:

- Fabric Colour • Border Colour • Dimensions • Backing Type • Quantity • Special Delivery Needs

Blank sizes are based on the maximum height and maximum width of the blank area.



## Accepted Design / Artwork File Types:

The chart below lists the various graphic and design file types that Emblemtek will accept for artwork and production purposes. Certain file types are preferred as noted.

### Graphic File Types:

- CorelDraw ver.13 / ver.X3 (.cdr) **pref**
- Adobe Illustrator ver.CS3 (.ai) **pref**
- Encapsulated PostScript (.eps) **pref**
- Adobe Portable Document File (.pdf) **pref**
- Joint Photographic Experts Group (.jpg) **pref**
- Portable Network Graphics (.png) **pref**
- Adobe Photoshop ver.CS3 (.psd)
- Corel Photo-Paint ver.13 / ver.X3 (.cpt)
- Targa Bitmap (.tga)
- Tagged Image File Format (.tiff)
- Windows Bitmap (.bmp)
- CompuServe Bitmap (.gif)

### Embroidery File Types:

- Tajima Stitch File (.dst) **pref**
- Wilcom EMB File (.emb) **pref**
- Pulse Embroidery File (.pxf)
- Tajima TBF File (.tbf)
- Barudan Stitch File (.dsb)
- Melco Expanded File (.exp)

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