



Miller Weldmaster Setting for Marlen Textiles' Fabrics



Product		T300 Hot Wedge					T300 Hot Air					Impulse Extreme		
		Temp (°F)	Speed	Upper Weld Roller %	Drive Start	Tensile (lb force)	Temp (°F)	Speed	Upper Weld Roller %	Drive Start	Tensile (lb force)	Heat Time (sec)	Cool Down Time (Sec)	Tensile (lb force)
			(meters/ min)		Delay Time (Sec)			(meters/ min)		Delay Time (Sec)				
Top Notch FR	Tape	450	11.0	98.5	0.04	116	650	4.5	98.5	0.30	107	Did not try/Should weld OK		
Top Notch FR	No Tape	450	2.5	98.5	1.00	121	650	4.5	98.5	0.50	150	Did not try/Should weld OK		
Top Gun FR/FR Lite	Tape	450	2.0	100	0.75	107	400	2.0	99	0.45	99	20	36	127
Top Notch	Tape	435	4.0	100	0.75	178*	400	2.0	99	0.45	114	15	30	114
Top Notch	No Tape	435	4.0	100	0.75	249*	450	2.0	99	0.45	174*	Did not try/Should weld OK		
Top Notch 9	Tape	450	4.5	100	0.75	126	450	4.5	99	0.45	95	15	30	94
Top Notch 9	No Tape	450	4.5	100	0.75	148	450	3.0	99	0.45	156*	Did not try/Should weld OK		
Top Notch 1S	Tape	435	4.0	100	0.75	84*	450	3.0	99	0.45	55*	15	30	114*
Top Notch 1S	No Tape	435	4.0	100	0.75	40	Weld was not strong					Did not try/Should weld OK		
Top Gun/Top Gun 9	Tape	435	4.0	100	0.75	97	450	2.5	99	0.45	75	15	30	102
Top Gun/Top Gun 9	No Tape	435	4.0	100	0.75	86	Weld was not strong					Did not try/Should weld OK		
Odyssey FR	Tape	450	4.0	100	0.75	66	450	2.0	99	0.45	98*	15	30	90*
Odyssey FR	No Tape	435	6.0	100	0.75	72*	Weld was not strong					Did not try/Should weld OK		
Top Gun 1S	Tape	450	4.5	100	0.75	97	Weld was not strong					Weld was not strong		
Odyssey	Tape	450	2.0	100	0.75	66*	450	2.75	99	0.45	70*	15	30	89*

* means fabric broke during tensile test and not the weld

Impulse was not tried without tape. Should work without tape on Top Notch, Top Notch 9, Top Notch1S, Top Gun/TG 9, & Odyssey FR

Top Notch 1S & Odyssey weld better with coated side up on wedge and hot air

Top Gun with no tape welded better on Hot Wedge. Using tape for Top Gun Hot Wedge & Hot Air, must sand coating first. With Impulse, no sanding needed.