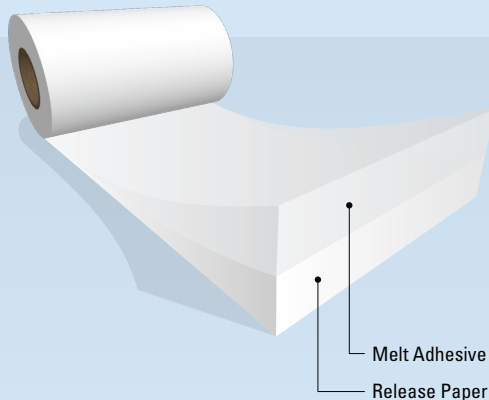


DUPONT™ INTEXAR™ TE-21C

COVER FILM FOR WEARABLES APPLICATIONS

Cover Film TE-21C



PRODUCT DESCRIPTION

DuPont™ Intexar™ TE-21C Cover Film is a stretchable melt adhesive layer that functions to bond to fabrics and TE-11C Base Layer. The melt adhesive layer is specially designed for compatibility with Base Film TE-11C and is well suited to bonding to fabrics under heat press lamination. The film is supplied on a temperature stable paper carrier.

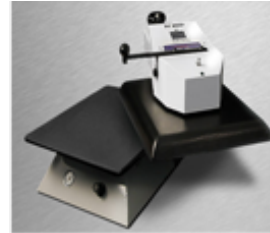
PRODUCT BENEFITS

- Light weight, stretchable melt adhesive
- Designed for compatibility with Intexar™ Base Film TE-11C
- Designed for multiple lamination processes in sequence, bonding to TE-11C then after carrier removal, bonding to fabric.
- Bonds strongly to most knit and woven type fabrics including polyester blends

PROCESSING GUIDELINES

- Laminate in a clamshell style press with uniform platen temperature & pressure
- Avoid air entrapment
- Temperature set-point 125 – 135°C (expect 5 – 10°C offset between set-point and maximum temperature achieved during bonding process)
- Dwell time 15 seconds
- Pressure 414 kPa gauge pressure (60 psig)

Example of Clamshell Style Press



Example from <http://geoknight.com/>

Lay-up in Laminator

Heating Plate
Parchment Paper
Base Film
Fabric
Parchment Paper
Laminator Base

ROLL LENGTHS & WIDTHS

Roll Width (mm)	Roll Length (m)	
406	100	500
610	100	500
813	100	500
1473	100	500

Roll Width (in)	Roll Length (yd)	
16	109	547
24	109	547
32	109	547
58	109	547

Other dimensions may be available upon request, please contact local sales agent.

BASE FILM TYPICAL PROPERTIES: TE-21C

Typical Properties	Value
Color	Translucent
Melt Adhesive Layer Thickness	20 – 50 µm
Recovery ¹	96%
Modulus ²	(40%) 1.6N (100%) 1.7N
Shore A Hardness	65
Melt Adhesive glue line temperature	130°C
Roll Length ³	100 – 500 m
Roll Width ³	406 – 1473 mm

¹Recovered strain after 40% strain at 508mm/min, 1 second rest

²Force required to pull 2cm wide 25µm thick film to specified strain after first cycle

³Refer to Roll Lengths & Widths Tables above for details



DUPONT™ INTEXAR™ TE-21C COVER FILM FOR WEARABLES APPLICATIONS

STORAGE AND SHELF LIFE

Rolls should be stored in a clean stable environment at room temperature (<25°C).

SAFETY AND HANDLING

For Safety and Handling information, please refer to the Article Information Sheet.

FOR MORE INFORMATION ON DUPONT™ INTEXAR™ TE-21C OR OTHER DUPONT PRODUCTS, PLEASE CONTACT YOUR LOCAL REPRESENTATIVE:

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CAUTION: Do not use in medical applications involving permanent implantation in the human body. For other medical applications, see "DuPont Medical Caution Statement," H-50102-5.

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