



## Double-sided adhesive tapes

### Processing Instructions

#### General information:

These processing instructions are intended to provide the user with the necessary processing instructions for working with adhesive tapes. In the event that these instructions are insufficient for individual purposes and/or additional information is required, we would be happy to advise you accordingly.

#### Processing temperature:

The optimum processing temperature (bonding elements and ambient temperature) is between +15 °C and +30 °C (60 °F and 85 °F). Adhesion operations below this temperature are not recommended. With the exception of special types of adhesive that can also be processed at low temperatures.

#### Surface cleaning:

To achieve an optimum bond strength, the bonding surfaces must be dry, free of dust, release agents and oil. Do not touch the bonding surface. A suitable solvent such as isopropanol should be used to clean surfaces. Please follow the manufacturer's safety instructions when using cleaning solvents. The cleaning tissue must be lint-free and should only be used once.

#### Surface condition:

Good bonds are achieved on smooth surfaces; rough surfaces require a thicker layer of adhesive. Problem-free bonding elements include: metal, glass, unplasticized PVC, polycarbonate. Difficult bonding elements include: PP and PE, powder-coated surfaces, rubber, plastics with lubricants, plasticized PVC and silicones.

#### Bonding pressure:

Pressure should be applied onto the adhesive tape by using a roller or a squeegee (contact pressure/guide value > 15 N/cm<sup>2</sup>)

#### Loading:

Designs that cause delamination stress or peel stress should be avoided. Shear stress and tensile stress have to be distributed over the entire bonded area. Mechanical stress at the end of the bonded components should also be avoided. The adhesive bond should be load-free for at least 24 hours.

**For further important product information and processing instructions, please refer to the test reports and the processing guidelines.**