

Guide for installing FluoroGrip® samples

Surface Preparation

Please follow the surface preparations carefully to ensure maximum product performance.

It is critical that the substrate surface to which you are bonding is clean. Remove surface contaminants with an appropriate solvent (a solution of 90% water/10% methanol or alcohol may be sufficient depending on the condition of the surface).

Wipe the substrate surface down and allow the solvent to evaporate. No surface roughening, etching, blasting or primer is required. However, loose rust, previous paint materials and contaminants must be removed.

When overlapping the film or top coating with a resin or adhesive, the film surface must also be cleaned with solvent to remove possible silicone contaminants from the release paper.

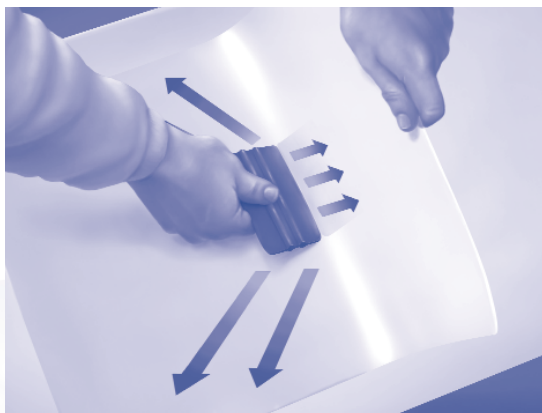
Application Instructions

Film application may be accomplished in a variety of ways depending on the intended use.

Round all corners to a minimum 1/2" radius using scissors or a sharp knife. Peel back the release liner and apply the leading edge of the adhesive backed film to the cleaned surface. Preferably, the film should be applied at room temperature, however, it may be applied at lower temperatures if necessary (to 40°F).

Apply the film slowly, removing the paper while smoothing the film. A rubber roller, plastic squeegee or other device may be used to assist with film application. Take care to minimize entrained air by working the film from the center outward toward edges. Once the film has been applied, vigorously bur-nish the film to enhance the bonding.

The film will display excellent initial bonding. However, adhesion will continue to improve with time, **achieving maximum bonding 14 days after application.**



Note

If the sample is for chemical service, the edges must be sealed with FluoroGrip SB-100 or SC-200 Fluoroelastomer edge-sealant or cap strip welded to protect the underlying adhesive. Follow surface preparation and application procedures on the sealants technical data sheet.

See reverse side for sample adhesion evaluation methods.

Call 716-873-1199 if you have any questions regarding the application requirements. Ask for the Technical Services department.

Integument

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Correct Methods for Adhesion Testing

The following information is provided to assist you in properly performing and evaluating adhesion tests on samples of FluoroGrip® contact film.

It is important to note there are distinct differences between traditional paints and coatings and elastomeric contact films such as FluoroGrip® in regard to the way these materials bond to a substrate. To evaluate and compare adhesion to traditional coatings and linings, do not pull up by hand. Doing so creates extremely concentrated stresses that do not properly represent the film's performance in application environment conditions. **Therefore, such a test method does not constitute an accurate evaluation of the adhesive bond.**

(Illustration A)

There are two correct methods – as outlined below – that you may use to accurately determine adhesive bond strength to your particular substrates.

Test Method – Peel Strength Test, 180° – ASTM D 903-98

TEST IN ACCORDANCE WITH ASTM D 903-98. Adhere test sample strips to a properly prepared substrate (see instructions on reverse side) and then exert a measured force 180° to the surface to pull off the strips

(Illustration B)

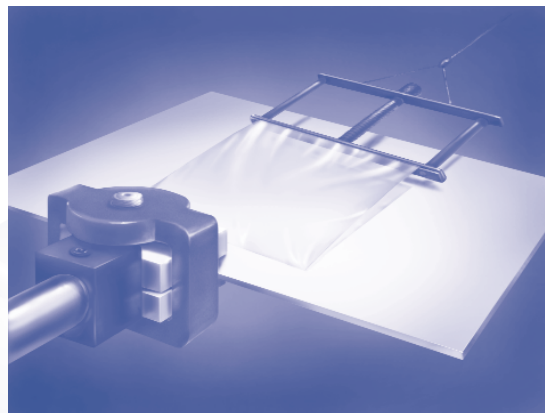
Test Method – ASTM-D 4541 Adhesion Pull

Adhere test samples to substrate and glue the test dolly to the top film (see instructions on reverse for surface preparation). Elcometer 106 tester utilizes a spring arrangement to apply a lift force to the dolly and indicator scale shows numerical value of the adhesion in terms of force required to remove samples.

(Illustration C)



A



B



C

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