



- **Heatseal Film - HSF-5256** is a polyester based thermoplastic adhesive film used to permanently bond badges or appliqué to garments. Heatseal produces a durable bond with excellent washing and dry cleaning resistance up to 60°C.

- **To seal a badge or emblem:** Place the Heatseal face down on the reverse of the badge ensuring the paper backing remains between the heat source and the film to avoid sticking. Bond lightly using a heat press or iron. Heat press temperature setting 170°C, 0 - 1 bar for 5 seconds or iron at a high temperature, 3 points without steam, for 5 seconds on each side.

- **To adhere a badge or appliqué to a garment:** Follow previous step, then peel off the release paper and position onto the garment. Cover with a clean cloth and heat press or iron. Heat press temperature setting 160°C - 200°C at 2.8 - 4.2 bar (40 - 60 psi) for 15 - 20 seconds. Alternatively iron on both sides at a high temperature, 3 points without steam, for 15 - 20 seconds.

- Bonding conditions will vary between different machinery and fabrics. Always run tests before production to establish optimal bonding conditions.

- Heatseal film achieves its full adhesive force after 48 hours and will be reactivated each time it is ironed. The film will adhere to most fabrics, those containing cotton will have the best results.

- Heatseal film is compliant with OEKO-TEX® standard 100 Class I certification and is therefore suitable even for use on baby items.

Learn more:

Punch Book - Digitising for Embroidery design by Bonnie Nielsen

For more information go to www.madeira.co.uk

Madeira Embroidery Training Courses contact: training@madeira.co.uk

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