

CONVERSION & TROUBLE SHOOTING GUIDE

TEMPERATURE CONVERSION:

To convert Fahrenheit to Celsius (Centigrade) - (F - 32) divided by 1.8

To convert Celsius (Centigrade) to Fahrenheit - (1.8 x C) plus 32

CALCULATING INTERNAL CYLINDER (Piston) AREA:

Check with your manufacturer to determine Piston Diameter and refer to the following table:

Piston Diameter	1 3/4"	2"	2 1/4"	2 1/2"	2 3/4"	3"	3 1/4"	3 1/2"	3 3/4"	4"
Piston Area/Inches	2.4	3.14	3.97	4.91	5.94	7.07	8.29	9.62	11.04	12.56

FORMULA FOR CALCULATING GAUGE PRESSURE:

Barcodes require 20 - 25 lbs. INTER-PLATEN CLAMPING pressure for proper adhesion. For non-Texas Automation equipment you will need to determine the proper amount of air gauge pressure required to meet specifications.

25 lbs. Desired Inter-Platen Pressure X Platen Area Square Inches = Gauge Pressure

Area/Inches Internal Piston

For example:

25	lb. inter-platen pressure
x 16.25	square inches of 3 1/4" x 5" platen
406.25	
÷ 7.07	area of 3" diameter internal piston
57.46	psi pressure

Use 55 - 60 psi air gauge pressure

Fabric Types: There are no specific application rules by fabric type. However, if you are working with fragile fabrics, test application on out-of-service or remnant materials first. Some general guidelines follow:

Nylon: Labels applied to nylon show little dye migration but may not bond as well as to polyester.

Poly/Cotton Blend: The fibers in a poly/cotton blend provide the best application surface. Read **New Garments** section below.

Polyester: Labels applied to polyester may show increased dye migration compared to nylon but improved adhesion.

Wool: Do not apply directly to wool. The combination of temperature and pressure will have a "felting" effect and damage your garment. We recommend folding over the inside lining and applying through lining fabric only.

Lifting Labels: This can be an indication of under application, misapplication or could be caused by a finish on the fabric. Review machine settings. It may be necessary to pre-burn the application area to burn off the finish or garments may require pre-washing. If you are applying to a fabric with a satin finish, we recommend application to the dull side of the fabric if possible for best adhesion. See **New Garments** below.

New Garments: A heavy water soluble finish found on **some** new garments may prevent proper bonding. If labels lift, pre-burn application site for 5 seconds and proceed as above. Pre-washing may be required to resolve problem.

Removing Labels: The CK-2006 label is removable. To do so place your garments back on the heat seal machine and press for approximately 5 seconds. Use caution when removing the label as it will be hot. It may be necessary to use a small edged tool to pull the label away. This must be done quickly as adhesives will reset upon cooling.

Resealing: If label lifts at the edges reseal as above for 5 seconds. You do not need to cover the label.

For more information contact Amber@ipc-tags.com

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