

Miller Weldmaster

The below settings have been provided to Ultraflex by Miller Weldmaster Corporation and are to be used as a guideline only; settings may vary.

Product	Weld Type	Machine	Heat System	Welding Temp	Welding Speed	Vari-Drive	Weld Roller Pressure	Weld Roller Type	Cooling Time
PVC Front-lit Media									
BIOflex	Overlap Hem	112	Hot Air	1350	105		Medium	Steel	
		112	Hot Air	1350	180				
Ultima Supreme	Hem	T100	Hot Air	700	150	2.0	Light	Steel	
	Overlap	T100	Hot Air	900	150	0.0	Light	Steel	
	Hem	T100	Hot Wedge	700	250	1.0	Light	Silicone	
	Overlap	T100	Hot Wedge	700	200	0.0	None	Silicone	
	Hem	112	Hot Air	1000	225				
	Overlap	112	Hot Air	1000	175				
Normandy Pro	Hem	T100	Hot Air	700	151	2.0	Light	Steel	
	Overlap	T100	Hot Air	750	250	0.0	Medium	Steel	
	Hem	T100	Hot Wedge	700	200	1.0	Light	Silicone	
	Overlap	T100	Hot Wedge	700	200	0.0	None	Silicone	
	Hem	112	Hot Air	1000	220				
	Overlap	112	Hot Air	1000	175				
JetFlex	Hem	T100	Hot Air	675	200	2.0	Light	Steel	
	Overlap	T100	Hot Air	750	225	0.7	Light	Steel	
	Hem	T100	Hot Wedge	700	250	1.0	Light	Silicone	
	Overlap	T100	Hot Wedge	700	200	0.0	None	Silicone	
	Hem	112	Hot Air	1000	180				
	Overlap	112	Hot Air	1000	135				
SuperPrint Plus	Hem	T100	Hot Wedge	700	475				
Normandy Lite	Hem	T300	Hot Wedge	450	12		Light	Silicone	
	Overlap	T300	Hot Wedge	450	14		Light	Silicone	
	Pocket	T300	Hot Wedge	450	14		Light	Silicone	
UltraBanner	Hem	T100	Hot Air	675	250	2.0	Light	Steel	
	Overlap	T100	Hot Air	850	200	0.6	Light	Steel	
	Hem	T100	Hot Wedge	700	250	1.0	Light	Silicone	
	Overlap	T100	Hot Wedge	700	200	0.0	None	Silicone	
	Hem	112	Hot Air	1000	220				
	Overlap	112	Hot Air	1000	175				
SuperPrint Lite (welding FACE to FACE) <i>Preferred</i>	Hem	112	Hot Wedge	625	305				
	Hem	T100	Hot Wedge	625	305				
SuperPrint Lite (welding BACK to BACK)	Overlap	112	Hot Air	352	25		10psi/light		
	Pocket	112	Hot Air	352	25		20 psi		
	Hem	112	Hot Air	500	25		10 psi/light		
	Hem	T100	Hot Wedge	625	300				

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PVC Back-lit Media									
Vulite Pro	Hem	T100	Hot Air	700	130	2.0	Light	Steel	
	Overlap	T100	Hot Air	750	150	0.0	Light	Steel	
	Hem	T100	Hot Wedge	700	200	1.0	Light	Silicone	
	Overlap	T100	Hot Wedge	700	200	0.0	None	Silicone	
	Hem	112	Hot Air	1000	225				
	Overlap	112	Hot Air	1000	175				
PVC Mesh Media									
UltraMesh Supreme	Hem	T100	Hot Air	800	200	1.0	Light	Steel	
	Overlap	T100	Hot Air	800	150	0.0	Heavy	Steel	
	Hem	T100	Hot Wedge	700	150	1.0	Light	Silicone	
	Overlap	T100	Hot Wedge	700	150	0.0	None	Silicone	
	Hem	112	Hot Air	1000	200				
	Overlap	112	Hot Air	1000	170				
UltraMesh 100	Hem	T100	Hot Air	700	200	2.0	Light	Steel	
	Overlap	T100	Hot Air	750	150	0.0	Medium	Steel	
	Hem	T100	Hot Wedge	700	150	1.0	Light	Silicone	
	Overlap	T100	Hot Wedge	700	150	0.0	None	Silicone	
	Hem	112	Hot Air	1000	220				
	Overlap	112	Hot Air	1000	175				
UltraMesh Xcel	Hem	T100	Hot Air	700	150	2.0	Light	Steel	
	Overlap	T100	Hot Air	750	150	0.0	Medium	Steel	
	Hem	T100	Hot Wedge	700	150	1.0	Light	Silicone	
	Overlap	T100	Hot Wedge	700	200	0.0	None	Silicone	
	Hem	112	Hot Air	1000	220				
	Overlap	112	Hot Air	1000	175				
Strip Mesh Plus	Overlap	112	Hot Air	625	25		10 psi/light		
	Pocket	112	Hot Air	625	25		20 psi		
	Hem	112	Hot Air	525	25		10 psi/light		
PVC Blockout Media									
DSS	Hem	T100	Hot Wedge	600	500				
Ultrablockout Banner Pro 15 oz	Hem	T100	Hot Air	675	200	2.0	Light	Steel	
	Hem	T100	Hot Wedge	700	250	1.0	Light	Silicone	
	Overlap	T100	Hot Wedge	700	250	0.0	Light	Silicone	
	Overlap	T100	Hot Air	800	200	0.0	Light	Steel	
	Hem	112	Hot Air	1000	220				
	Overlap	122	Hot Air	1000	175				

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Textile Media ***Textile settings provided may have utilized Extreme Seam welding tape by Trivantage***									
Canvas Artist C325	Hem	T100	Hot Wedge	800	500				
Canvas Backlit U280	Hem	Mpulse	Impulse	High	12 sec				14 sec
	Overlap	Mpulse	Impulse	High	12 sec				14 sec
	Pocket	Mpulse	Impulse	High	12 sec				14 sec
Canvas Economy C205	Hem	T100	Hot Wedge	800	500				
Canvas Heavy C285	Overlap*	T-100	Hot Wedge	800	220		40 lbs		
Canvas Light C190	Overlap*	T-100	Hot Wedge	800	220		40 lbs		
Cotton C200	Hem	T100	Hot Wedge	750	250				
Flag PES C110	Hem	Mpulse	Impulse	High	12 sec				14 sec
	Overlap	Mpulse	Impulse	High	12 sec				14 sec
	Pocket	Mpulse	Impulse	High	12 sec				14 sec
	Overlap*	T-100	Hot Wedge	800	220		40 lbs		
Poplin Crystal U170	Testing in progress								
Poplin Pro U180	Hem	Mpulse	Impulse	High	12 sec				14 sec
	Overlap	Mpulse	Impulse	High	12 sec				14 sec
	Pocket	Mpulse	Impulse	High	12 sec				14 sec
Poplin PES C240	Hem	T100	Hot Wedge	600	400				
Organic U230	Hem	Mpulse	Impulse	High	12 sec				14 sec
	Overlap	Mpulse	Impulse	High	12 sec				14 sec
	Pocket	Mpulse	Impulse	High	12 sec				14 sec
Organic C265	Hem	Mpulse	Impulse	High	12 sec				14 sec
	Overlap	Mpulse	Impulse	High	12 sec				14 sec
	Pocket	Mpulse	Impulse	High	12 sec				14 sec

* These settings utilized Extreme Seam Tape

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Product	Weld Type	Machine	Heat System	Welding Temp	Welding Speed	Vari-Drive	Weld Roller Pressure	Weld Roller Type	Cooling Time
Discontinued Products									
SuperPrint Banner	Hem	T100	Hot Air	675	225	2.0	Light	Steel	
	Overlap	T100	Hot Air	800	300	0.0	Medium	Steel	
	Hem	T100	Hot Wedge	700	250	1.0	Light	Silicone	
	Overlap	T100	Hot Wedge	700	200	0.0	None	Silicone	
	Hem	112	Hot Air	1000	220				
	Overlap	112	Hot Air	1000	175				
SuperPrint 300	Hem	T100	Hot Air	700	200	2.0	Light	Steel	
	Overlap	T100	Hot Air	800	150	0.0	Light	Steel	
	Hem	T100	Hot Wedge	700	240	1.0	Light	Silicone	
	Overlap	T100	Hot Wedge	700	200	0.0	None	Silicone	
	Hem	112	Hot Air	1000	200				
	Overlap	112	Hot Air	1000	175				
SuperPrint 500	Hem	T100	Hot Air	700	175	2.0	Light	Steel	
	Overlap	T100	Hot Air	700	150	0.0	Light	Steel	
	Hem	T100	Hot Wedge	700	200	1.0	Light	Silicone	
	Overlap	T100	Hot Wedge	700	200	0.0	None	Silicone	
	Hem	112	Hot Air	1000	225				
	Overlap	112	Hot Air	1000	175				
SuperPrint 1000	Hem	T100	Hot Air	700	151	2.0	Light	Steel	
	Overlap	T100	Hot Air	750	200	0.0	Light	Steel	
	Hem	T100	Hot Wedge	700	250	1.0	Light	Silicone	
	Overlap	T100	Hot Wedge	700	200	0.0	None	Silicone	
	Hem	112	Hot Air	1000	220				
	Overlap	112	Hot Air	1000	175				
SuperPrint Pro	Hem	T100	Hot Wedge	850	750				