



Instructions are shown below for manual and pneumatic (air) heat seal machines. Please refer to the section that most closely represents your machine and platen size. If you require assistance please contact Amber Nowlin at (817) 714-8400 or by e-mail at Amber@ipc-tags.com.

***Using Manual Model Heat Seal Machines***

**Temperature:** Top Heat: 400° - 410° F Bottom Heat: 330° - 350° F \*\*  
204° - 210° C 165° - 176° C \*\*

**Note:** \* If your machine is not equipped with bottom heat we recommend that you warm the bottom platen during machine warm-up or when the machine has been idle for long periods of time. Pre-warm the bottom platen by pulling the heated top platen down and resting it on the lower platen. It is not necessary to engage pressure.

**Press Time:** Add 2 seconds to these times if you DO NOT have bottom heat.

**Light Garments:** 8 Seconds (Shirts, linings, light jackets, aprons)  
**Heavy Garments:** 10 Seconds (Waistbands, coveralls, heavy jackets)

***Using Texas Automation Air Models  
MS, ES or DES-32 or 42 with 3" cylinder***

**Temperature:** Top Heat: 400° - 410° F Bottom Heat: 330° - 350° F \*\*  
204° - 210° C 165° - 176° C \*\*

**Press Time:** Light garments: 8 seconds (Shirts, linings, light jackets, aprons)  
Heavy garments: 10 seconds (Waistbands, coveralls, heavy jackets)

**Pressure:** Do NOT exceed 25 lb. ipc (Inter-Platen Clamping Pressure) \*\*

**Gauge Setting:** These setting are for machines with 3" cylinders. For machines with larger cylinders please refer to the Conversion Chart on page 2.

<u>2" x 4" Platen</u> 25 - 30 psi	<u>4" x 6" Platen</u> 70 - 85 psi	<u>3-1/4" x 5" Gooseneck</u> 55 - 65 psi	<u>MS-32 2" x 3"</u> 55 - 65 psi
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**Note:** \*\* Piston and platen sizes vary. For machines other than Texas Automation Products units listed above, refer to Conversion Table, consult manufacturer or phone IPC-Tags to determine air pressure required to achieve 20 – 25 lbs. Inter-platen clamping pressure.

**CAUTION:** Barcodes must be applied to a smooth, flat surface. Do Not apply over seams, creases, stitching, buttons or embellishments.

For more information contact Amber@ipc-tags.com

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# 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.

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