

Procedure

AX'Lin heat-sealing



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1 Heat sealing

Heat-sealing is a process that allows the tag to be glued to the textile by heat. In order to obtain a quality heat seal, it is necessary to have the necessary equipment, a coating adapted to the textile and a support.

The temperature to which the adhesive is subjected is key as it allows the adhesive to become fluid. It must be at least 172 degrees. Similarly, the heat seal time is also important because it allows the fluid adhesive to flow into the textile.

These two parameters vary according to the heat seal machine used by the customer (machine reference, pressure, etc.) and the composition of the tag (one or more layers of fabric).

Therefore, it is strongly recommended to follow the following procedure and perform the required tests to determine these 2 key factors.

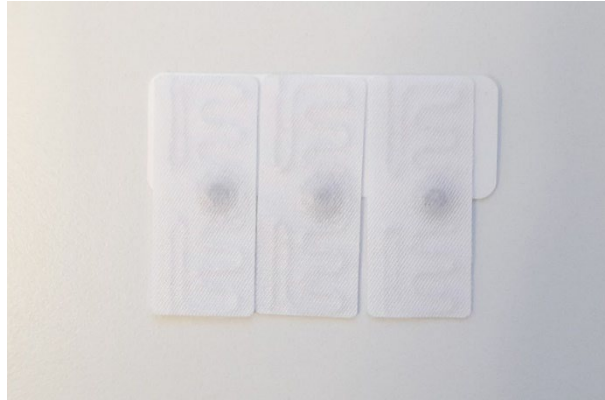
2 Procedure

Material

- A temperature indicator (ref. 0646.2532 - Testo)
- AX'Lin Thermo tags (references: LINEPUHF1217, LINEPUHF1980, LINEPUHF1968, LINEPUHF1996, LINEPUHF1994)
- A piece of linen to be tagged
- A heat seal machine. AX'Lin Thermo laundry tags are compatible with all models.

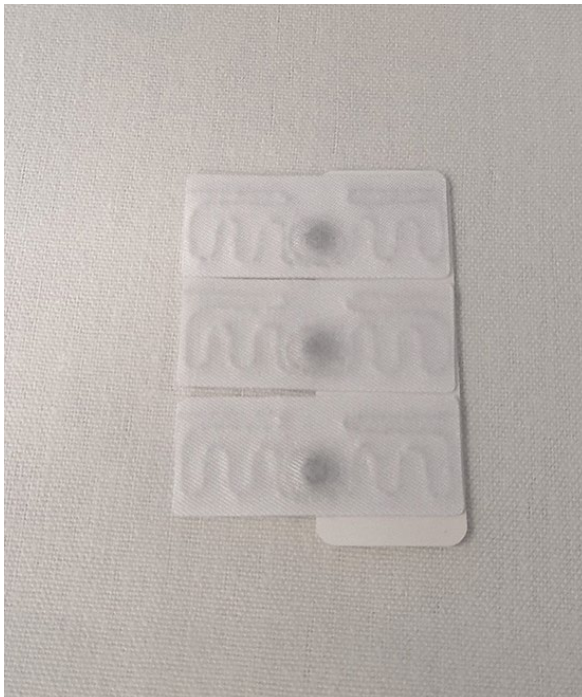
Steps

- 1) Attach the tag to the temperature indicator. Cover the surface of the indicator as much as possible, but do not place the module (black counter) on the indicator as this does not allow temperature transfer. If the tag is too small to cover the entire surface of the indicator, it is recommended to use several tags. In the below example, 3 tags have been attached.

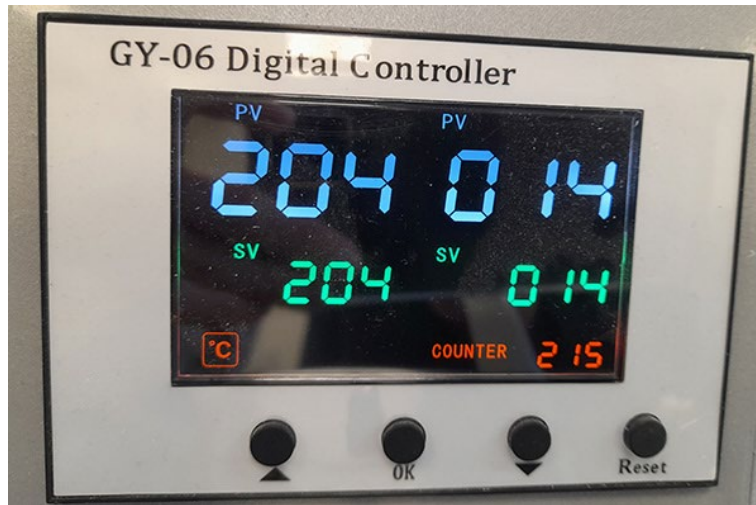


Be careful when applying the tag: the adhesive side of the AX'Lin Thermo tag must be applied to the adhesive side of the indicator.

- 2) Heat seal the tag(s) and the temperature indicator on a linen :



In the procedure approved by AXEM Technology, the heat seal machine is set at 204 degrees for 14 seconds to subject the adhesive to a temperature of 172 degrees.



It is recommended to perform a test with these parameters and adjust them according to the test results.

3) Check the result



The temperature of the glue is 172 degrees.
The procedure is validated.



The temperature is too low. The procedure must be repeated with a higher temperature.



The temperature is too high. The procedure must be repeated with a lower temperature.