

### Surface characteristics

Please secure that the desired surface is dry, free from dust, oil, oxides, release agents, rust and other contaminations. On plain surfaces you will reach better adhesive joints. The varnish of coated surfaces has to adhere permanent and should be closed.

### Surface cleaning

Please use following cleaning supplies for removing dust, oil, release agents and other contaminations:

- Ethanol or heptane
- Acetone or methyl ethyl ketone
- Isopropanol/water 50/50
- Interflon® Fin Degreaser EM30+
- or other appropriate cleaning supplies which leave no residues and do not attack the substrate

### Following materials are particularly critical to bond:

- Polyolefin (polyethylene, polypropylene)
- Vulcanized rubber (ethylene-propylene-diene-monomer etc.)
- Powder coated material
- Silicone
- Teflon

### Processing temperature

The best processing temperature for our labels is between +15 and +25°C. Particularly the formation of condensate should be avoided. This happens when the desired material comes from cold storage rooms into warm production areas. At low temperatures the initial strength of the bond gets reduced.

### Contact pressure

The bond strength depends on the contact of the adhesive to the surface that should be bonded. A short, but high contact pressure, about 15-20 N/cm<sup>2</sup> (e.g. with a squeegee, a roller etc.) provides an exceptionally good surface contact. The type and amount of the contact pressure depends on the material (thin- or thick-walled etc.) and on the geometry of the components.

### Ultimate bond strength

Depending on the adhesive system the residence time to reach the ultimate bond strength takes up to 72 hours. The ultimate bond strength can be reached faster by a very high pressure and/or heating.

### Storage

The labels must be stored at room temperature and normal humidity (50-70%).

### Note

Above information represent current experiences of adhesive manufacturer and are not to transfer in the specifications. Please check before using our label on the original surface, if it is suitable for your intended purposes because of possible custom-designed influences.

### Instruction for applying the labels

