



Usage instructions DuploCOLL® 26xxx OC

Processing

Preparation of the adhesive tape

- When unpacking, make sure that the material is not scratched or damaged by sharp edges, hard materials or other mechanical influences. The rolls should be stored hanging in the core or standing on the end faces.
- Before further processing, adjust the tape for 24 h to the appropriate processing conditions (20 °C, 50 % RH).
- Wear gloves to avoid fingerprints or nail marks.
- Die-cutting or cutting the adhesive tape can be done by strip cutting, cutting plotter and laser plotter. Weeding of the blanks should be done immediately after die die-cutting / cutting to prevent re-gluing of the cut edges.
- For cleanroom processing, remove the tape roll from the box before entering the cleanroom and transport it to the controlled environment.

Preparation of the bonding surface

- Surfaces and joining partners must be dry and clean. Moisture precipitation on the surfaces to be bonded (e.g. due to transport of cold objects to warmer rooms) must be avoided. The surfaces to be bonded must be free of dust, grease, oil and release agents. Loose coatings or top coats must be removed or consolidated. To clean the surfaces, use only clean cloths with solvents compatible with the material, such as benzines, alcohol, esters or ketones.
- For hydrophilic plastics such as polycarbonate (PC) and polymethyl methacrylate (PMMA), it is recommended to condition them in an autoclave after the laminating process.

Laminating process

Step 1: Remove the less tacky liner from the DuploCOLL® 26xxx OC and then laminate the adhesive tape with a roller in an automated process at 18 °C bis 35 °C onto the first substrate to be bonded.

Recommendation: roller pressure 0,1 – 0,2 MPa, roller speed 0,5 1 m / min

Step 2: Remove the more tacky liner and laminate the second substrate. Air bubbles can be avoided by vacuum lamination. The ideal lamination angle is 10 – 15 °

Recommendation: Vacuum conditions < 50 Pa, pressure 0,1 – 0,2 MPa

Step 3: Autoclave process

For optimum optical appearance and best possible temperature resistance, store the laminate in an autoclave.

Recommendation: 30 – 60 °C / 3 – 5 bar / 20 – 30 min

Storage

- Store in the original packaging or in a plastic bag.
- Avoid pressure or placing objects on the product to prevent dents or deformation on the surface of the material.
- Adhesive tapes must be stored at room temperature and normal humidity (50 – 70 %). Shelf life is 2 years after delivery.

Note

All information is given to the best of our knowledge and belief. However, they do not release the user from testing to determine the suitability of the adhesive films for the intended application. Our application engineering department will be pleased to provide technical advice..