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APPLICATION GUIDE

Alamotape® Thermosetting Adhesive Tapes

5105, 5202

ESTABLISHING APPLICATION PROCESS

The lamination of Alamotape Thermosetting Adhesive Tapes is ideally conducted on a machine laminator using a nip roller capable of adjusting the nip pressure. While machine lamination is preferred, hand lamination can be performed using a squeegee or roller to squeeze out air and provide intimate contact of the adhesive film to the substrate. Intimate adhesive contact is the key to providing a good overall bond. The chosen process will depend on details of the specific customer manufacturing process or field conditions.

SURFACE PREPARATION

The surface on which the tape is to be applied can significantly influence tape performance. The substrate must be clean (no dust, debris, or grease). The goal for surface preparation and application is to obtain a laminate which is free of air bubbles and pockets.

TAPE APPLICATION

Alamotape Thermosetting Adhesive Tapes are supplied in roll form and are self-wound using a differential release liner. Pre-attaching is done at room temperature. The protective release liner is removed immediately prior to adding a secondary substrate to ensure a clean defect-free part. Any dirt or oil from the skin will compromise the tape adhesion. Follow these steps for adhering two substrates by hand:

1. Unroll 1-3" of adhesive and apply it to substrate aligning the edges. Avoid touching surface of adhesive.
2. Apply firm hand pressure with a squeegee or roller to anchor the adhesive to the end of the substrate.
3. Roll out the adhesive over the remainder of the sheet and, using a hand squeegee or roller, smooth the adhesive over the substrate surface to provide intimate contact.
4. Squeeze out air starting on the edge. Move squeegee in a pulling manner rather than pushing.
   Note: For substrate stock wider than the tape width, the tape sections can overlap adhesive edge to adhesive edge to provide complete coverage of the substrate surface.
5. Trim any excess adhesive/liner from the edges of the substrate.
6. Allow the adhesive to knit to the substrate by letting it rest for 1-5 minutes after application.
7. Remove the release liner at a 45° angle to expose the adhesive surface previously fixed to the first substrate.
   Note: If the adhesive lifts from the substrate, allow more rest time before removing the liner.
8. Place the secondary substrate over the exposed adhesive surface on the first substrate to join the two substrates.
9. Press the two substrates together to increase the adhesive contact between the two substrates.
   Note:
   - A hand roller can be used to press the two substrates, or a press can be used if available.
   - Increased pressure used for fixing the adhesive to the substrates and time after adhesive application both increase the adhesion and provide optimum bonding.
   - Thermoforming can take place immediately after joining the substrates or the adhesive can be allowed to rest for longer time to increase the initial adhesion prior to forming.