

Apparel

Product Data Sheet



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Adhesives, Coatings, Specialty Films & Seam Tape

Submitted by: E Toner

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Version: 1

PRODUCT DESCRIPTION: 3412

This product is an extremely soft elastomeric adhesive with excellent recovery. It is designed to be used in Sewfree® applications where low modulus and recovery are required. Fabrics that are bonded using this adhesive exhibit excellent wash resistance and retain most of their elasticity.

SUGGESTED APPLICATIONS:

Intimates: Fabric lay-down, fold over hem and body shaping

Outerwear/ Performance: Overlap seams

PRODUCT BENEFITS:

The product offers soft hand, low modulus and excellent recovery.

COMPOSITION:

Ester Polyurethane

THERMAL & PHYSICAL PROPERTIES

- Color: Clear
- Weight: 31 gm/m² (per 25 µm)
- Release Liner: Paper
- Gauge: 25 µm (.001") 50 µm (.002") 100 µm (.004")
- Width: 1524 mm (60 "); Product can be slit to requested widths, no less than 4mm (.16")
- Hand: Very soft
- Wash: Excellent up to 60 °C
- Modulus and Recovery:

Gauge	Modulus of 25.4mm (1") wide sample		Recovery after 100% elongation at a rate of 304mm (12") per minute
	@ 40% of original length	@ 100% of original length	
25 µm (.001")	0.9 N (0.2lbs)	3.0 N (0.68 lbs)	99%
50 µm (.002")	1.8 N (0.4lbs)	3.6 N (0.8 lbs)	99%
100 µm (.004")	3.6N (0.8lbs)	4.48 N (1.0")	99%

- Softening Point: 115 °C
- Melt Flow Index: 34 dg/min Condition: 175 °C / 2.16 Kg Load
- Glue Line Temperature¹: 150 °C to 170 °C
- Recommended Bonding Conditions²:
 - **Flat Press:**
 - Machine Setting: 150 °C to 170 °C
 - Dwell Time: 20 to 30 seconds
 - Pressure: 2.8 to 4.2 Bar (40-60 psi)
 - **Continuous Bonding Machine:**
 - Machine Setting: 250 °C to 300 °C
 - Speed: 1.5 to 2.0 m/min
 - Pressure: 1 Bar (14.3 psi)

¹ 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. ² 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.

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