Apparel Product Data Sheet

BEMIS

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Adhesives, Specialty Films & Seam Tape

Submitted by: R. Goodwin   **Date: 5/29/2014**   **Version: 1**

PRODUCT   **5256**

DESCRIPTION:
Bemis 5256 is a polyester based thermoplastic adhesive that produces excellent adhesion to cotton, poly/cotton and blended fabrics. Bemis 5256 exhibits excellent laundry and dry cleaning resistance. 5256 is compliant with Oeko-Tex Standard 100 Class 1 (Baby) as a Tin-free and Phenol-free adhesive

SUGGESTED APPLICATIONS:
5256 is engineered to produce strong bonds to garments and various materials.

PRODUCT BENEFITS:
5256 produces a durable bond which will withstand laundry and dry-cleaning. This adhesive is classified as a Tin-free and Phenol-free product as defined in the Oeko-Tex Standard 100 Class 1 (Baby).

COMPOSITION:
Polyester

THERMAL & PHYSICAL PROPERTIES
- Color: Hazy, Translucent
- Weight: 30 gm/m² (per 25 μm)
- Release Liner: Free Film
- Gauge: 76 μm (.003")
- Width: 1289 mm (50.75")
- Hand: Firm
- Wash: Excellent up to 60℃
- Softening Point: 125℃
- Melt Flow Index: 22 dg/min   Condition: 175℃ / 2.16 Kg Load
- Glue Line Temperature[1]:   149℃ to 191℃
- Recommended Bonding Conditions[2]:
  - **Flat Press**:
    - Machine Setting: 160℃ to 200℃
    - Dwell Time: 15-20 seconds
    - Pressure: 2.8-4.2 Bar (40-60 psi)
  - **Continuous Bonding Machine**: This adhesive is not recommended for continuous bonding

[1] Glue Line Temperature (GLT) refers to the temperature of the adhesive in the bonding process. Glue line temperature must be measured to receive accurate machine settings.

[2] Recommended bonding conditions will vary between different machinery and fabrics. The recommended conditions stated are a starting point only. Optimal bonding conditions should be established by the factory for the specific application.