

# Woven Emblems

TekSpec®  
Product technical details



-  Industrial
-  Dry-clean
-  Heat seal
-  Sew-on
-  Velcro®
-  PS backing
-  Removable



## PRODUCT DETAILS

### Emblem Dimensions:

- **Minimum** emblem size is **0.40" x 0.40"** (10mm x 10mm) – without merrow border.
- **Minimum** emblem size is **0.80" x 0.80"** (20mm x 20mm) – with merrow border.
- **Maximum** emblem size is **16.30" x 16.30"** (414mm x 414mm).

### Design Lettering Dimensions:

The text within a design should not be less than 2mm (0.08") in height. Smaller text may need to be altered. For designs requiring a lot of small text, printed emblems may be a viable alternative.



### Thread Type & Colours:

**100% polyester. 8 colours per design maximum.**

Woven Emblems are made with 100% polyester threads. Choose up to a maximum of 8 thread colours, which can be referenced from the Pantone® matching system. Since Woven Emblems are 100% woven, design background colours should be included in the number of colours chosen. Extra charges are applicable when using metallic threads. Glow-in-the-dark threads are not available for this product.

### Border / Edge Styles:

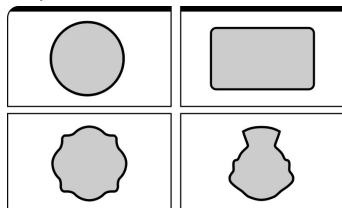
**2 options.** Merrowed border • no border  
Woven Emblems can be manufactured with or without merrowed borders. Choose one colour of thread for the merrowed border, which can be referenced from the Pantone® matching system. Extra charges are applicable when using metallic threads.



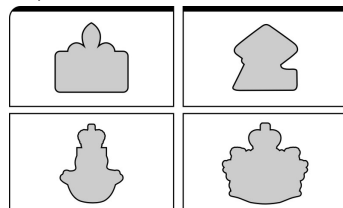
### Merrow Border Limitations:

The ability to sew a merrowed border onto an emblem is directly related to the emblem shape. 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.

### Backing Types:

**5 options.** Low-melt glue • pressure sensitive "stick-on" • non-woven material (no-glue) • no backing • Velcro®

### Design / Emblem Treatment Options:

**Double-sided.**

Woven Emblems can also be configured as double-sided to create key-chains or pull-tags. Depending on the shape, double-sided emblems can be created in different formats such as:

- The same design on both sides.
- Two completely different designs on both sides.



### Accessory Attachment Options:

Woven Emblems can be manufactured with a range of attachment options based on the following list. When using accessories, it is highly recommend to apply a low-melt glue backing, which will provide extra stability.

- EWL1.** Grommet
- EWL2.** Grommet & Split-Ring
- EWL3.** Grommet & Chain
- EWL4.** Grommet & Swivel Split-Ring (as pull tag)
- EWL5.** Grommet & Swivel Clasp Hook
- EWL6.** Grommet & Swivel Snap-Hook
- EWL7.** Triangle Clip with Push-Button-Snap



## APPLICATION & WASH GUIDELINES

### Application Methods

**Sew-on, heat seal or stick-on.** 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. 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	HEAT SEAL APPLICATION			SEW ON	BY HAND
Low-Melt Glue	212°F - 248°F (100°C - 120°C)	80 PSI (5.5 Bar)	10 - 15 seconds	✓	✗
Velcro®		✗		✗	✓
Pressure Sensitive "Stick-On"		✗		possible	✓
Non-Woven Material (No Glue)		✗		✓	✗

### 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	WASH TYPE	WASH TEMPERATURE	DRY TYPE
Low-Melt Glue	Commercial	Wash in domestic or commercial machine in water <b>not exceeding 140°F (60°C)</b>	Tumble dry at low heat <b>not exceeding 130°F (55°C)</b>
Velcro® Pressure Sensitive "Stick-On"	Home Care	Wash gently by hand in water <b>not exceeding 86°F (30°C)</b> .	NO machine dry
Non-Woven Material (No Glue)	Industrial (Sew-On Application)	Wash in commercial machine in water <b>not exceeding 200°F (93°C)</b>	Tumble dry at high heat <b>not exceeding 167°F (75°C)</b>

It is recommended not to expose heat sealed emblems to wash or drying conditions exceeding **200°F (93°C)**. Emblems with accessory attachment options should be exposed to hand washing only.

## 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, including emblems with Velcro® or pressure sensitive “stick-on” backings, and emblems with accessory attachment options.

### 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:

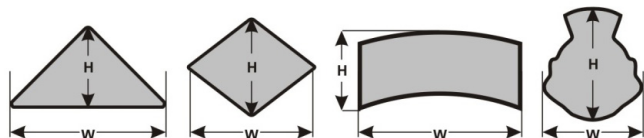
Delivery times are relative to order quantity and accessory options if chosen. Emblems greater than 6.00” x 6.00” (15.24cm x 15.24cm) may take longer to manufacture. See price guide for more information.

### 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 • Border Type • Border 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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