

HiTranz[®] Poly Garment & Textile Transfers

TekSpec[®]
Product technical details



  
Industrial Dry-clean Heat seal

PRODUCT DETAILS

Transfer Dimensions:

- **Minimum** transfer size is **0.5" x 0.5"** (1.27cm x 1.27cm).
- **Maximum** transfer size is **18" x 25"** (45.7cm x 63.5cm).

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 to transfer slightly larger.



Substrate Type:

100% polyester clear carrier.

Design Colours:

Choose up to a maximum of 6 colours.

Colours can be referenced from the Pantone® matching system.

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 50. The minimum order quantity is 50 transfers.

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 transfer sizes custom quoted. See price guide for more information.

Delivery Times:

Delivery times are relative to order quantity. 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:

Transfer Type • Design Colours • Dimensions • Quantity • Special Delivery Needs

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)



To request a quote,
please visit
emblemtek.com/quote



To request literature and samples,
please visit
emblemtek.com/samples

APPLICATION & WASH GUIDELINES

Application Methods

Heat seal. HiTranz® Garment and Textile Transfers can be heat sealed on to garments and other textile products using a heat seal machine.

HITRANZ® TRANSFER TYPE	HEAT SEAL APPLICATION		
HiTranz® Poly HiTranz® PolyAS HiTranz® PolyFR	320°F to 356°F (160°C to 180°C)	65 to 80 PSI (4.5 to 5.5 Bar)	12 to 15 seconds

These recommended settings are based on manually operated or air operated heat seal machines with top iron heat only.

Heat Seal Notes & Tips:

Place the garment or textile on the bottom platen of the heat seal machine and ensure that the area that is to be transferred is as flat and smooth as possible. Place the transfer carrier over the area to be transferred and position the transfer so that the design is aligned to the garment or textile as required. Cycle the heat seal machine based on the temperature, pressure and time settings noted above. When the heat seal cycle is complete, remove the transfer carrier slowly from the garment or textile while still warm.

Due to the diverse nature of fabrics and textiles in the market place, customers are advised to carry out application, wash and any technical tests (including flame retardant) prior to placing orders.

- **Thicker fabrics**, which may absorb excess heat, may require longer cycle times as charted above.
- **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 transfer are heat sealed to them. Transfers may not apply correctly to items such as toques and scarves. It is recommended that these fabrics be tested first.
- **Terry knit materials** such as towels and bathrobes may not provide a smooth enough surface for proper heat seal application.
- **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.
- **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 transfers not be greater than 2-1/4" in height and 4" in width.

Washing & Drying Guidelines

HITRANZ® TRANSFER TYPE	WASH TYPE	WASH TEMPERATURE	DRY TYPE
HiTranz® Poly HiTranz® PolyFR	Industrial	Wash in commercial machine in water not exceeding 203°F (95°C)	Tumble dry at medium heat not exceeding 150°F (65°C)
HiTranz® PolyAS	Industrial	Wash in commercial machine in water not exceeding 185°F (85°C)	Tumble dry at medium heat not exceeding 150°F (65°C)



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info@emblemtek.com

For complete product details, please visit
emblemtek.com/tekspec/

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Client: Polymark (GB) Ltd
Sopwith Way
Drayton Fields
Daventry
Northants
NN11 8PB

Entry No: 50737-02

TEST CERTIFICATE

Job Title: EN ISO 11611:2007

Date Received: 8th May 2012

Date Tests Completed: 12th June 2012

Client's Description: Polytrans FR ('3') applied to the following:
FABRIC: Megatec 250N
FINISH: Proban® flame retardant – WOR – Antistatic (0148 88)

Performance Standard: Testing to EN ISO 11611:2007
Clause 6.7 Flame spread procedure A (surface ignition)

Pre-treatment: Tests were made after 5 washing cycles at 75°C using Procedure 8 specified in ISO 15797:2002 Drying Procedure A. The tumble drying was carried out after the completion of each wash (subcontracted to another UKAS Accredited Laboratory).

N.B. The machine used for washing the above samples has a larger cage volume and cage diameter than the machine specified in ISO 15797:2002

In accordance with Annex C of EN ISO 11611 the uncertainty of measurement associated with the test methods was not taken into account

Clause	Test Method	EN ISO 11611 Requirement & Performance Levels	Results	Pass/Fail or Class
6.7 Flame spread (procedure A)	ISO 15025:2000	Class 1 & 2: No flaming to top or side edge No hole formation No flaming or molten debris Mean afterflame ≤ 2s Mean afterglow ≤ 2s	<u>Procedure A</u> No flaming to top or side edge No hole formation No flaming or molten debris No afterflame No afterglow	PASS Class1 & Class 2

-----End of Document-----

This is hereby certified to be a correct return of the tests made of the items referred to herein.



H Mackereth

Helen Mackereth
Senior Technician
13th June 2012

- ❖ Unless instructed otherwise by the client sample remnants will be disposed of after 28 days
- ❖ Test marked (*) in this certificate are not included in the UKAS Accreditation Schedule for this Laboratory.
- ❖ Opinions and interpretations expressed herein are outside the scope of UKAS accreditation.
- ❖ This Certificate relates only to the sample received and, unless that sample has been drawn by the staff of this laboratory, or its agent, and endorsed accordingly, any application of the result to a bulk quantity or other material is entirely the responsibility of the client.





Client: Polymark (GB) Ltd
Sopwith Way
Drayton Fields
Daventry
Northants
NN11 8PB

Entry No: 50737-03

TEST CERTIFICATE

Job Title: EN ISO 11612:2008

Date Received: 8th May 2012

Date Tests Completed: 12th June 2012

Client's Description: Polytrans FR ('3') applied to the following:
FABRIC: Megatec 250N
FINISH: Proban® flame retardant – WOR – Antistatic (0148 88)

Performance Standard: Testing to EN ISO 11612:2008
Clause 6.3 Limited flame spread (A1 surface ignition)

Pre-treatment: Tests were made before and after 5 washing cycles at 75°C using Procedure 8 specified in ISO 15797:2002 Drying Procedure A. The tumble drying was carried out after the completion of each wash (subcontracted to another UKAS Accredited Laboratory).

N.B. The machine used for washing the above samples has a larger cage volume and cage diameter than the machine specified in ISO 15797:2002

In accordance with Annex G of EN ISO 11612:2008 the uncertainty of measurement associated with the test methods was not taken into account.

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This is hereby certified to be a correct return of the tests made of the items referred to herein.



H Mackereth

Helen Mackereth
Senior Technician
13th June 2012

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**West Yorkshire
Materials Testing
Service**

PO Box 5, Morley, LS27 0QP
Nepshaw Lane South, Morley, Leeds
Tel 0113 253 0241 Fax 0113 252 7029
Head of Laboratory G. Briggs C. Text ATI

Client: Polymark (GB) Ltd
Sopwith Way
Drayton Fields
Daventry
Northants
NN11 8PB

Entry No: 50737-03

Clause	Test Method	EN ISO 11612 Requirement & Performance Levels	Results	Pass/Fail or Level
6.3 Limited flame spread (A1)	ISO 15025:2000	No flaming to top or side edge No hole formation No flaming, melting or molten debris Mean afterflame ≤ 2s Mean afterglow ≤ 2s	Surface ignition as received No flaming to top or side edge No hole formation No flaming, melting or molten debris Mean afterflame = 2 s No afterglow <u>Surface ignition after 5 washing cycles</u> No flaming to top or side edge No hole formation No flaming, melting or molten debris No afterflame No afterglow	PASS

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This is hereby certified to be a correct return of the tests made of the items referred to herein.



1104

H Mackereth

Helen Mackereth
Senior Technician
13th June 2012

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addressee
Polymark (GB) Ltd

our ref.
CR/206_2014

date
2014-01-21

page number
2

tests from EN ISO 14116	requirements	result	pass/fail and level
Index 3	No flaming to the top or either side edge No flaming debris No afterglow shall spread in the undamaged area No hole formation After flame of each individual specimen $\leq 2s$	No flaming to the top or either side edge No flaming debris No afterglow No hole formation No after flame	Pass Index 3

tests from EN ISO 11611	requirements	result	pass/fail and level
flame spread on logo after 5*(60°C 2A + ☐ tumble dry) ISO 6330	Mean after flame ($\leq 2s$) Mean afterglow ($\leq 2s$) in the undamaged area No flaming debris No molten debris No flaming to the top or either side edge No hole formation	No after flame No afterglow No flaming debris No molten debris No flaming to the top or either side edge No hole formation	Pass

tests from EN ISO 11612	requirements	result	pass/fail and level
flame spread on logo after 5*(60°C 2A + ☐ tumble dry) ISO 6330	Mean after flame, ($\leq 2s$) Mean afterglow ($\leq 2s$) in undamaged area No flaming debris No melting or molten debris No flaming to the top or either side edge No hole formation	No after flame No afterglow No flaming debris No molten debris No flaming to the top or either side edge No hole formation	Pass

Detailed results can be found in:

Centexbel: analysis report 13.05561.01 of 2013-12-05

Kristina De Temmerman
By order of Inge De Witte
Certification Manager

Firm: Polymark GB Limited
14 Sopwith Way
Drayton Fields
Daventry
Northants
NN11 8PB

For the attention of: Mr P York

Technical Services Report

Subject: Effects of heat applied transfers on
the EN 1149 parts 1 & 2 properties of a
fabric

Our ref: 63639/0539/SPC-0/DMcK

Your ref:

Date: 13th October 2005

Conditions of Issue:

This report may be forwarded to other parties concerned provided that it is not abbreviated or changed in any way. It must not be published, for example by including it in advertisements, without the prior, written permission of SATRA.

Results given in this report refer only to the samples submitted for analysis and tested by SATRA. Comments are for guidance only and are not part of the reported results. All comments and interpretations are outside the scope of UKAS accreditation and are based on current SATRA knowledge.

A satisfactory test report in no way implies that the product tested is approved by SATRA and no warranty is given as to the performance of the product tested. SATRA shall not be liable for any subsequent loss or damage incurred by the client as a result of information supplied in the report.

Tests marked † are not UKAS accredited.

Introduction

Samples of transfers were supplied in order to assess the effects of heat application on the surface and vertical resistance of a fabric. Test methods EN 1149 parts 1 and 2 were used to measure the surface and vertical resistances of fabric both in the fresh state and after application of the transfers.

Testing was carried out between the 6th and 11th October.

Transfer references:-

- A) "Wurth"
- B) "Culinary theme"
- C) "Large Michelin"
- D) "Small Michelin"

The transfer were applied to a fabric known to have a surface resistivity which complies with EN 1149-1. Application was carried out using a heated press supplied by the client, at a temperature of 180°C and a dwell time of 10 seconds.

Results

Table 1 – Surface resistivity

Specimen	Surface resistance MΩ	Surface resistivity GΩ	Overall Result – against requirements of EN 1149-1:1995 clause 4.1 >50 GΩ
Fabric – no transfers applied	179.9 110.4 7.85 15.4 12.1	3.5 2.1 0.15 0.30 0.23	PASS
Fabric in the proximity of A)	182.6 5.86 25.5 8.54	3.5 0.11 0.50 0.17	PASS
Fabric in the proximity of B)	219 176.3 40.8 7.06 6.22	4.3 3.4 0.79 0.14 0.12	PASS
Fabric in the proximity of C)	8.18 4.25 1.66 22.5 34.5	0.16 0.08 0.03 0.44 0.67	PASS
Fabric in the proximity of D)	15.97 4.90 6.03 15.33 2.82	0.31 0.09 0.12 0.30 0.05	PASS

Table 2 – Vertical resistance

Specimen	Vertical resistance MΩ
Fabric – no transfers applied	112.2
	98.3
	134.5
	98.0
	69.9
	92.7
Fabric in the proximity of A)	139.5
	113.5
	127.6
	105.7
Fabric in the proximity of B)	118.5
	172.4
Fabric in the proximity of C)	82.6
	75.4
	82.2
Fabric in the proximity of D)	64.0
	63.6
	59.5

Conclusions

The presence of the heat applied transfer appears to have had no significant effect on the surface resistivity and the vertical resistance of the fabric used in the exercise.