

PRODUCT SELECTOR & APPLICATION GUIDE

	WEF 201	WEF 202	WEF 205	WEF 208	WEF 3003	WEF 3004	WEF WA-001
Standard Gauge	50 µm	75 µm	50 µm	50 µm	75 µm	100 µm	20 g/yd ²
Chemistry	Ester TPU	Ester TPU	Ester TPU	Ester TPU	TPU Elastomer	TPU Elastomer	TPO Elastomer
Construction	Monolayer	Monolayer	Monolayer	Monolayer	High Recovery	High Recovery	Non-Woven Web
Appearance	Transparent	Transparent	Transparent	Transparent	Transparent	Transparent	White Filament
Substrate	Release Paper	Release Paper	Release Paper	Release Paper	Release Paper	Release Paper	N/A
Compliance/Certification¹	Oeko-Tex, REACH, CPSIA	Oeko-Tex, REACH, CPSIA	Oeko-Tex, REACH, CPSIA	Oeko-Tex, REACH, CPSIA	Oeko-Tex, REACH, CPSIA	Oeko-Tex, REACH, CPSIA	Oeko-Tex, REACH, CPSIA
Comments	Excellent adhesion and wash resistance on a broad range of fabrics; ideal for molding/forming applications	Low activation temperature with good stretch and recovery; ideal for heat sensitive fabrics	Low profile, extremely soft with low modulus and good recovery	Low activation temperature with exceptional stretch and recovery; ideal for heat sensitive fabrics and continuous processing	Low profile adhesive, ideal for applications that require high stretch and high recovery	Designed to replace elastics, ideal for applications that require high stretch and high recovery	Very light, breathable, with desirable stretch; ideal for fabric to fabric lamination
Width	4 - 1397 mm	4 - 1397 mm	4 - 1397 mm	4 - 1397 mm	4 - 1371 mm	4 - 1371 mm	1524 mm
Weight	30.2 g/m ² (per 25 mm)	29.5 g/m ² (per 25 mm)	29 g/m ² (per 25 mm)	29.2 g/m ² (per 25 mm)	85.8 g/m ²	112.8 g/m ²	23.9 g/m ² (per 25 mm)
Hand	Soft	Soft	Very Soft	Very Soft	Soft	Soft	Very Soft
Wash	up to 55°C (131°F)	up to 55°C (131°F)	up to 55°C (131°F)	up to 55°C (131°F)	up to 55°C (131°F)	up to 55°C (131°F)	up to 55°C (131°F)
Modulus²	@ 50 µm (.002")	@ 75 µm (.003")	@ 50 µm (.002")	@ 50 µm (.002")	@ 75 µm (.003")	@ 100 µm (.004")	N/A
40%	4.0 N (0.9 lbs)	5.7 N (1.28 lbs)	1.8 N (0.4 lbs)	1.8 N (0.4 lbs)	4.2 N (0.9 lbs)	4.8 N (1.1 lbs)	
100%	6.6 N (1.5 lbs)	6.7 N (1.5 lbs)	3.6 N (0.8 lbs)	3.6 N (0.8 lbs)	6.2 N (1.4 lbs)	8.4 N (1.9 lbs)	
Recovery³	@ 50 µm (.002")	@ 75 µm (.003")	@ 50 µm (.002")	@ 50 µm (.002")	@ 75 µm (.003")	@ 100 µm (.004")	N/A
	97%	96%	99%	99%	100%	100%	
Softening Point⁴	120°C (248°F)	95°C (203°F)	130°C (266°F)	95°C (203°F)	95°C (203°F)	95°C (203°F)	75°C (167°F)
Melt Flow Index⁵	20 dg/min	45 dg/min	35 dg/min	10 dg/min	45 dg/min	45 dg/min	10 dg/min
Glue Line Temperature⁶	150 - 170°C 300 - 338°F	120 - 130°C 248 - 266°F	150 - 170°C 300 - 338°F	110 - 130°C 230 - 266°F	120 - 165°C 248 - 329°F	120 - 165°C 248 - 329°F	140 - 160°C 284 - 320°F
Suggested Bonding Conditions (Flat Press)⁷							
Temperature	165 - 185°C	130 - 150°C	160 - 180°C	140 - 160°C	140 - 160°C	140 - 160°C	N/A ⁸
Time	20 - 25 sec	20 - 25 sec	20 - 25 sec	20 - 25 sec	20 - 25 sec	20 - 25 sec	
Pressure	3 - 5 bar	3- 5 bar	3 - 5 bar	3 - 5 bar	3 - 5 bar	3 - 5 bar	
Suggested Bonding Conditions (Continuous Machine)⁷							
Foot & Plate Temperature	N/A	130 - 140°C	160 - 170°C	140 - 150°C	140 - 150°C	140 - 150°C	N/A ⁸
Air Temperature		130 - 140°C	160 - 170°C	140 - 150°C	140 - 150°C	140 - 150°C	
Speed		2 - 2.5 m/min	1.5 - 2 m/min	2 - 2.5 m/min	2 - 2.5 m/min	2 - 2.5 m/min	
Roller Pressure		1 - 1.5 bar	1.5 - 2 bar	1 - 1.5 bar	1 - 1.5 bar	1 - 1.5 bar	

1. Oeko-Tex, Standard 100 Class 1 (Test No. 6187); REACH compliant, EU legislation concerning the Registration, Evaluation, Authorization, and Restriction of Chemicals; CPSIA compliant, procedure CPSE-CH-E1002-08 title 1, section 101 – Consumer Product Safety Improvement.

2. Modulus: Force required to pull a 25.4mm (1") wide sample at the specified gauge to 40% and 100% of test length.

3. Recovery: After 100% elongation at a test speed of 304mm (12") per minute.

4. Softening point: Temperature where the adhesive begins to soften and flow. All values refer to the adhesive layer.

5. Melt flow index: Readings were taken at 175°C, 2.16 kg load. The index is an indication of how fast the adhesive flows when molten.

6. Glue line temperature: Refers to the temperature of the adhesive layer in the bonding process to achieve the best bond. Glue line temperature must be measured to achieve ideal machine settings.

7. Bonding conditions: Recommended bonding conditions vary greatly between machinery and fabrics. The recommended conditions stated are for starting reference point only.

8. WA 001 web adhesive: For best results and optimum functionality, we recommend bonding this product on a belt laminator. Please refer to this product's TDS for the detailed bonding process.

