



### **Heat Seal Machine Process**

Our experience has shown the Heat Seal Process to be an effective solution when adding new labels or replacing worn labels. In our testing labels have lasted over 75 wash cycles.

The type, setup and effectiveness of heat seal equipment can vary widely depending on the available air pressure and the heat produced by the individual machine. Because of this, we recommend that you thoroughly check the equipment to be used and then make some tests using the above information as a guide. It is also recommended you carry out wash test to evaluate the results before undertaking a large project.

If you have any questions please contact Kleen-Tex for further advice.

### **Required Materials:**

- Labels - Available for purchase from Kleen-Tex
- Uncured Rubber - Available for purchase from Kleen-Tex

### **Required Equipment:**

- Heat Seal Machine
- Grinder with wire brush or grinding stone attached
- PTFE/Teflon sheet

### **Instructions for Front Edge Labels:**

1. Clean off the area where the old labels are or grind the area where you want to place the new label, so you have a rough rubber surface, which will improve the bond between old rubber and new rubber/label
2. Set the temperature and pressure on the heat seal machine - 80 psi or 5.5 bar is desirable and temperature between 160 °C and 180 °C
3. Place the mat in the heat seal machine with the buffed rubber area in the middle
4. Place the label on the uncured rubber
5. Cover the label and the entire repair area with a piece of PTFE/Teflon sheet
6. Close the heat seal machine and allow the label and the rubber to cook for 6 - 10 minutes
7. When the cook cycle is completed, allow the mat to cool before handling

### **Instructions for Back Labels:**

1. Clean off the area where the old labels are or buff the area where you want to place the new label, so you have a smooth surface. If the mat is kleeted, be sure to remove all kleet. Even with smooth backed mats, it is also necessary to buff the surface to improve the bond between the old rubber and new rubber/label. Be careful not to be too aggressive during grinding as you may grind through the rubber backing, damaging the mat.
2. Set your heat seal machine to full air pressure (80 psi or 5.5 bar is desirable) and temperature between 160 °C and 180 °C.
3. Place the mat in the heat seal machine with the buffed rubber area in the middle.
4. Place the label on the uncured rubber.
5. Cover the label and the entire repair area with a piece of PTFE/Teflon fabric.
6. Close the heat seal machine and allow the label and the rubber to cook for 6 - 10 minutes.
7. When the cook cycle is completed, allow the mat to cool before handling.