



# SONATECH

## **Processing Instructions for Foams with Self-Adhesive Backing**

### **Processing Temperature:**

The most favourable processing temperature for foams with self-adhesive backing is between + 18°C and + 35°C. The degree of initial bonding is reduced when bonding is carried out at lower temperatures.

### **Surfaces:**

The surfaces of the parts to be joined must be dry and clean. Moisture or condensation on the surfaces which are to be bonded (e.g. due to cold items being brought into warm rooms) should be avoided. The parts which are to be joined must be free of dirt, grease, oil and release agents. Loose coatings or top coats must be removed or hardened.

### **Cleaning:**

Only clean cloths and dissolvents which are compatible with the material such as petrol, alcohol, ester or ketone should be used for cleaning surfaces.

### **Surface Finish:**

Good bonding is obtained on smooth surfaces: more raw surfaces require thicker adhesive tape. The following materials can be bonded without any problems: metals, high-energy plastics (e.g. ABS, polycarbonate, rigid PVC), smooth wood, stone and glass. Care should be taken with unplasticized plastics. With these plasticizers the adhesive layer can alter, which affects the strength of the bonding. In the case of difficult surfaces (e.g. polyethylene, polypropylene, plastics with lubricant additives, powder mould, rubber) corresponding tests have to be carried out.

### **Storage:**

Foam with self-adhesive backing should be stored at room temperature and normal humidity (50 – 70%). Furthermore, it should not be exposed to UV rays. Foam with self-adhesive backing should not be stored for longer than 3 months after delivery and it is important to always store it in PE-film or to keep it securely packed in a box.

### **Overhead Adhesion:**

The self-adhesive backing (=SK) is merely to assist assembly, i.e. when sticking the material to an overhead surface, it is additionally necessary to secure it mechanically.