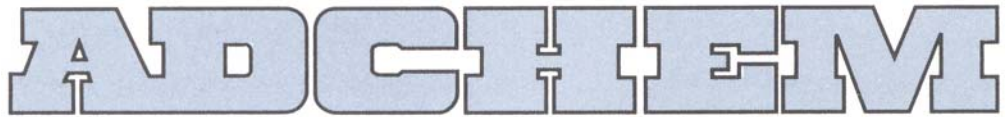




TECHNICAL BULLETIN

Adhesive Films • Double Coated Tapes
• Custom Coatings



APPLICATION GUIDE

APPLICATION TEMPERATURE

The recommended application temperature is 68°F to 100°F. Application with Heat Assist (warming adhesive just prior or during application) can aid adhesive flow and surface wet out. In general, 100 - 150° F is satisfactory, although individual applications will vary.

SURFACE PREPARATION

Surfaces to be bonded must be clean and dry. Contaminated surfaces (mold release, oil, dust) may be first cleaned with solvents such as isopropyl alcohol and allowed to thoroughly dry. When using a solvent, read, understand and follow manufacturer's recommendations and precautions.

Surface contact pressure is required to achieve bond. Bond strength developed is dependent upon a number of factors including specific adhesion, the amount of pressure, surface contact, and residence time.

EXPOSED SIDE BONDING

Only unwind enough material required to make the necessary bond. Do not allow adhesive to remain exposed to air for extended periods of time as dust, moisture, dry heat and other ambient conditions can reduce the effectiveness of the adhesive. Index the tape to the bonding surface, usually foam, and laminate with at least 50% compression. The use of a two-stage lamination process is recommended. The first stage applies the tape to the foam in the proper location using 10-25% compression, followed by the second laminator, which should provide the 50% compression to affect the bond. The use of heat during lamination will provide some flow to the exposed side adhesive and is sometimes found to improve the bond. In general, 100 - 150° F is satisfactory, although individual applications will vary. The fabricator is responsible for testing and determining the most effective method of bonding based on their substrates, equipment capabilities and the requirements of the product's end use.



APPLICATION GUIDE (Continued)

LINER SIDE BONDING

Only remove the liner when ready to make the final lamination. Do not allow adhesive to remain exposed to air for extended periods of time as dust, moisture, dry heat and other ambient conditions can reduce the effectiveness of the adhesive. Peel back the liner only as much is required to index the laminate to the liner side substrate. Do not put excessive pressure on the bond line until the part is properly placed. Apply adequate pressure to the entire bond line to ensure proper adhesion. The fabricator is responsible for testing and determining the most effective method of bonding based on their substrates, equipment capabilities and the requirements of the product's end use.

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