

BONDED WITH PASSION

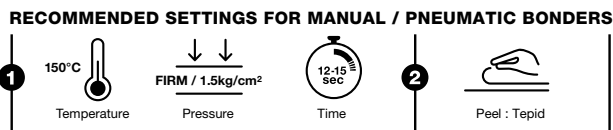
Bonding Instructions

How To bond with a Manual Bonder:

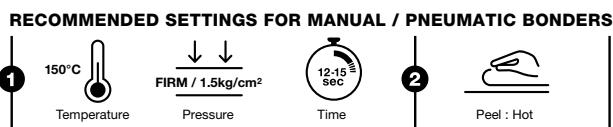
There are 3 factors when it comes to bonding Heat Transfer Labels onto garments using a Manual bonder (Heat Press)

- Temperature
- Pressure
- Time
- Release

All of these elements are of equal importance and can be seen on every bag of Avery Dennison supplied Heat Transfers as follows:



*some items require a hot peel. Please refer to information provided on the bag.



Safety:

First, check that the Bonder (Heat Press) is secure on top of the work surface. Not too close to the edge and better still, to have it mounted to the work top and secured down.

No Damage to the bonding platens:
Ensure there is no damage to the top and bottom platens and check to see that they are level. You can test this with the Avery Dennison “paper test”. Please refer to our instructions on **Bonder Health Checks**

Clean Platens:

Then check that the bonding (top) platen is clean. Looking for any residual ink left over from previous bonding. If it is dirty, then use a damp cloth to clean it or follow bonder manufacturer’s instructions.

Temperature:

Set the temperature using the machine controls. 150 degs C is the Avery Dennison recommended bonding temperature for Polyester football shirts. But do refer to our guide on fabrics and garments to check the correct bonding temperature for a specific type of fabric. You can then adjust the temperature accordingly.

Pressure:

Please ensure that the bonder is set to firm pressure. This is to a level where the operator feels that it is firm pressure but at a level that they can operate with during the day. Too light a pressure on the bonder setting can result in a problem with Heat Transfer adhesion.

Time:

The next step is to check the set time. Normally this is between 12-15 seconds on a manual bonder. You are then ready to press the Heat Transfer onto the garment.

To release the polyester from the Heat Transfer, you should wait until it is at a tepid to cold temperature. When it is, you can simply peel away the polyester backing.*

Bonding:

Next place the garment you are going to bond, onto the lower platen, checking alignment with ruler or an Avery Dennison name and number template.

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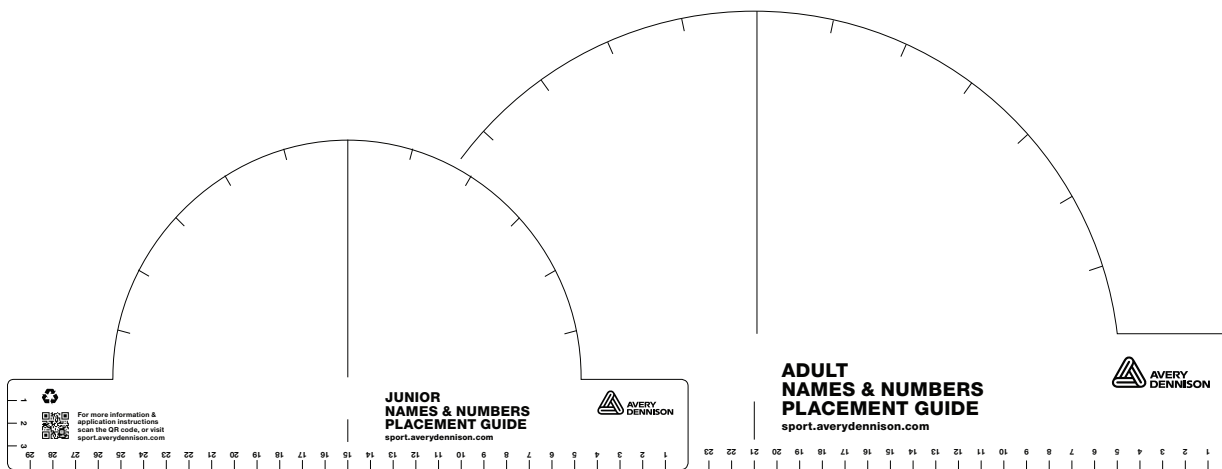
Bonding Instructions

Straight Line Nameblocks:

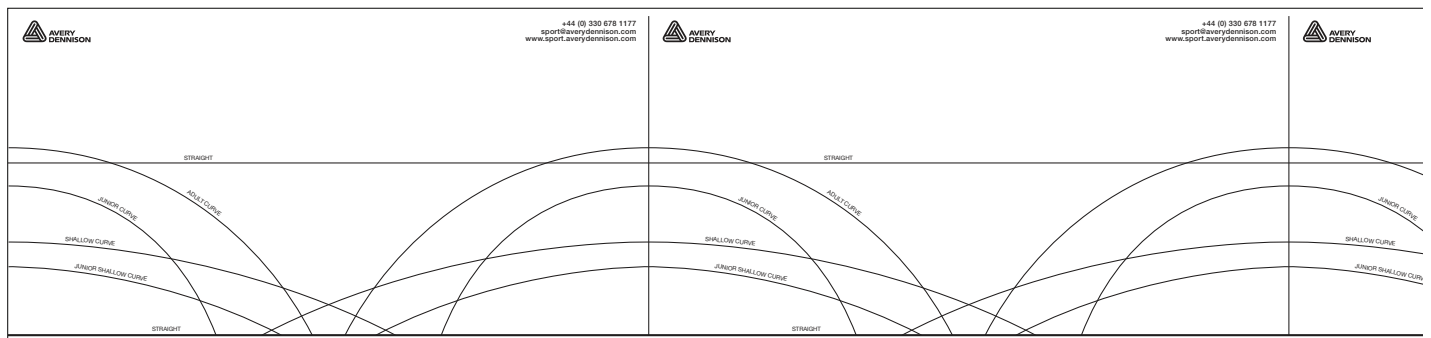
If bonding in a straight line for the nameblock, use a ruler to ensure correct alignment at the bottom of the letters. Measure that the number is at the correct distance from the nameblock and in the middle of the nameblock.

Curved Nameblocks:

If the nameblock is on a curve, please use the Avery Dennison supplied Placement Guide.



Placement Guide Rulers



Placement Guide Adhesive Sheets