

## Adhesive type 31

### Adhesive properties:

High strength 100 % acrylic foam adhesive with foil as release liner.  
High adhesive glue with slowly improving adhesive performance.  
Very good adhesion, which improves on aging, to most substrates.

### Adhesion:

**Peel strength : approx. 15 N/cm**

**Shear strength : approx. 60 N/cm<sup>2</sup>**

**All measurements relate to a self adhesive finished KLETTOSTAR<sup>®</sup> hook at room temperature.**

The bond strength is tested on a high quality polished steel in accordance with DIN 16864 and the Ford Spec. SKM-3G 9512-A.

### Temperature range:

approx. - 30°C up to + 160°C (short time) depending on the surface and load

### Softening point:

approx.. + 150°C, in accordance with Ford Spec. SKM-3G 9512-A

### Glue resistance:

virtually weather and waterproof

Resistant to ageing due to moisture and heat in accordance with Ford Spec. SKM-3G 9512-A

### Appearance (colour):

transparent

### Storage:

dry, dust-free, dark area, up to max. temperature + 25°C

### Shelf life:

in suitable storage 12 months

### Materials to be bonded:

Metal, stone, porcelain, glass, varnished parts and plastics, like PVC, ABS

### Test for suitability:

Because of different surfaces, environmental exposures (temperatures, moisture or wetness) operational load tests to determine the suitability are absolutely essential.

## Instructions for bonding

### Background:

The surface to be bonded must be free of grease, loose particles and moisture. In addition the surface must be suited to the adhesive; not too uneven, weathered, brittle, too soft, too unstable, saturated with softeners, furnished with flaking or glue-resistant lacquers or coats of paint.

The surface has to be pre-treated with:

acetone for metal/aluminium

lighter fuel for lacquered surfaces and plastics.

### Influence:

The adhesive must flow onto the surface and create full surface contact.

Best bonding results are reached when the surface and the self-adhesive coated tape have a temperature of at least 20°C.

Hard pressure is necessary (e. g. with a rubberized roller).

### Intensifying the bond:

By short exposure to heat, e. g. approx. 2 minutes hot air with 60-80°C or warming cabinet the bond can be intensified.

### Load:

Since the glue has to bond with the surface it is recommended not to put a weight on before 30 minutes (even better 2 hours).

### Removing surplus glue:

Useful solvents are e.g.:

lighter fuel, acetone, ethyl acetate

Important: Test suitability of surface before application, most important for lacquer and plastic surfaces.

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