



SimBroidery™ Emblems [ESB]

Technical Specifications
rev. 2011-02b

Product Details

Emblem Dimensions:

- **Minimum** emblem size is 0.5" x 0.5" (1.27cm x 1.27cm).
- **Maximum** emblem size is 13.00" x 17.50" (33.02cm x 44.45cm).

Design Letting Dimensions:

Embroidered text within a design should not be less than 4mm (0.16") in height. Any lettering that is to be cut-out should not be less than 6mm (0.24") in height. Some smaller text or detail font styles may need to be altered in order to be embroidered or cut properly. For designs requiring a lot of small text, Woven Emblems or printed emblems may be a viable alternative.



Fabric Type & Colours:

100% polyester twill. 45+ colours to choose from.

The fabric content is 100% polyester twill, constructed for embroidery processes. Choose from over 45 standard colours, which can be found on the [Emblemtek Embroidered Emblem Fabric Chart](#). GloDark™ and HiVis™ emblems are also made with 100% polyester materials.

Thread Type & Colours:

100% polyester. 120+ colours to choose from. 15 colours per design maximum.

Emblemtek uses 100% polyester Madeira Polyneon™ thread. Choose from over 120 standard colours, which can be found on the [Emblemtek Embroidered Emblem Thread Chart](#). A maximum of 15 thread colours can be chosen per design. Extra charges are applicable when using metallic or glow-in-the-dark threads.

Border / Edge Styles:

3 styles. SimBroidery™ Emblems are characterized by the intricate cutting details both around and inside the design. When cut to shape and heat sealed to garments, the fully embroidered designs with interior cuts can take on the appearance of simulated direct embroidery. SimBroidery™ Emblems may be heat-cut or laser-cut. Emblems can be finished with a **stitched edge**, **no border** or **fabric edge**.



Backing Types:

2 options. Hi-melt glue • low-melt glue

Design / Emblem Treatment Options:

Emblem treatment options such as **3D-puff** embroidery stitching or **double-sided** emblem are **not** available for SimBroidery™ Emblems.

Accessory Attachment Options:

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

Application & Wash Guidelines

Application Methods:

Heat seal. Due to the intricate shapes of many SimBroidery™ emblems, and the concept of simulating direct embroidery, it is highly recommended that these emblems be heat seal applied. It may be possible to sew on certain emblems if the sizes and details allow for easy manipulation, however heat seal application is still the preferred method.

The manner in which embroidered emblems 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 emblems and the types of materials that the emblems will be attached to. 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

* 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	heat seal	heat seal	heat seal	heat seal
low-melt glue	not recommended	heat seal	heat seal	heat seal

*It is recommended not to expose heat sealed emblems to wash or drying conditions exceeding 200°F (93°C).

Ordering Guidelines

Artwork & Set-up Fees:

No fees*. Emblemtek will provide artwork on new emblem orders for customer Approval prior to production. There are no artwork or set-up fees when existing, electronic or physical designs or samples are provided to Emblemtek. Artwork fees may apply when designs are created from scratch.

Order Quantities:

Minimum 100. The minimum order quantity is 100 pieces.

Pre-production Samples:

Available \$. Electronic (scan) or physical pre-production samples (single unit) are available for approved designs. Samples fees are applicable, relative to design detail and emblem size. See price guide for more information.

Pricing:

Quoted. Prices are quoted.

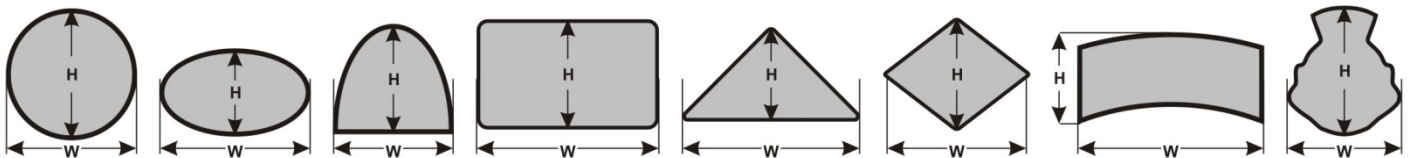
Delivery Times:

Delivery times are relative to order quantity and accessory options if chosen. Emblems greater than 6.00" x 6.00" (15.24cm x 15.24cm) may take longer to manufacture. See price guide for more information.

Ordering Guidelines:

Order specifics. During the design, artwork and ordering processes, there are specific details that we require in order to proceed with your request, such as: Emblem Type • Design Colours • Fabric Colour • Dimensions • Backing Type • Quantity • Special Delivery Needs

Emblem sizes are calculated by adding the height (h) and the width (w), then dividing by two. Example 2" (h) + 4" (w) = 6 divided by 2 = 3.



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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