

# Heat-Sealing Instructions

## Heat Sealing Tips

- In order to achieve the best possible sealing results, the correct setting of all parameters is essential.
- What is the aim of heat-sealing tags? To make the laundry RFID tags stick to the garment for lifespan withstands laundry processes even in the most severe washing processes.
- To make it easy to complete the sewing by using pneumatic or manual operation of the heat sealing machine.

## Technical Advice

- Heat sealing transponder patch proposal is set to **204°C**. The temperature setting is critical because it requires the glue to become fluid within a reasonable time frame.
- The set time is critical since the fluid glue needs to flow into the textile. The standard advised time setting is set to **12 seconds**.
- The standard advice pressure setting is crucial. Because the glue must be pressed into textile material that it can best adhere on the textile material. The standard recommends that the inter-plate thermal pressure imprint must be **0.5kg/cm<sup>2</sup>**, which usually corresponds to 4~5 bars of input air pressure on a pneumatic heat seal press (warning: the conversion rate between input air pressure and inter-plate pressure depends on the heat seal press so as to check your specific user manual).

## Notice

- Heat sealing should be performed on clean and dry items. Heat sealing on soiled and wet items can be done if the position that needs to be marked, is dried under the heat seal press until all moisture is evaporated. After this, the label can be placed and heat sealed, following advised instructions. Using this method can lead to fixation of dirt and other undesired substances into the textile.
- Barrier textiles need special attention.
- An extra cycle with Pre-heating the barrier textiles for 7~10 seconds can amend any attached issues. Position the transponder patch immediately after Pre-heating and seal it into place.
- For specific settings, it is suggested to be tested before starting any production, to establish what the optimal heat sealing settings are for individual types of (barrier) textiles.
- Most issues when sealing tags or transfers are caused by not following the instructions provided or by malfunctioning of the heat seal press.