PennEdge® Custom Emblems

Industrial　Dry-clean　Heat seal　Sew-on　Removable

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PRODUCT DETAILS

Emblem Dimensions
- **Minimum** emblem size is **1.0" x 1.75"** (2.5cm x 4.4cm).
- **Maximum** emblem size is **10.0" x 10.0"** (25.4cm x 25.4cm).

Design Lettering Dimensions
The text within a design should not be less than 4mm (0.16") in height.
Smaller text may need to be altered to embroider slightly larger.
For designs requiring a lot of small text, Woven Emblems or printed emblems
may be a viable alternative.

Fabric Type & Colours
PennEdge® Custom Emblems are a patented product format that uses
various types of shirt-weight materials. Choose from 19 standard colours,
which can be found on the Emblemtek PennEdge® Fabric Chart. The poplin,
poly-cotton, polyester or flame resistant materials are chosen from a select
range of popular workwear and career wear shirts currently available from
leading uniform textile manufacturers.

Thread Type & Colours
**100% polyester. 120+ colours to choose from. 15 colours per design
maximum.** Emblemtek uses 100% polyester Madeira Polyneon™ thread.
Choose from over 120 standard colours, which can be found on the
Emblemtek Embroidered Emblem Thread Chart. A maximum of 15 thread
colours can be chosen per design, including the border.

Backing Types
3 options. Hi-melt glue • low-melt glue • non-woven material (no-glue)

Border / Edge Styles
Stitched border. PennEdge® Custom Emblems are produced in combination
with thinly stitched, colour coordinated embroidered borders as part of
the design element. When heat sealed or sewn onto matching workwear
shirts, the emblems blend into the garment resulting in a simulated direct
embroidery look.

Design / Emblem Treatment Options

Watermarks and background.
Other design elements can be introduced to the embroidery, such as
watermarks and background stitch patterns.

Watermarks	Background stitch pattern
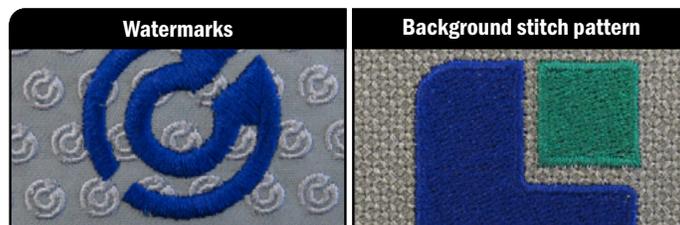
Other emblem treatment options such as **3D-puff** embroidery stitching or
double-sided emblem are **not** available for PennEdge® Custom Emblems .

Accessory Attachment Options
Accessory options, such as button loops, snaps, rings, etc..., are **not** available
for PennEdge® Custom Emblems.

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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 <u>type of backing</u> used in the manufacturing process, <u>the size</u> of the emblems and the <u>types of materials</u> 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.

➢ Treated fabrics finished with coatings, sizing or repellants may not allow for proper heat seal bonding.

Washing & Drying Guidelines

BACKING TYPE	WASH TYPE	WASH TEMPERATURE		DRY TYPE	
Hi-Melt Glue	**Industrial**	Wash in commercial machine in water **not exceeding 176°F** *(80°C)*	🧺	Tumble dry at medium heat **not exceeding 150°F** *(65°C)*	⊡
Low-Melt Glue	**Commercial**	Wash in domestic or commercial machine in water **not exceeding 140°F** *(60°C)*	🧺	Tumble dry at low heat **not exceeding 130°F** *(55°C)*	⊡
Non-Woven Material (No Glue)	**Industrial** (Sew-On Application)	Wash in commercial machine in water **not exceeding 200°F** *(93°C)*	🧺	Tumble dry at high heat **not exceeding 167°F** *(75°C)*	⊡

It is recommended not to expose heat sealed emblems to wash or drying conditions exceeding **200°F (93°C)**.

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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 25. The minimum order quantity is 25 pieces.

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 • Fabric Colour • 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.
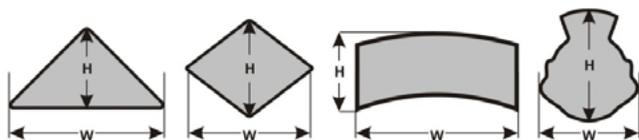
Accepted Design / Artwork File Types
The chart below lists the various graphic and design file types that Emblemtek will accept for artwork and production purposes. Certain file types are preferred as noted.

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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