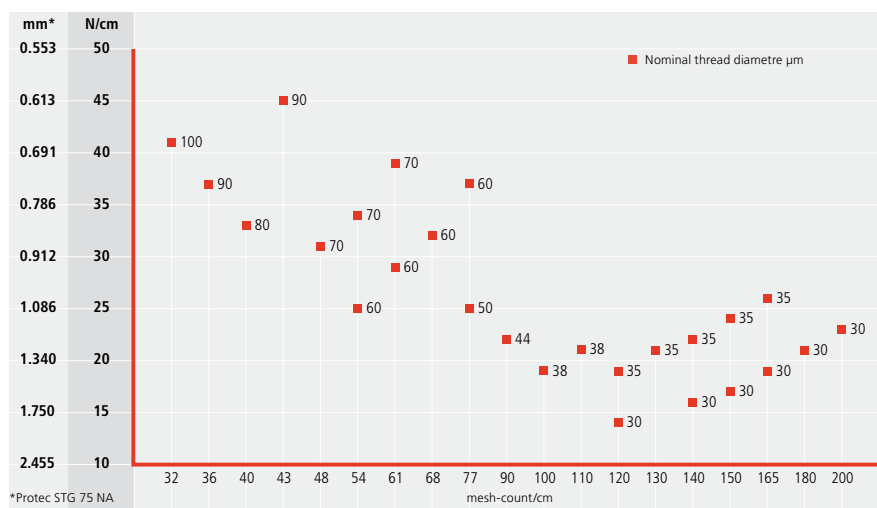


Possible Tension values for SEFAR® polyamide mesh



The stated values are in [N/cm] according to DIN 16611 (screen printing standard) and measured using SEFAR® Tensoscheck 100. The above values refer to tensions measured after stretching only (before gluing to the frame). These values are valid for dimensions of 1x1m. It is not general practice to use frames larger than this with polyamide mesh.

Tensioning system requirements

In view to obtain the above values, the performance of your tensioning system should be:

- Stretching clamps SEFAR® 2, SEFAR® 3A or any other system that guarantees even and balanced tension.
- A mesh clamping system that does not allow the mesh to slip, even under high tensions. It should be regularly cleaned and exempted of contaminants such as oil and dirt.
- Tensioning clamps should be regularly checked in view to avoid sharp edges which could damage the mesh.
- High humidity and high temperature could have influences on stretching performances. This may lead to difficulties during the stretching process.

Stretching process / Relaxation:

Tensioning process lasts up to 3 minutes until the desirable tension is achieved. Waiting time approx. 3 to 5 minutes before gluing the mesh on the frame. The loss of tension after 24 hours will be 20 to 30% for respectively, coarse and fine meshes (any other parameters such as frame deformation are not taken in account).

Other causes of loss of tension:

- Poor frame characteristics (profile, material...)
- Not adequate frame pre-tension
- Quality of the adhesive
- High humidity

Waver: It is exclusively in written agreements that we provide our customers with warrants and representations as to the technical contained specifications and/or the fitness for any particular purpose. The facts and figures herein are carefully compiled to the best of our knowledge, but they are intended for general informational purposes only. **Current data available on www.sefar.com**

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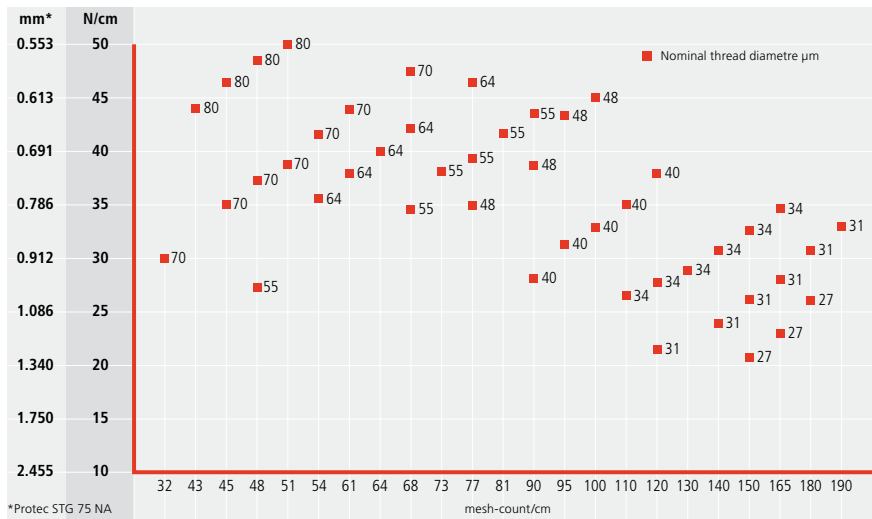
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Possible Tension values for SEFAR® PET high-modulus mesh



The stated values are in [N/cm] according to DIN 16611 (screen printing standard) and measured using SEFAR® Tensocheck 100. The above values refer to tensions measured after stretching only (before gluing to the frame). These values are valid for dimensions of 1x1m. Larger formats will show a reduction of approx 4% every 0,5 m of additional shank length.

Tensioning system requirements

In view to obtain the above values, the performance of your tensioning system should be:

- Stretching clamps SEFAR® 2, SEFAR® 3A or any other system that guarantees even and balanced tension.
- A mesh clamping system that does not allow the mesh to slip, even under high tensions. It should be regularly cleaned and exempted of contaminants such as oil and dirt.
- Tensioning clamps should be regularly checked in view to avoid sharp edges which could damage the mesh.
- High humidity and high temperature could have influences on stretching performances. This may lead to difficulties during the stretching process.

Stretching process / Relaxation:

Loss of tension after gluing process

Tensioning process lasts up to 3 minutes until the desirable tension is achieved. Waiting time approx 3 to 5 minutes before gluing the mesh on the frame, the loss of tension after 24 hours will be 10 to 20% for respectively, coarse and fine meshes (any other parameters such as frame deformation are not taken in account).

Other causes of loss of tension:

- Poor frame characteristics (profile, material...)
- Not adequate frame pre-tension
- Quality of the adhesive
- High humidity

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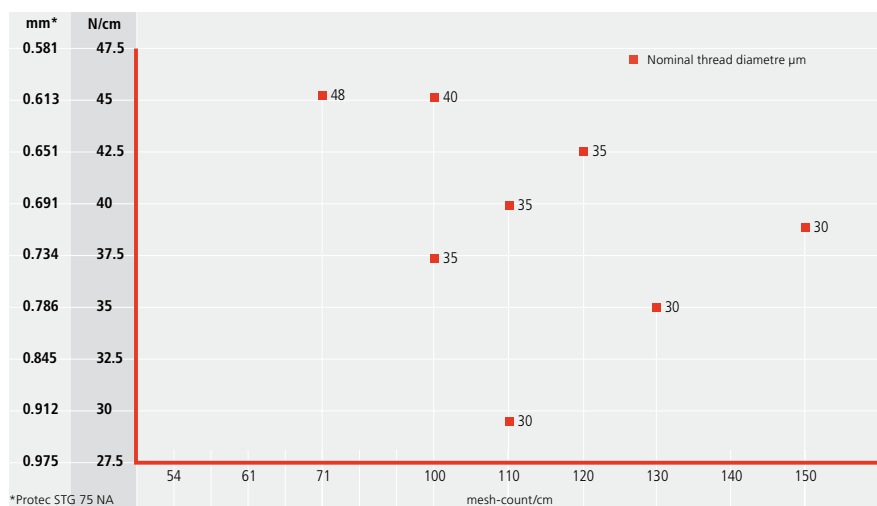
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Possible Tension values for SEFAR® PME



The stated values are in [N/cm] according to DIN 16611 (screen printing standard) and measured using SEFAR® Tensocheck 100. The above values refer to tensions measured after stretching only (before gluing to the frame). These values are valid for dimensions of 1x1m. Larger formats will show a reduction of approx 4% every 0,5 m of additional shank length.

Tensioning system requirements

In view to obtain the above values, the performance of your tensioning system should be:

- Stretching clamps SEFAR® 2, SEFAR® 3A or any other system that guarantees even and balanced tension.
- A mesh clamping system that does not allow the mesh to slip, even under high tensions. It should be regularly cleaned and exempted of contaminants such as hardened glue oil and dirt.
- Tensioning clamps should be regularly checked in view to avoid sharp edges which could damage the mesh.
- High humidity and high temperature could have influences on stretching performances. This may lead to difficulties during the stretching process.

Stretching process / Relaxation:

Loss of tension after gluing process

Tensioning process lasts up to 3 minutes until the desirable tension is achieved. Waiting time approx 3 to 5 minutes before gluing the mesh on the frame, the loss of tension after 24 hours will be 10 to 15% for respectively, coarse and fine meshes (any other parameters such as frame deformation are not taken in account).

Other causes of loss of tension:

- Poor frame characteristics (profile, material...)
- Not adequate frame pre-tension
- Quality of the adhesive
- High humidity

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