

### Standard Style Material Combinations

Material	Temperature	Pressure	Accessories	Application
<b>Thermo-FILM® or Thermo-GRIP® foreground on...</b>	330° F 165° C	Medium	Kraft Paper/Teflon Sheet	Apply Thermo-FILM® foreground on background for 12 seconds.
<b>Thermo-FILM®</b>				
<b>GORILLA-GRIP® II</b>	320° F 160° C	Light	Kraft Paper/Teflon Sheet	Apply GORILLA-GRIP® II background for 2 seconds; Peel COLD. Apply Thermo-Film® or Thermo-Grip® for 12 seconds.
<b>Thermo-GRIP®</b>	330° F 165° C	Medium	Kraft Paper/Teflon Sheet	Apply Thermo-GRIP® foreground on background for 12 seconds.
<b>Vinyl (Heat Applied)</b>	330°-350° F 165°-177° C	Medium/Firm	Kraft Paper/Teflon Sheet	Apply Vinyl background for 3 seconds; Peel paper facing COLD. Cover and heat seal for 15 seconds. Apply Thermo-Film® or Thermo-Grip® for 6 seconds.

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Material	Temperature	Pressure	Accessories	Application
<b>GORILLA-GRIP® II foreground on...</b>	330° F 165° C	Medium	Kraft Paper/Teflon Sheet	Apply Thermo-FILM® background for 2 seconds. Apply GORILLA-GRIP® II for 2 seconds; Peel COLD. Cover and heat seal for 10 seconds.
<b>Thermo-FILM®</b>				
<b>GORILLA-GRIP® II</b>	320° F 160° C	Light	Kraft Paper/Teflon Sheet	Apply GORILLA-GRIP® II background for 2 seconds; Peel COLD. Apply GORILLA-GRIP® II foreground for 2 seconds; Peel COLD. Cover and heat seal for 10 seconds.
<b>Thermo-GRIP®</b>	330° F 165° C	Medium	Kraft Paper/Teflon Sheet	Apply Thermo-GRIP® background for 2 seconds. Apply GORILLA-GRIP® II for 2 seconds; Peel COLD. Cover and heat seal for 10 seconds.
<b>Vinyl (Heat Applied)</b>	330°-350° F 165°-177° C	Medium/Firm	Kraft Paper/Teflon Sheet	Apply Vinyl background for 3 seconds; Peel paper facing COLD. Cover and heat seal for 15 seconds. Decrease pressure to light. Apply GORILLA-GRIP® II for 2 seconds; Peel COLD. Cover and heat seal for 5 seconds.

**Standard Style Material Combinations**

Material	Temperature	Pressure	Accessories	Application
<b>Thermo-FLOCK® foreground on...</b>	330° F 165° C	Medium	Kraft Paper/Teflon Sheet	Apply Thermo-FLOCK® foreground to Thermo-FILM® background for 15 seconds.
<b>Thermo-FILM®</b>				
<b>GORILLA-GRIP® II</b>	320° F 160° C	Light	Kraft Paper/Teflon Sheet	Apply GORILLA-GRIP® II background for 2 seconds; Peel COLD. Apply Thermo-FLOCK® foreground for 15 seconds.
<b>Thermo-GRIP®</b>	330° F 165° C	Medium	Kraft Paper/Teflon Sheet	Apply Thermo-FLOCK® foreground to Thermo-GRIP® background for 15 seconds.
<b>Vinyl (Heat Applied)</b>	330°-350° F 165°-177° C	Medium/Firm	Kraft Paper/Teflon Sheet	Apply Vinyl background for 3 seconds; Peel paper facing COLD. Cover and heat seal for 15 seconds. Apply Thermo-FLOCK® for 8 seconds.

**Standard Style Material Combinations**

Material	Temperature	Pressure	Accessories	Application
<b>Scotchlite Reflective by 3M® foreground on...</b>	330° F 165° C	Medium	Kraft Paper/Teflon Sheet	Apply Scotchlite Reflective by 3M® foreground on Thermo-FILM® background for 8 seconds. Peel paper facing COLD. Cover and heat seal for 12 seconds.
<b>Thermo-FILM®</b>				
<b>GORILLA-GRIP® II</b>	320° F 160° C	Light	Kraft Paper/Teflon Sheet	Apply GORILLA-GRIP® II background for 2 seconds; Peel COLD. Apply Scotchlite Reflective by 3M® foreground for 5 seconds; Peel paper facing COLD. Cover and heat seal for 10 seconds.
<b>Thermo-GRIP®</b>	330° F 165° C	Medium	Kraft Paper/Teflon Sheet	Apply Scotchlite Reflective by 3M® foreground on Thermo-GRIP® background for 8 seconds. Peel paper facing COLD. Cover and heat seal for 12 seconds.
<b>Vinyl (Heat Applied)</b>	330°-350° F 165°-177° C	Medium/Firm	Kraft Paper/Teflon Sheet	Apply Vinyl background for 3 seconds; Peel paper facing COLD. Cover and heat seal for 15 seconds. Decrease pressure to light. Apply Scotchlite Reflective by 3M® for 5 seconds; Peel paper facing COLD. Cover and heat seal for 8 seconds.

### Standard Style Material Combinations

Material	Temperature	Pressure	Accessories	Application
<b>Vinyl foreground on...</b>	330° F 165° C	Medium	Kraft Paper/Teflon Sheet	Apply Thermo-FILM® background for 2 seconds. Apply Vinyl for 5 seconds; Peel paper facing COOL. Cover and heat seal for 15 seconds.
<b>Thermo-FILM®</b>				
<b>GORILLA-GRIP® II</b>	320° F 160° C	Light	Kraft Paper/Teflon Sheet	Apply GORILLA-GRIP® II background for 2 seconds; Peel COLD. Apply Vinyl for 5 seconds; Peel paper facing COOL. Cover and heat seal for 15 seconds.
<b>Thermo-GRIP®</b>	330° F 165° C	Medium	Kraft Paper/Teflon Sheet	Apply Thermo-GRIP® background for 2 seconds. Apply Vinyl for 5 seconds; Peel paper facing COOL. Cover and heat seal for 15 seconds.
<b>Vinyl (Heat Applied)</b>	330°-350° F 165°-177° C	Medium/Firm	Kraft Paper/Teflon Sheet	Apply Vinyl background for 3 seconds; Peel paper facing COLD. Apply Vinyl foreground for 3 seconds; Peel COLD. Cover and heat seal for 15 seconds.