



## HEAT SEAL INSTRUCTIONS

These are basic guidelines. Not all heat presses are the same. The key is to not over heat the patch. Over heating will cause the patch surface to melt, or cause the heat seal backing to over liquify and lose effectiveness. Merrow borders will flatten when heat pressed. Testing on safety garments is recommended.

### FOR USE ON:

Cotton, 100% polyester, poly/cotton blends, acrylics, fleece, and wool. Will not work on nylon.

### EMBROIDERED PATCHES:

TEMPERATURE: 300° - 350°F

PRE-HEAT: 10 - 15 seconds

PRESSURE: Medium / Firm

TIME: 15 - 25 seconds

COMMENTS: Place light weight press-cloth over patch. Allow to cool thoroughly.

### WOVEN PATCHES:

TEMPERATURE: 275° - 300°F

PRE-HEAT: 10 - 15 seconds

PRESSURE: Medium / Firm

TIME: 20 - 30 seconds

COMMENTS: Place light weight press-cloth over patch. Allow to cool thoroughly.

### TACKLE TWILL PATCHES:

#### FOR COTTON FABRICS:

TEMPERATURE: 350° - 400°F

PRE-HEAT: 10 seconds

PRESSURE: Medium / Firm

TIME: 30 seconds

COMMENTS: Place light weight press-cloth over patch. Allow to cool thoroughly.

#### FOR POLYESTER FABRICS:

TEMPERATURE: 325° - 350°F

PRE-HEAT: 10 seconds

PRESSURE: Medium / Firm

TIME: 30 seconds



## HEAT SEAL INSTRUCTIONS



**MADE IN THE USA LEATHER PATCHES**



### **REAL LEATHER AND FAUX LEATHER:**

As with any machine, proper setup will yield the best results.

Ensure that the top head of the press is not loose, crooked, or otherwise out of alignment with the bottom platen. The top and bottom platen should align with each other when in the closed position, with no overlap at the bottom (closest to the operator) of the platen.

Using the GEOKnight DK7 Cap Press with the DKA-35BHT attachment is highly recommended for leather patch application on headwear and other garments as the heat source is provided from below the garment. Top heat application is acceptable with the correct silicone/Teflon covering over the patch however; excessive heat to the face of the patch may result in discoloration of your genuine leather patch.

Top heat application using the DK7 = 100°

Bottom heat from the DKA-35BHT attachment = 315°-325°

Depending on the material of you cap, dwell time can range from 20-35 seconds. Thinner material like unstructured cotton caps will need less dwell time than a structured, acrylic/wool blend.

The pressure applied to the front of the cap for application of the patch needs to be just enough to press, but not enough to push.

If you are experiencing “press marks” on your headwear, further fine tuning of the machine is necessary.

**TIP:** Ensure that the sweatband of the cap is pulled out to reduce the amount of material in contact with the platen.