

INSTRUCTIONS FOR THE APPLICATION OF ADHESIVE TAPES

General guidelines

This instruction shall provide the user with technical advice relating to the application of adhesive tapes. Should this advice not be sufficient for the individual purpose of application, or if supplementary information is required for the optimal application of the adhesive tape, please feel free to ask for our technical assistance.

Application temperature

The most favorable application temperatures (object temperature and application temperature) are between +15 °C and +30 °C. Adhesions below these temperatures are not recommendable. Exceptions are permitted only for particular adhesive tapes especially developed for lower temperatures. Please note:

- If an adhesive tape is subjected to low temperatures or if it is applied onto a cold surface, the pressure sensitive adhesive can become too hard. As a consequence, an optimal adhesion will not be obtained.
- Condensation of water vapor should be avoided. For example, if the adhesive tape has been stored in a cold room and is being brought into a heated production room, it should be given sufficient time to acclimate. The same is true for the surfaces on which the tape shall be applied.

Cleaning of surfaces

In order to obtain the properties indicated in the technical data sheet, the surfaces must be dry, free of dust, separating agents, oil and grease. Clean the surface prior to applying the adhesive tape. Observe security prescriptions for cleaning solvents. The cleaning cloth must be free from flushes and should be used only once. Do not touch the surface with fingers after cleaning.

Surface constitution

Excellent adhesions can be attained on plain surfaces. Rough surfaces require adhesive tapes of larger thickness. Non-critical assembling partners are metals, glass, rigid PVC, polycarbonate and ABS. More critical assembling partners are polypropylene and lubricants (such as mould release agents), soft PVC and polyethylene; powder varnish, rubber, plastics moistened with traces of silicones. Remarks:

- Porous surfaces (such as concrete) or fibrous materials (such as wood) require a cover layer of a sealing compound prior to applying an adhesive tape.
- Adhesions on soft PVC require a primer or particular adhesive tapes in order to diminish migration of plasticizers.

Pressure

Firmly press the adhesive tape onto the material surface by using a roll or a scraper. The pressure-sensitive adhesive on the tape requires an intensified pressure in order to develop its adhesive force.

Charge

Avoid constructions that generate a delamination load or a peeling tension. Shearing and tensile loads must be distributed over the entire adhesive surface. Tensions at the end sections of the assembling elements should be avoided. Please note: Permanent tensions impair the stability of the adhesion. The adhesive tape should not be charged with mechanical load earlier than 24 hours after installation.

Storage

Store the material in its original cardboard box at ambient temperature and a relative humidity of about 60%. Protect it against ultra-violet radiation. The duration of storage is indicated in the corresponding data sheet.

Check for suitability

All details and technical information mentioned above are based on laboratory examinations or on details provided by our material suppliers. All these details and information have been determined to the best of our knowledge. However, a warranty of completeness and correctness is excluded. Prior to the use of our product, it is necessary to check its suitability for the intended purpose of application. Questions relating to guarantee or product liability are governed by our general terms of business unless legal regulations provide other instructions.