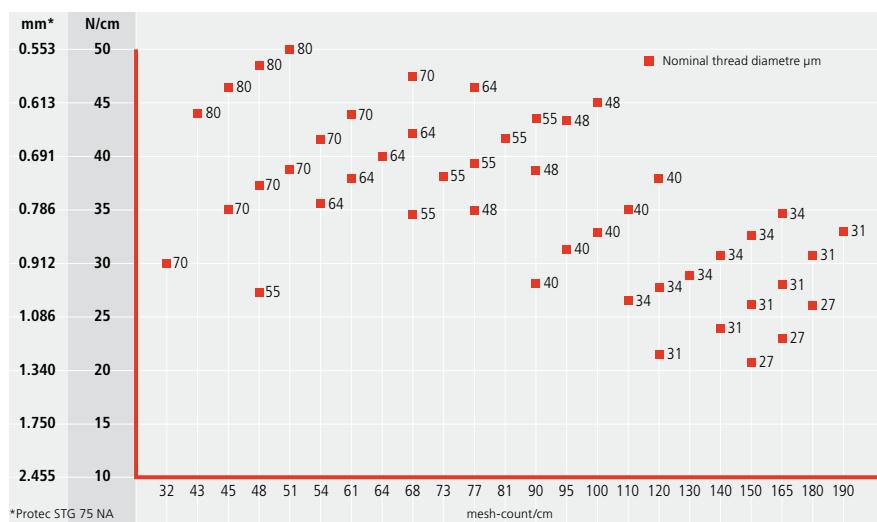


Possible Tension values for SEFAR® PET high-modulus mesh



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

Headquarters

Sefar AG

Hinterbissastrasse 12
9410 Heiden
Switzerland
Phone +41 71 898 57 00
Fax +41 71 898 57 21
printing@sefar.com
www.sefar.com

Subsidiaries

Sefar Maissa S.A.

08440 Cardedeu (Barcelona), Spain
Phone +34 93 844 47 10
Fax +34 93 844 47 20

Sefar Inc.

Buffalo, New York 14043, USA
Phone +1 800 995 0531
Fax +1 716 685 9469

Sefar S.A. de C.V.

54080 Tlalnepantla, Estado de México, México
Phone +52 55 5394 8689
Fax +52 55 5319 0358

Sefar Printing Solutions Ltda.

09895-003 São Bernardo do Campo, Brazil
Phone +55 11 4390 6300
Fax +55 11 4390 6301

Sefar Singapore Pte. Ltd.

159 Kampong Ampat #05-02 KA
Place, Singapore 368328
Phone +65 6299 9092
Fax +65 6299 6359

Sefar Filtration (India) Pvt. Ltd.

Val Bhiwandi 421302, Dist. Thane, India
Phone +91 2522 2940 34/35/36
Fax +91 2522 2940 37

Sefar Printing Solutions (Shanghai) Co. Ltd.

Shanghai 201108, China
Phone +86 21 6442 6800
Fax +86 21 6442 6866

Sefar Trading (Shenzhen) Co. Ltd.

518048 Futian District Shenzhen, China
Phone +86 755 3398 3868
Fax +86 755 3398 3863

Sefar (International) AG

Kwai Fong N.T., Hong Kong
Phone +852 2650 0581
Fax +852 2638 0580

Sefar Co. Ltd.

Suehiro-cho, Kita-ku Osaka,
Japan 530-0053
Phone +81 6 4709 1070
Fax +81 6 4709 1071

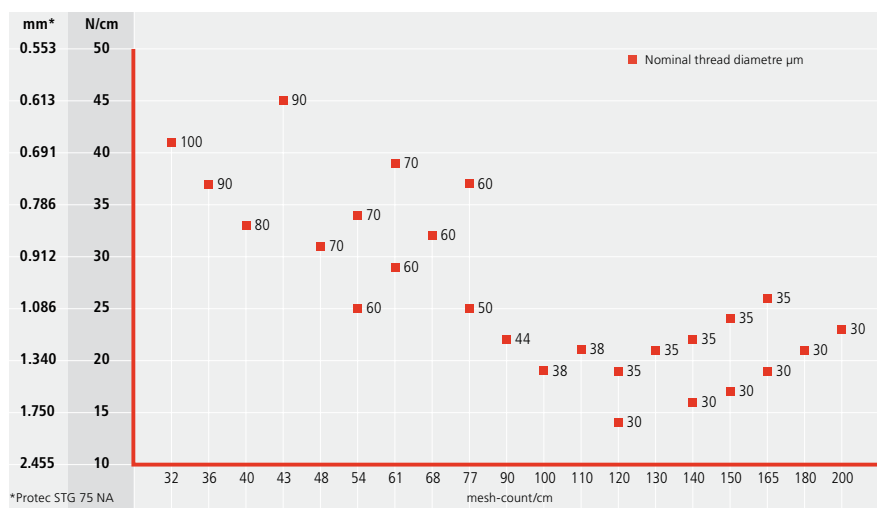
Sefar Pty Ltd

3043 Tullamarine, Victoria, Australia
Phone +61 3 9330 1122
Fax +61 3 9335 2592

S E F A R



Possible Tension values for SEFAR® PA 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**

Headquarters

Sefar AG

Hinterbissastrasse 12
9410 Heiden
Switzerland
Phone +41 71 898 57 00
Fax +41 71 898 57 21
printing@sefar.com
www.sefar.com

Subsidiaries

Sefar Maissa S.A.

08440 Cardedeu (Barcelona), Spain
Phone +34 93 844 47 10
Fax +34 93 844 47 20

Sefar Inc.

Buffalo, New York 14043, USA
Phone +1 800 995 0531
Fax +1 716 685 9469

Sefar S.A. de C.V.

54080 Tlalnepantla, Estado de México, México
Phone +52 55 5394 8689
Fax +52 55 5319 0358

Sefar Printing Solutions Ltda.

09895-003 São Bernardo do Campo, Brazil
Phone +55 11 4390 6300
Fax +55 11 4390 6301

Sefar Singapore Pte. Ltd.

159 Kampong Ampat #05-02 KA
Place, Singapore 368328
Phone +65 6299 9092
Fax +65 6299 6359

Sefar Filtration (India) Pvt. Ltd.

Val Bhiwandi 421302, Dist. Thane, India
Phone +91 2522 2940 34/35/36
Fax +91 2522 2940 37

Sefar Printing Solutions (Shanghai) Co. Ltd.

Shanghai 201108, China
Phone +86 21 6442 6800
Fax +86 21 6442 6866

Sefar Trading (Shenzhen) Co. Ltd.

518048 Futian District Shenzhen, China
Phone +86 755 3398 3868
Fax +86 755 3398 3863

Sefar (International) AG

Kwai Fong N.T., Hong Kong
Phone +852 2650 0581
Fax +852 2638 0580

Sefar Co. Ltd.

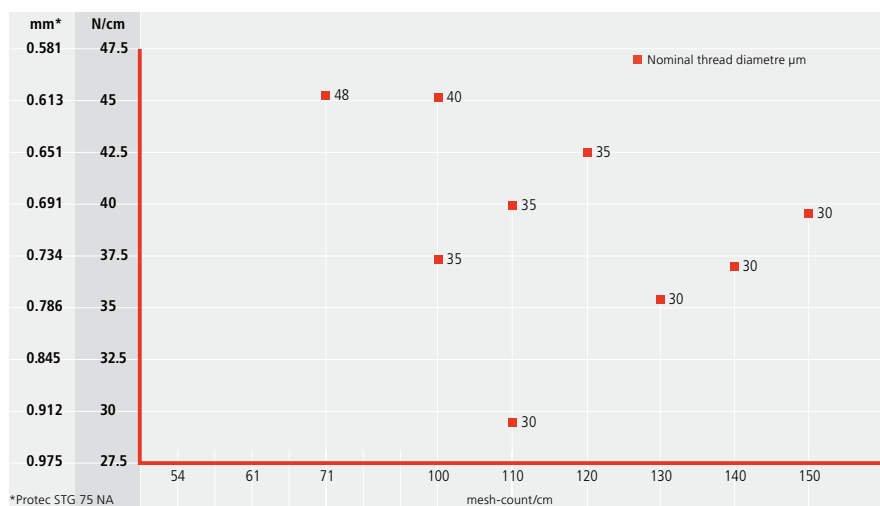
Suehiro-cho, Kita-ku Osaka,
Japan 530-0053
Phone +81 6 4709 1070
Fax +81 6 4709 1071

Sefar Pty Ltd

3043 Tullamarine, Victoria, Australia
Phone +61 3 9330 1122
Fax +61 3 9335 2592



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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Headquarters

Sefar AG

Hinterbissastrasse 12
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Switzerland
Phone +41 71 898 57 00
Fax +41 71 898 57 21
printing@sefar.com
www.sefar.com

Subsidiaries

Sefar Maissa S.A.

08440 Cardedeu (Barcelona), Spain
Phone +34 93 844 47 10
Fax +34 93 844 47 20

Sefar Inc.

Buffalo, New York 14043, USA
Phone +1 800 995 0531
Fax +1 716 685 9469

Sefar S.A. de C.V.

54080 Tlalnepantla, Estado de México, México
Phone +52 55 5394 8689
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09895-003 São Bernardo do Campo, Brazil
Phone +55 11 4390 6300
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159 Kampong Ampat #05-02 KA
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Fax +65 6299 6359

Sefar Filtration (India) Pvt. Ltd.

Val Bhiwandi 421302, Dist. Thane, India
Phone +91 2522 2940 34/35/36
Fax +91 2522 2940 37

Sefar Printing Solutions (Shanghai) Co. Ltd.

Shanghai 201108, China
Phone +86 21 6442 6800
Fax +86 21 6442 6866

Sefar Trading (Shenzhen) Co. Ltd.

518048 Futian District Shenzhen, China
Phone +86 755 3398 3868
Fax +86 755 3398 3863

Sefar (International) AG

Kwai Fong N.T., Hong Kong
Phone +852 2650 0581
Fax +852 2638 0580

Sefar Co. Ltd.

Suehiro-cho, Kita-ku Osaka,
Japan 530-0053
Phone +81 6 4709 1070
Fax +81 6 4709 1071

Sefar Pty Ltd

3043 Tullamarine, Victoria, Australia
Phone +61 3 9330 1122
Fax +61 3 9335 2592

