



APPLICATION GUIDE Doubler-sided Thermalbond® V2100

To ensure maximum adhesion of your product you must carry out the following steps.

1. Always test all products under actual application conditions prior to commercial use.
2. The material should be stored at 21deg C.
3. The product must be applied at the application temperature recommended on the product data-sheet. This should be a minimum of 20deg C. If a temperature-controlled environment is not obtainable in cold weather, we recommend warming the product and the contact surface with a hair dryer.
4. For maximum adhesive performance, preparing the contact surface correctly is crucial. Always prepare the contact surface by removing dirt, wax or moisture with a cleaning solvent. A typical cleaning solvent is a 50/50 isopropyl alcohol/water mixture. For added adhesion, it may be necessary to seal and/or prime the contact surface with Tite-R-Bond.
5. Apply the tape to the first surface with the liner on, and then firmly rub down. Remove the liner just prior to bonding surfaces together and apply full pressure to ensure full adhesive-to-surface contact.
6. Although bond strength is dependent on the substrate surface, application temperature and dwell time, it is recommended that 24 hours dwell time at room temperature be allowed before loading.

Thermalbond® is a registered trademark.