

Description

Thanks to an internal self-adhesive tape, KERAFIX® 2000 Premium is easier, cleaner, more economical and faster to apply than other products and variants. To take full advantage of this system, please observe the following application instructions.

Surface Finish

The surface to be adhered must be dry, free from dust, oil, grease, oxides, separating agents and other impurities. Moisture condensation on the adhesive surface (e.g. condensation on cold material in warm production rooms) must be avoided. If possible, adhere on smooth, closed surfaces.

Surface Cleaning

Only use clean, lint-free disposable cloths (paper/cloth) for cleaning the surfaces, using material-compatible solvents such as petrol, alcohols, esters or ketones. The cleaning agents/systems must not leave any residues and must not attack the substrate. When handling solvents and chemicals, follow the manufacturer's safety instructions. Never touch the adhesive surfaces. After cleaning, allow a drying time until the solvents have completely evaporated and then stick quickly to avoid re-soiling (dust/fingerprints).

Note

Solvents extract heat from the environment as they evaporate, so that the material cools down. There is a risk of condensation, so do not adhere until the material has returned to room temperature (RT).

Mechanical Surface Cleaning

If a suitable surface cannot be achieved with solvents, light sanding should be carried out (e.g. with oxides, release agents or powder-coated substrates). The adhesive surfaces should be cleaned with suitable cleaning agents before and after sanding. The solvent compatibility of lacquers and plastics must be tested.

Critical Surfaces

Critical surfaces are polyolefins, rubber, Teflon, silicones and powder-coated materials. Care should also be taken with plasticised plastics as the plasticisers can alter the adhesive. Therefore, a detailed test should precede, particularly for critical surfaces.

Temperature

A favourable application temperature is between 18°C and 25°C in dry rooms. Material and ambient temperature should be the same (hazard: formation of condensation). Avoid application temperatures below 10°C.

Note

At low temperatures the adhesive becomes too hard, at high temperatures too soft.

Pressing On

The adhesion of an adhesive tape is directly dependent on the contact that the adhesive has with the adhesive surfaces. Pressing on briefly ensures good surface contact.

Note

Ensure that the application equipment/hands are free of release agent!

Final Adhesive Strength

A set-up time of at least 24 h is required until the final adhesive strength is reached. Pressure and/or heat accelerate this process, as the flow behaviour of visco-elastic adhesive tapes is improved. Only then should the adhered materials be stored, transported or loaded outdoors.

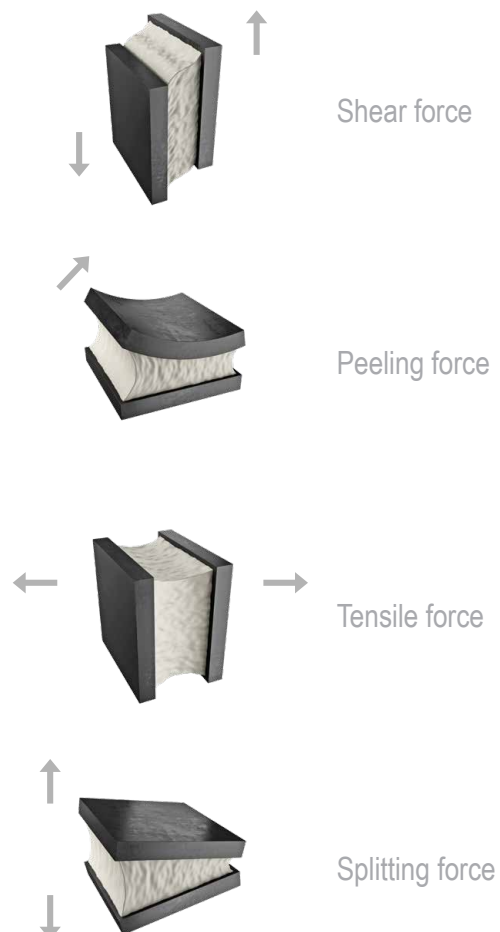
Load

The adhered joints must be constructed in such a way that no gap stress or peel stress occurs. Shear and tensile loads must be able to be distributed over the entire adhesive surface. Compressions and stresses at the ends of the joint partners must be avoided at all costs.

Note

Continuous tension affects the strength of the adhesion.

The adhesion should be loaded after 24 hours at the earliest.



Application of the Self-Adhesive Liner Tapes

Loosen the grip flap at an acute angle (approx. 180°) in order to be able to apply the one-sided self-adhesive KERAFIX® 2000 Premium with a precise fit. Apply the KERAFIX® 2000 Premium. Afterwards, the liner tape is lightly pressed on and cut to length. To optimisation the adhesion, the tape is pressed on evenly with a hard foam roller and then the final adhesive strength is waited for.

Note

Unnecessary loads (tension/compression) must be avoided at all costs. The final adhesive strength is reached after 24 h at the earliest.

Support Surface

The entire adhesive surface of the single-sided self-adhesive underlay tapes should rest on the substrate and contribute to the adhesion. It is strongly advised not to adhere one-sided self-adhesive liner tapes beyond corners (neither inside nor outside).

Storage

Self-adhesive liner tapes should be stored in the original packaging at RT (18 - 25 °C) and normal humidity (50 - 70 %) and protected from direct sunlight (UV light). Under these conditions they can be stored for about 1 year.

Application Steps

1. Cleaning/Drying
2. Loosening the grip loop at an acute angle
3. Removing the protected start
4. Precise fitting
5. Application
6. Cutting to length
7. Pressing on
8. Wait for final adhesive strength