



UltraPrint™ Emblems [EUP]

Technical Specifications
rev. 2011-03a

Product Details

Emblem Dimensions:

- **Minimum** emblem size is 1" x 1" (2.54cm x 25.4cm) – without merrow border.
- **Minimum** emblem size is 1" x 2" (2.54cm x 50.8cm) – with merrow border.
- **Maximum** emblem size is 13.00" x 17.50" (33.0cm x 44.5cm).
 **Take note that the maximum size of the emblem may be restricted to the size of the heat seal machine for heat seal application.
 **If larger sizes are required, please consult with a Customer Service Representative for possibilities.

Design Lettering Dimensions:

The text within a design should not be less than 1.5mm (0.06") in height – the equivalent to 7pt font size. Smaller text may need to be altered to print slightly larger.



Fabric Type & Colours:

100% polyester fabric finished with a heat seal backing.

Type	Colour	Description	Merrow Border	Heat Seal	Sew-On
Type 1	White PF8-01W	"Thin"	Not Possible	Yes	Not Possible
Type 2	White PF8-02W	"Thick"	Yes or No	Yes	Yes

Design Colours:

UltraPrint™ Emblems can be produced with a multitude of **standard** colours, which can be found on the [Emblemtek UltraPrint™ Colour Chart](#). Custom colours can also be created to **closely match most** referenced Pantone® colours or provided samples. High quality photo-realistic images will be produced as is, without colour manipulation.

Backing Types:

High-melt glue. UltraPrint™ Emblems are manufactured with high-melt glue backing only.

Border / Edge Styles:

2 options merrowed border • no border

Emblems produced on Type 1 "Thin" material **cannot** be finished with a merrow border. Type 2 "Thick" material **can** be finished with or without a merrow border. 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 ([see page 2](#)).



**Printed Border:

Alternatively, as part of the actual design, UltraPrint™ emblems can be produced with a printed border.

Merrow Border Thread Type & Colours:

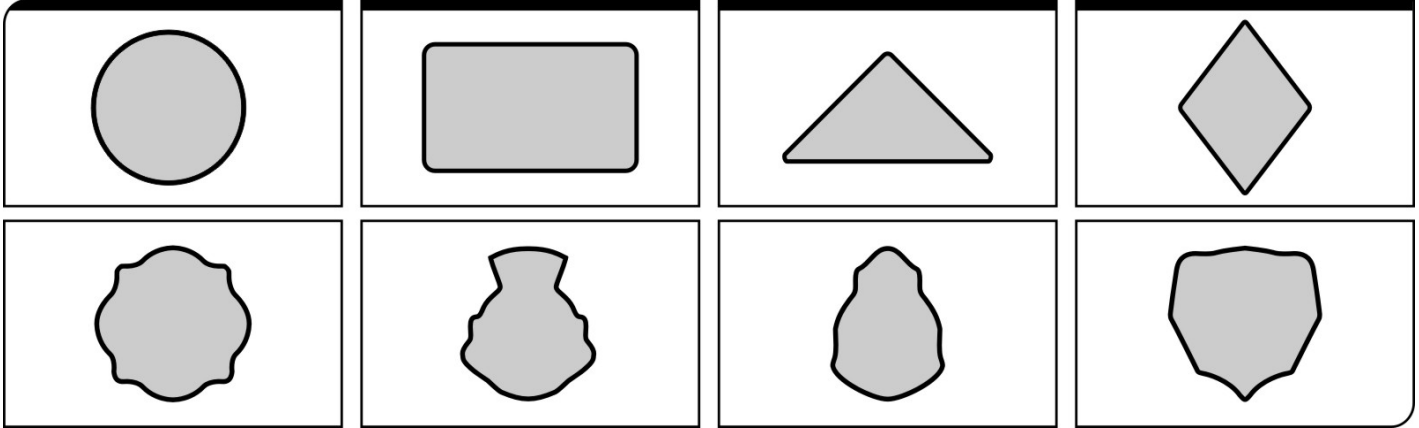
100% polyester. 120+ colours to choose from.

For merrow borders, Emblemtek uses 100% polyester Madeira Polyneon™ thread. Choose one colour of thread for the merrowed border from the [Emblemtek Embroidered Emblem Thread Chart](#). Extra charges are applicable when using metallic thread. Glow-in-the-dark threads are not available.

Merrow Border Limitations:

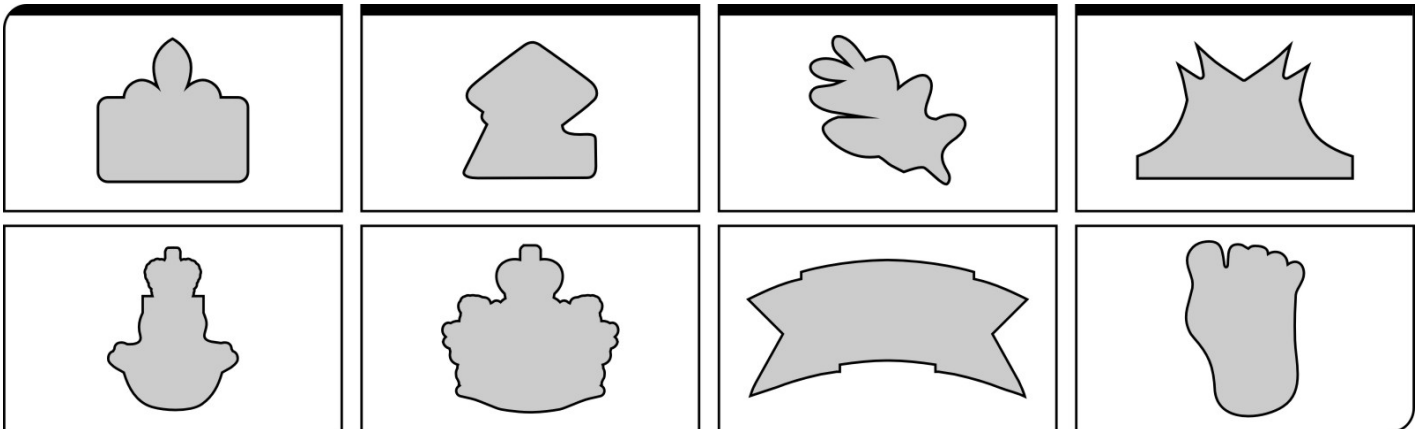
As noted above, UltraPrint™ Emblems can be manufactured with merrowed borders if produced on Type 2 “Thick” material. The edges of the emblem are guided through a surging, over-lock sewing machine by hand, and a heavy stitching is applied. Shapes with edges that are completely open and “exterior” are more easily merrowed. However, odd, intricate shapes with edges that angle back towards the interior of the emblem, generally cannot be merrowed.

Shapes that can be merrowed.



Shapes that cannot be merrowed.

Images are not to size.



Application & Wash Guidelines

Application Methods:

Sew-on or heat seal. The manner in which 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. 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	375°F (190°C)	20 PSI *	10 to 12 seconds

[^]Only emblems produced with Type 2 “Thick” material can be sewn on to garments.

* 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

[^]Only emblems produced with Type 2 “Thick” material can be sewn on to garments.

*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 25. The minimum order quantity is 25 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:

Charted & quoted. Charted pricing is available up to a certain size threshold, with larger quantities and larger emblem sizes custom quoted. See price guide for more information.

Delivery Times:

Delivery times are relative to order quantity, size and cutting detail. Emblems greater than 6.00" x 6.00" (15.24cm x 15.24cm), and emblems with intricate cutting requirements, may take longer to produce. 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 • **Thin or Thick Material** • Border Type & Colour • Dimensions • Quantity • Special Delivery Needs

Accepted Design / Artwork File Types:

Emblems are printed using a superior resolution that provides levels of clarity, sharpness and details not possible with other product type. Full process color mode and intricate cut shapes with no additional cost. The higher the resolution of the provided art will ensure the better output. 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)

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