

# TekSpec<sup>®</sup>

## Twill Emblem Blanks

Twill blanks for text emblems, printed emblems and name bars.



Industrial



Dry-clean



Heat seal



Sew-on



Removable



BLOCK  
font



Script  
font



## PRODUCT DETAILS

### Blank Dimensions:

See price guide for a list of standard, common and custom blank sizes.

- **Minimum** blank size is **1.0" x 2.0"** (2.5cm x 5.1cm).
- **Maximum** blank size is **12.0" x 16.0"** (30.5 cm x 40.6 cm).

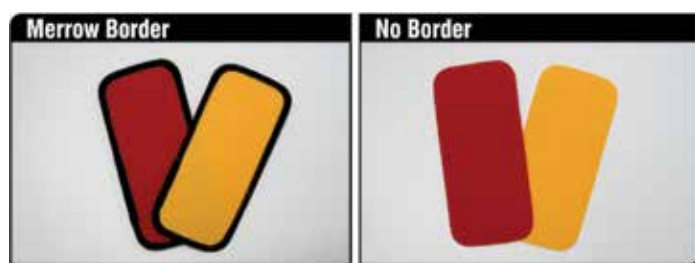
### Fabric Type & Colours:

**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. **White, code #300** fabric is also suitable for sublimation transfer application. Reflective and Flame Resistant materials are also **available**. Please refer to the Emblemtek Reflective Fabric Chart and the Emblemtek Flame Resistant Fabric Chart. Felt and glow-in-the-dark materials are **not available** for blanks.

### Border / Edge Styles:

**Merrow border.** Standard and common size Embroidered Blanks are manufactured with merrowed borders, a separately stitched over-lock edge.



### Thread Type & Colours for Merrow Borders:

**100% polyester. 120+ colours to choose from.** Emblemtek uses 100% polyester Madeira Polyneon™ thread for Merrow borders. Choose from over 120 standard colours, which can be found on the Emblemtek Embroidered Emblem Thread Chart. Extra charges may be applicable when using metallic threads.

### Custom Fabrics & Threads:

Refer to the ExtremeBlanks® TekSpec® for custom fabric and thread options.

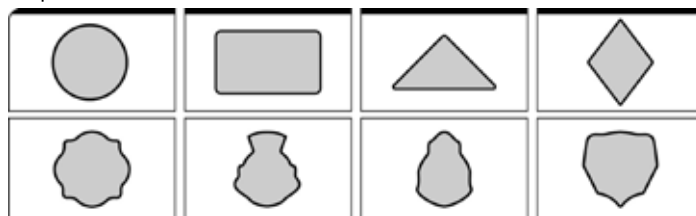
### Backing Types:

**3 options.** Hi-melt glue • low-melt glue • non-woven material (no-glue) Velcro®, pressure sensitive “stick-on” and soft magnet backings are not available for blanks.

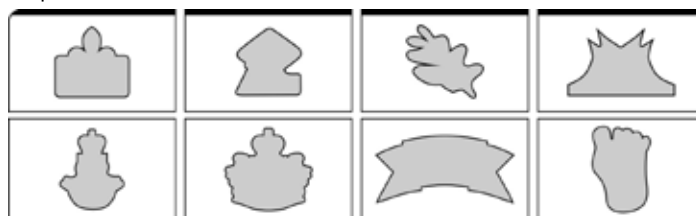
### Merrow Border Limitations:

As noted above, Embroidered Blanks are manufactured with merrowed borders. 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.

### Accessory Attachment Options

Accessory options, such as button loops, snaps, rings, etc..., are **not available** for blanks.

## APPLICATION & WASH GUIDELINES

### Application Methods







**Sew-on or heat seal.** 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
Hi-Melt Glue	385°F - 405°F (196°C - 207°C)	80 PSI (5.5 Bar)	15 - 20 seconds	✓	✗
Low-Melt Glue	365°F - 385°F (185°C - 196°C)	80 PSI (5.5 Bar)	15 - 20 seconds	✓	✗
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 TYPE	WASH TYPE	WASH TEMPERATURE	DRY TYPE
Hi-Melt Glue	Industrial	Wash in commercial machine in water <b>not exceeding 176°F (80°C)</b> 	Tumble dry at medium heat <b>not exceeding 150°F (65°C)</b> 
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> 
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).

## ORDERING GUIDELINES

### Artwork & Set-up Fees:

**No fees\*.** Artwork is not required for standard and common blank sizes and shapes (see price guide). Emblemtek will provide artwork on new custom blank orders for customer Approval prior to production. There are no artwork or set-up fees.

### Order Quantities:

**Standard & Common Sizes:** The minimum order quantity is **25 pieces**.

**Custom Sizes:** The minimum order quantity is **25 pieces**.

### Pre-production Samples:

**Available \$.** Electronic (scan) or physical pre-production samples (single unit) are available for standard, common blank sizes and approved custom sizes. Samples fees are applicable, relative to blank size and custom design. See price guide for more information.

### Pricing:

**Charted & quoted.** Charted pricing is available for standard, common and custom blank sizes. Some very large blanks and blanks with reflective and flame resistant materials, or metallic merrow thread, may be custom quoted. See price guide for more information.

### Delivery Times:

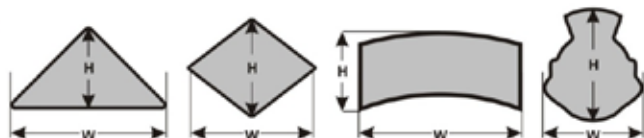
Delivery times are relative to blank size, order quantity and the use of special materials. See price guide for more information.

### Ordering Guidelines:

**Order specifics.** There are specific details that we require in order to proceed with your order, such as:

Fabric Colour • Border Colour • Dimensions • Backing Type • Quantity • Special Delivery Needs

Custom blank sizes are calculated in square inches, by multiplying the height (h) and the width (w) of the emblem. Example 5" (h) x 7" (w) = 35 square inches.



### 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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