

Patch Application Instructions

GENUINE LEATHER

1. Using the Hotronix 360 IQ hat press ... heat upper platen to 290F, lower platen 280F
2. Set pressure to between 5-7 (It'll be up to you to find your sweet spot on heat and pressure)
3. Pre-press your hat for 7 seconds to eliminate any moisture and to shape your hat to platen
4. Using a "pre-heated" 1/16 or 1/8" silicone pad press patch on hat for 40-50 seconds
5. Inspect patch to make sure it is fully adhered on all sides
6. Remove hat and set aside, allow 24 hours for adhesive to fully cure before handling

LEATHERETTE

1. Using the Hotronix 360 IQ hat press ... heat upper platen to 280F, lower platen 280F
2. Set pressure to between 5-7 (It'll be up to you to find your sweet spot on heat and pressure)
3. Pre-press your hat for 7 seconds to eliminate any moisture and to shape your hat to platen
4. Using a "pre-heated" 1/16 or 1/8" silicone pad press patch on hat for 25-30 seconds
5. Inspect patch to make sure it is fully adhered on all sides
6. Remove hat and set aside, allow 24 hours for adhesive to fully cure before handling

OTHER HAT PRESSES

For all other hat presses here are some "jumping off point" settings you can use. As always practice on your machine to dial in your settings as they will vary from machine to machine

Time: Leatherette

20-30 seconds

Time: Genuine Leather

40-50 seconds

Temperature:

340-350F

Pressure:

Medium 5-7

Cover Pad:

1/16" or 1/8" Silicone pad

Instructions:

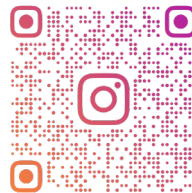
Pre-heat your lower platen for 50-60 seconds. Add your hat and pre-heat for 20 seconds (using your silicone pad, prevents scorching and or burn marks). Make sure to mold the hat shape to the platen, you should have no air gaps between the hat and the platen, it should be flat to the platen surface. Add patch and Cover with a Silicone flex pad and press.

IMPORTANT TIPS

- Always use a silicone pad or your 1/8" foam pad for pre, and main, press, for post press use only a silicone pad (recommended)
- Always pre-heat or garment to evaporate moisture
- Check your patches before placement.
- Always check your heat press platen with a laser temperature gun to ensure accurate temps.
- Store your patches in a cool dry place.
- Lint roll your garments prior to placement.
- All tests are done using a Stahls Hotronix 360 IQ Hat press, your settings may vary for any other style hat press. For Leather and embroidered patches upper and lower heat is highly recommended, and is why we choose to use the 360 IQ Hat Press
- Always order a few extra patches as well practice with other hats first to dial in your hat heat press settings

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