

# Professor T.H. Read's

## ★Lessons in Carefree Embroidery★



### How to Make Patches

**Patches** are an embroidered design on firm backing that is applied to clothing and fabrics.

#### Materials Needed:

- Top fabric: twill, sailcloth, or other suitable fabric, usually a cotton, polyester or blend material.
- Backing material: (crinoline and/or tear away)
- Heat seal.
- Embroidery and merrow threads.

#### Equipment Needed:

- Embroidery or monogram machine.
- Overedging or zig-zag machine for finishing the edges of the patches.

#### General Guidelines:

1. Hoop fabric, crinolin and/or backing.
2. Embroider design. It is helpful to have a "cut line" incorporated into the design to act as a guide when cutting the patch.
3. Apply heat seal (either 4220 or 3218) to the back of the embroidered fabric.  
Use an iron or a heat press to bond heat seal to patch material.
4. Cut patch to shape with scissors or die cutter.
5. Finish the edges using a serger or overedging or zig zag machine.

#### Madeira offers the following Heat Seals:

**4220** is a highly bondable heat seal used primarily on back side of patches that will be permanently sealed to garment or hats. Adheres well to acetate, silk, cotton, rayon and wool. Use medium pressure at 286°F - 376°F degrees for 15 seconds. Made of Nylon (Polyamide).

**5250** is a heat seal film used in conjunction with 3218 or alone to produce permanent seals on patches and appliqués. An economical patch can be created by using 3218 as a stiffener before embroidering and then adding the 5250 as a final coat. Adheres well to polyester, poly/cotton and blended fabric substrates. Use light to moderate pressure between 300°F - 376°F. Made of Polyester.

**3218** is film laminate for finishing the back of patches. Eliminates fraying and adds body and stability to sew-on patches. Suitable to a wide range of materials including heat sensitive and vinyl coated. Adheres well to Nylon, Polyester, Polyurethane and PVC. It may also be used to seal up the back side of embroidery on water resistant garments. Use medium pressure at 248°F -266°F for 20 seconds. Made of Polyurethane.

Please note that the recommend heat setting of the garment or substrate must be taken into account when setting the temperature of your iron or heat press to adhere the heat seals and laminate.



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