



# Tedlar®

polyvinyl fluoride film

## Tedlar® Heat-Sealable Film

### Introduction

Typical applications for *Tedlar*® heat-sealable film are fabrication of bags for use in gas sampling, and encapsulation of sound-absorbing ceiling tiles.

Heat-sealing *Tedlar*® PVF film to itself requires a clean, contaminant-free surface. When purchasing *Tedlar*® for thermal seal fabrication, specify non-adherable “S”\* surface film.

The tendency of *Tedlar*® to shrink at elevated temperatures must be taken into account when selecting heat-seal equipment.

Because of the tendency to shrink, it is essential that the sealer hold the film securely during heating and cooling cycles. Two types of heat sealers meet this requirement and are recommended for sealing *Tedlar*®: thermal impulse and rotary band.

### Heat-Seal Equipment

Because there are many heat-seal equipment suppliers and models available, the following heat seal recommendation is presented as a guideline to enable fabricators to optimize heat seal bond values on their equipment. The *Tedlar*® heat

sealing temperature is 204–232°C (400°–450°F) at 0.14 MPa (20 psi) jaw pressure. Most equipment dwell times at this temperature range are approximately a 1–2-second heat cycle followed by 3–4-second cooling period. These conditions vary slightly with film thickness.

### Impulse Heat Sealers

Vertrod Corp., 2037 Utica Avenue, Brooklyn, NY 11234, (718) 241-8080

### Rotary Band Sealers

Ralph Chaffee Company, 850 Mahler Road, Burlingame, CA 94010, (650) 259-1888

### Heat-Sealable *Tedlar*® Films

#### Pigmented Films

TGY85SL2  
(insulation bags)

TWH10SS3

TWH20SS3

#### Transparent Films

TTR10SG3

TTR20SG4

TST20SG4  
(gas sampling bags)

*Tedlar*® is a registered trademark of DuPont.

\* **Note:** For optimum results, only *Tedlar*® “S” types should be heat sealed.

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**For more information on *Tedlar*® films:**

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**CAUTION:** Do not use in medical applications involving permanent implantation in the human body. For other medical applications, see "DuPont Medical Caution Statement," H-50102.



**Tedlar**®

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