



Sun Control Textiles™

## WELDING TAPE 103218 DATA SHEET

Mermet 103218 adhesive film is a tough, polyurethane heat activated film. This elastomeric adhesive film has a low activation temperature ideal for either continuous bonding operations or when using with heat sensitive fabrics. This film has a low flow rate and stiff hand making it easy for handling and positioning. This film has proven successful with superior bond strength in fabrics that utilize DWR (Durable Water Repellent) coatings.

<b>Description:</b>	Mermet Heat Seal 103218 5-mil
<b>Size:</b>	10mm (1/32") x 91.44 linear meters (100 yards)
<b>Composition:</b>	Ester Polyurethane
<b>Color:</b>	Hazy, Translucent
<b>Weight:</b>	29 gm/m <sup>2</sup> per mil
<b>Substrate</b>	None (no release paper)
<b>Thickness:</b>	.005" / .125mm
<b>Hand:</b>	Stiff
<b>Washability:</b>	Excellent up to 40°C / 104°F
<b>Softening Point:</b>	92°C / 198°F
<b>Melt Flow Index (MFI):</b>	5 dg (decigrams)/min, Condition: 175°C / 2.16 Kg Load
<b>Glue Line Temperature<sup>1</sup>:</b>	120°C - 130°C / 248°F - 266°F

### Recommended Bonding Conditions<sup>2</sup>:

#### Flat Press (Heat Impulse):

<b>Description:</b>	120°C to 130°C
<b>Dwell Time:</b>	20-30 seconds
<b>Pressure:</b>	2.8 to 4.2 Bar (40-60 psi)

#### Continuous Bonding Machine:

<b>Description:</b>	200°C to 250°C
<b>Speed:</b>	1.5 – 2.0 meters/min
<b>Pressure:</b>	1.0 Bar (14.3 psi)

<sup>1</sup> Glue Line Temperature (GLT) refers to the temperature of the adhesive in the bonding process. Glue line temperature must be measured to receive accurate machine settings.

<sup>2</sup> Recommended bonding conditions will vary between different machinery and fabrics. The recommended conditions stated are a starting point only. Optimal bonding conditions should be established by the factory for the specific application.