

## HAT HEAT PRESS INSTRUCTIONS

While our patches can be heat pressed to any non-nylon apparel, they are most commonly heat pressed to hats. Below are instructions for heat pressing onto hats using a hat press with top & bottom heat. If heat pressing onto apparel, you may need to tweak the time, temp, and pressure depending on the garment material & thickness. If you are experiencing hat wrinkling after pressing on patches, reduce the hold time in 3-5 second increments until the wrinkling stops.

### **EMBROIDERED PATCHES:**

Top Temp: 285° F  
Bottom Temp: 320° F  
Time: 30 seconds  
Pressure: Medium (4-6)  
Notes: Use 1/8th inch Silicon Pad

### **3D PUFF PATCHES:**

Top Temp: 310° F  
Bottom Temp: 320° F  
Time: 40 seconds  
Pressure: Medium (5-6)  
Notes: Use 1/8th inch Silicon Pad

### **MADE IN USA LEATHER**

Top Temp: 285° F  
Bottom Temp: 320° F  
Time: 40 seconds  
Pressure: Medium (4-6)  
Notes: Use 1/8th inch Silicon Pad.  
Do not use thermal tape for placement as it can negatively impact the leather.

### **RUBBER/PVC PATCHES**

Top Temp: 280° F  
Bottom Temp: 320° F  
Time: 30 seconds  
Pressure: Medium (4-6)  
Notes: Use 1/8th inch Silicon Pad.

### **WOVEN PATCHES:**

Top Temp: 280° F  
Bottom Temp: 320° F  
Time: 30 seconds  
Pressure: Medium (4-5)  
Notes: Use 1/8th inch Silicon Pad

### **SUBLIMATED PATCHES:**

Top Temp: 280° F  
Bottom Temp: 320° F  
Time: 30 seconds  
Pressure: Medium (4-5)  
Notes: Use 1/8th inch Silicon Pad

### **MADE IN USA FAUX LEATHER**

Top Temp: 300° F  
Bottom Temp: 320° F  
Time: 35 seconds  
Pressure: Medium (5-6)  
Notes: Use 1/8th inch Silicon Pad.

### **Tips for Heat Pressing Hats**

1. Fold the sweatband down when securing the hat to ensure for better heat transfer.
2. To contour patches to the shape of a hat, place the patches in a paper towel tube for 5-10 minutes prior to application.
3. If the lever that secures the hat during the heat press process does not catch the hat, try tightening the strap/snapback on the back of the hat for a better catch.



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### FELT ON CARRIER PAPER

Place the clear film down and slowly peel the white carrier paper away from the patches and clear film. Keep the patches in place on the clear film.

Place the patches on the hat, so the patches are touching the hat and the clear film is facing up (so the patches are between the hat and clear film). Then place the 1/8th inch silicon pad on the clear film. Then heat press the patches. Remove the silicon pad and clear film once the patches have been heat pressed.

#### **100% COTTON AND BLENDS**

Top Temp: 350° F

Bottom Temp: 320° F

Time: 30 seconds

Pressure: Medium (4-6)

Notes: Use 1/8th inch Silicon Pad.

#### **100% POLYESTER**

Top Temp: 400° F

Bottom Temp: 320° F

Time: 15-30 seconds

Pressure: Medium (4-6)

Notes: Use 1/8th inch Silicon Pad.

Some Poly types cannot withstand 400°F temperatures. Please test before mass production.