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Product	Weld Type	Machine	Heat System	Welding Temp	Welding Speed	Vari-Drive Pressure	Weld Roller Pressure	Weld Roller Type	Cooling Time
PVC Front-lit Media									
BIOflex	Overlap	112	Hot Air	1350	105		Medium	Steel	
	Hem	112	Hot Air	1350	180				
Ultima Pro FL Matte	Hem	T112	Hot Air	730	30	Clutch 35			
	Overlap	T112	Hot Air	730	23	Clutch 15			
	Pocket	T112	Hot Air	730	23	Clutch 15			
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				
SuperPrint Economy Eclipse	Hem	T300	Hot Wedge	430	12				
	Pocket	T300	Hot Wedge	430	12				
	Hem	T112-EX	Hot Air	730	45				
	Pocket	T112-EX	Hot Air	730	35				
	Overlap	T112-EX	Hot Air	730	35				
SuperPrint Banner	Hem	T200	Hot Wedge	400	10	0.2			
	Pocket	T200	Hot Wedge	400	10	0.2			
	Overlap	T200	Hot Wedge	400	10	0.2			
	Hem	Impulse	Impulse		13 sec				20
	Pocket	Impulse	Impulse		13 sec				20
	Overlap	Impulse	Impulse		13 sec				20
	Hem	T112-EX	Hot Air	730	35	Clutch 40	15		
	Pocket	T112-EX	Hot Air	730	30	Clutch 6	15		
	Overlap	T112-EX	Hot Air	730	30	Clutch 6	15		
	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	

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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				
Billboard 420'	Hem	T100	Hot Wedge	700	380				
	Pocket	T100	Hot Wedge	700	380				
	Hem	T112-EX	Hot Air	430	30				
	Overlap	T112-EX	Hot Air	520	25				
	Pocket	T112-EX	Hot Air	520	25				
PVC Back-lit Media									
Ultralon IV	Hem	T200	Hot Wedge	400	3	0.2			20 sec
	Pocket	T200	Hot Wedge	400	4	0.2			
	Overlap	T200	Hot Wedge	400	3.5	0.2			
	Hem	Impulse	Impulse		13 sec				
	Pocket	Impulse	Impulse		13 sec				
	Overlap	Impulse	Impulse		13 sec				
	Hem	T112-EX	Hot Air	730	20	Clutch 35	15		
	Overlap	T112-EX	Hot Air	730	12	Clutch 8	15		
Vulite Supreme	Pocket	T200	Hot Wedge	400	4	0.2			20 sec
	Overlap	T200	Hot Wedge	400	4	2			
	Hem	T200	Hot Wedge	400	5	0.2			
	Hem	Impulse	Impulse		13 sec				
	Pocket	Impulse	Impulse		13 sec				
	Overlap	Impulse	Impulse		13 sec				
	Hem	T112-EX	Hot Air	730	22	Clutch 35	15		
	Overlap	T112-EX	Hot Air	730	13	Clutch 6	15		
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				

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Product	Weld Type	Machine	Heat System	Welding Temp	Welding Speed	Vari-Drive Press	Weld Roller Pressure	Weld Roller Type	Cooling Time
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				
Strip Mesh Plus	Overlap	112-EX	Hot Air	625	25		10 psi/light		
	Pocket	112-EX	Hot Air	625	25		20 psi		
	Hem	112-EX	Hot Air	525	25		10 psi/light		
Speaker Mesh	Hem	T200	Hot Wedge	400	5	0.2	15		20 20 20
	Pocket	T200	Hot Wedge	400	4.5	0.2			
	Overlap	T200	Hot Wedge	400	4.5	0.2			
	Hem	Impulse	Impulse		8 sec				
	Pocket	Impulse	Impulse		8 sec				
	Overlap	Impulse	Impulse		8 sec				
	Hem	T112- EX	Hot Air	730		Clutch			
	Pocket	T112- EX	Hot Air	730		40			
	Overlap	T112- EX	Hot Air	730		Clutch 30 Clutch 30			
PVC Blockout Media									
DSS 12oz	Hem	T300	Hot Wedge	420	10				
	Pocket	T300	Hot Wedge	420	10				
	Hem	T100	Hot Wedge	600	500				
	Hem	T112-EX	Hot Air	730	38	Clutch 30			
	Overlap	T112-EX	Hot Air	730	25				
	Pocket	T112-EX	Hot Air	730	28	Clutch 25			

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Product	Weld Type	Machine	Heat System	Welding Temp	Welding Speed	Vari-Drive	Weld Roller Pressure	Weld Roller Type	Cooling Time
PVC Blockout Media									
DSS Pro 14oz	Hem	T300	Hot Wedge	420	12				
	Pocket	T300	Hot Wedge	420	12				
	Hem	T200	Hot Wedge	400	8	0.2			
	Pocket	T200	Hot Wedge	400	8	0.2			
	Overlap	T200	Hot Wedge	400	8	0.2			
	Hem	Impulse	Impulse		9 sec	Clutch 35			20
	Pocket	Impulse	Impulse		9 sec				20
	Overlap	Impulse	Impulse		9 sec				20
	Hem	T112-EX	Hot Air	730	30	Clutch 35	15		
	Pocket	T112-EX	Hot Air	730	40	Clutch 6	15		
Overlap	T112-EX	Hot Air	730	40	Clutch 6	15			
SuperSmooth PET	Hem	T100	Hot Wedge	750	400				
	Pocket	T100	Hot Wedge	750	400				
	Hem	T112-EX	Hot Air	540	30				
	Overlap	T112-EX	Hot Air	550	25				
	Pocket	T112-EX	Hot Air	560	25				
UltrarBlockout 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				
Pole Banner 18oz	Hem	T300	Hot Wedge	420	10				
	Pocket	T300	Hot Wedge	420	10				
	Hem	T112-EX	Hot Air	730	29				
	Overlap	T112-EX	Hot Air	730	23				
	Pocket	T112-EX	Hot Air	730	23				
UltraBlockout Banner Pro 20oz	Hem	T200	Hot Wedge	400	5	0.2			
	Pocket	T200	Hot Wedge	400	4	0.2			
	Overlap	T200	Hot Wedge	400	4	0.2			
	Hem	Impulse	Impulse		11 sec				20 sec
	Pocket	Impulse	Impulse		11 sec				20 sec
	Overlap	Impulse	Impulse		11 sec				20 sec
	Hem	T112-EX	Hot Air	730	22	Clutch 35	15		
	Pocket	T112-EX	Hot Air	730	16	Clutch 16	15		
	Overlap	T112-EX	Hot Air	730	16	Clutch 6	15		

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Product	Weld Type	Machine	Heat System	Welding Temp	Welding Speed	Vari-Drive Press	Weld Roller Pressure	Weld Roller Type	Cooling Time
Specialty Media									
AquaFlex	Hem Overlap Pocket	T300 T300 T-112	Wedge Wedge Hot Air	115 360 730	360 1.5 13 sec	Clutch 10		Steel	
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 Overlap Pocket	Mpulse Mpulse Mpulse	Impulse Impulse Impulse	High High High	12 sec 12 sec 12 sec				14 sec 14 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 Overlap Pocket Overlap*	Mpulse Mpulse Mpulse T-100	Impulse Impulse Impulse Hot Wedge	High High High 800	12 sec 12 sec 12 sec 220		40 lbs		14 sec 14 sec 14 sec
MultiTex C220	Hem Pocket Overlap	Impulse Impulse Impulse	Impulse Impulse Impulse		6 sec 6 sec 6 sec				20 sec 20 sec 20 sec
Poplin Pro U180	Hem Overlap Pocket	Mpulse Mpulse Mpulse	Impulse Impulse Impulse	High High High	12 sec 12 sec 12 sec				14 sec 14 sec 14 sec
Poplin PES C240	Hem	T100	Hot Wedge	600	400				
UltraTex Blockout C335	Hem Pocket Overlap	Impulse Impulse Impulse	Impulse Impulse Impulse		6 sec 6 sec 6 sec				20 sec 20 sec 20 sec