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# SEFAR® Architecture TENARA® Fabrics

## Technical Information Procedure for RF welding

### Cutting for assembling

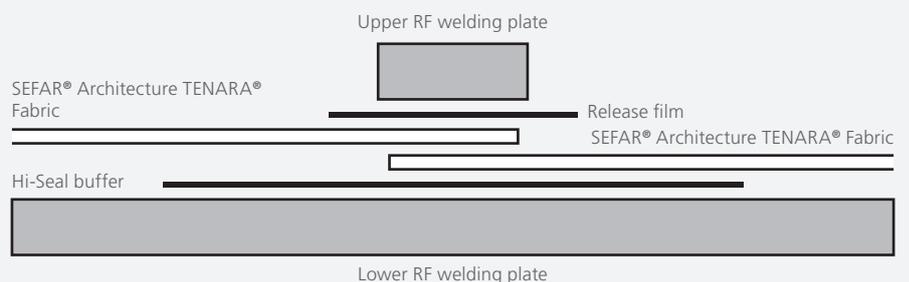
For cutting Tenara fabrics, we recommend sharpened tailoring shears. It is important to ensure a high sharpness of the blades. Tenara fabrics tend to fray slightly due to the tissue-penetrating coating. The cutline should be parallel as possible to the yarn path. However, if a loose thread exists, it can be cut off. This does not affect the fabric's properties.

### Radio/high frequency welding

1. SEFAR® Architecture TENARA® Fabric comes with a protective film layer on both sides. This must be removed from the fabric before welding.
2. It is important to insure that the fabric and the RF welding components are clean. Dirt on these surfaces can transfer to the fabric seams during the welding process.
3. See the side-view diagram below for placement of components in the RF welder.
4. Satisfactory welds can be made using Hi-Seal or an equivalent buffer (0.010 inch/0.25 mm thick polyester filmcovered paper) on the lower platen, and putting a release film between the upper bar and the fabric. Siliconecoated fiberglass cloth SRC-5 from Saint Gobain Performance Plastics is a typical release film, 0.003 inch/0.08 mm thick PTFE-coated fiberglass fabric also works well.
5. Typical process times are 3 seconds pre-seal, 6 seconds weld, and 3 seconds cool down.
6. It is good practice to have the upper bar temperature controlled for repeatable welds. 158° F/70° C is a typical control temperature.
7. Approximately 1 kilowatt of RF power per 5 square inches/32 square centimeters of weld area is a good estimate of the power required.
8. To insure that a satisfactory weld has been made, test the completed weld for the strength required.

**Time and temperature indications are only approximate empirical values. The effective machine settings have to be determined by the fabricator.**

### Side view of the welding device



This guideline can be changed any time without advance notice. The textile structure of SEFAR® Architecture fabrics are state of the art, slight variations in the appearance of the fabric are due to small differences in raw materials and production processes. Please consider all technical information and guidelines of SEFAR® Architecture.