

Processing recommendations

SKS Self-adhesive Foam



Bonding:

For secure bonding between the double-sided adhesive tape and the foam core pressure application as described below is absolutely necessary. Stadur does not assume any guarantee for further processing with various cover layers. We recommend to make test bondings beforehand.

Processing of double-sided self-adhesive tapes/SKS:

Processing temperature: The optimum processing temperature for adhesive tapes is between + 18°C and + 35°C. In case of bondings made at lower temperatures the initial strength of the bonding is reduced.

Surfaces:

Surfaces of the components to be joined must be dry and clean. Moisture condensation on the surfaces to be bonded (e.g. by transport of cold objects into warmer rooms) must be avoided. The components to be joined must be free from dust, grease, oil and release agents. Loose coats of paint or cover layers must be removed or solidified.

Cleaning:

To clean the surfaces use only clean cloths and material-compatible solvents, such as benzene, alcohol, esters or ketones.

Contact pressure:

Double-sided adhesive tapes are pressure-sensitive adhesive tapes. To obtain an optimum contact face pressure must be applied during bonding. Pressure (approx. 10 - 15 N/cm²) is applied via pressure roller, flat press or laminator. Full adhesive strength is only achieved after 24 hours minimum.

Avoid unnecessary loads:

Joints must be designed so that no leverage effect (nip load) occurs. Shearing and tensile loads must distribute over the entire bonding surface. Permanent peeling stress will impair the permanently elastic bonding (e.g. signs for curved surfaces must be pre-shaped accordingly). Tensions at the ends of the bonded components must be avoided.

Surface quality:

Good bonds are obtained on smooth surfaces; rough surfaces require thicker adhesive tapes. Metals, high-energy plastics (e.g. ABS, polycarbonate, rigid PVC), smooth wood, stone and glass can be bonded without problems. Care should be taken when processing plasticized plastics. The plasticizer of these materials may change the glue layer and thus impair the strength of the bonding.

Storage:

The SKS/self-adhesive tapes are to be stored at room temperature and normal humidity (50 - 70 %). Direct, permanent contact with sunlight is to be avoided. Storage should be limited to one year maximum.

Note:

Information about technical recommendations and processing instructions are provided to the best of our knowledge, but are not binding, and all liability is excluded. Customers and processors are not released from the obligation to test the goods by themselves for their suitability for the planned purpose.

