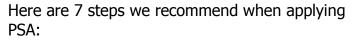


Technical Information

Installation of noise control material with pressure sensitive adhesive (PSA)

Long handle paint rollers with a short nap roller work best for applying reasonable pressure to acoustical foam with a pressure sensitive adhesive (PSA) backing. Roll over 100% of the foam after installation to assure good bonding of the PSA with the metal or plastic panel.

These rollers are available at any hardware store or Wal-Mart in the paint section.



- 1. Clean application surface of all dirt and residue.
 - Cleaners and degreasers will remove any unwanted residue such as overspray, oils, dirt etc.... from the substrate.
- 2. Thoroughly remove any cleaning solutions used with a 50/50 mixture of isopropyl alcohol and water.
 - Some harsh cleaners can leave behind a residue that can breakdown the PSA bond.
- 3. Wipe surface dry with a clean cloth after cleaning. Surface must be dry before application.
 - A dry surface is important. Any moisture left behind can create bonding issues.
- 4. Make sure installation temperature is above 50 degrees F
 - Temperatures below this threshold will cause initial tack problems.
- 5. Ideal temperature of installation would be from 60 to 80 degrees F.
 - Temperatures too low or too high will not allow the adhesive to set up properly.
- 6. Firm pressure must be applied to the entire part to ensure proper adhesion. Pressure rollers, jigs, fixtures or pressure plates recommended.
 - Laminate rollers are a great example of a way to apply proper pressure across the part.
 They can be found at industrial supply companies or home improvement stores.
- 7. Let adhesive cure for 24 hours before subjecting to major handling or outside environment.
 - This allows the adhesive to completely set up and bond to the substrate.

If all of the steps above are completed properly, your pressure sensitive adhesive will have a long-lasting bond to the substrate. When applying pressure sensitive adhesives, factors such as operating temperature, surface energy, plasticisers, etc. are important to ensure proper adhesion.

