

Instructions for use

Self-adhesive materials

General information

Self-adhesive materials should always be used in compliance with these instructions to ensure a permanent, secure bond and optimal adhesion to the appropriate surface.

Use

Preparation of the surface

When using self-adhesive materials, ensure that the surface is free of grease, oil, solvents or any other separating agents. The surface must be completely dry and largely dustfree.

To clean the surface, we recommend using pure, oil- and grease-free petroleum ether on a lintfree cotton cloth. After cleaning, the base material should be rubbed dry and left to air for at least 30 minutes to allow cleaning residues to evaporate. Other cleaners with the same cleaning effect may be used. Ensure that no cleaner residue remains on the base material.

Before cleaning varnished or plastic surfaces, test the cleaning agent in an inconspicuous area.

Different surfaces

- **Adhesion on untreated metal surfaces, e.g. galvanised sheet steel**

Further measures other than cleaning as described above are not normally required. It is vital to make sure, however, that the galvanised coating is abrasionproof and has good adhesive properties.

- **Adhesion on varnished metal surfaces**

Before adhesion, the varnish must have fully hardened; follow the instructions of the varnish manufacturer for drying times. This also applies to subsequent varnishing and improvements. Coating powders, in particular, can at times cause subsequent drifting of auxiliary products, e.g. waxes, which can then act like separating agents to weaken the bond after a while. In case of doubt, consult the varnish manufacturer or test for permanent bonding.

- **Adhesion on plastics**

Due to the multitude of standard plastics, no general statement can be made here. Before adhesion, we recommend testing the material for appropriate applications. It is important here that the plastic is free of other components such as softeners, separating and auxiliary agents which may drift into and destroy the self-adhesive layer.

Mechanical reinforcement

Additional mechanical reinforcement is recommended where special circumstances such as significant dead weight, condition of the surface, expansion, mechanical, thermal or other extraordinary loads occur which would put too much strain on the ordinary bond. Special safety considerations may also require additional mechanical reinforcement.

Instructions for use

Self-adhesive materials

Bonding procedure

Remove the protective sheet or foil (depending on component size and process), position the self-adhesive material without stretching or tension. Subsequently, affix to the base across the entire surface applying even pressure using a pressure roller. Avoid air bubbles, poor adhesion in places and soiling of the adhesive layer.

After removing the backing material, ensure immediate application as longer exposure of the unprotected adhesive layer to air may result in poor adhesion.

After initial application, the material cannot normally be readjusted due to strong initial adhesion.

The base and the self-adhesive material should preferably have the same temperature of between 18 and 25°C; do not use in temperatures below 15°C.

Leave the bond to set for 2 hours before applying mechanical load to ensure maximum adhesive strength. Leave for a period of 24 hours before applying thermal loads below +10°C and above +35°C.

Storage life

The minimum storage life of the self-adhesive material is 6 months from delivery, provided that the material is stored in dry, closed rooms at temperatures between +15 and +35°C. Do not expose the adhesive layer to direct sunlight.

Product-specific requirements

Where individual points on the data sheet of individual products deviate from these instructions, e.g. preparation of the surface, application temperature or storage period, the data on these individual sheets shall be applicable. All other instructions for use contained herein shall remain unaffected by this.

The technical data (mean values), material details and information are based on careful testing and many years of experience. Due to the particularities of each individual case, however, we cannot assume any responsibility for our instructions. Always test the material before use. On request, we are happy to provide further information.