

## Using Pressure Sensitive Adhesive on Flat Surfaces

### Application Guide

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Schneller's Pressure Sensitive Adhesive, PSLHR, is a factory-applied system selected for bonding Schneller decorative laminates. The adhesive system exhibits excellent adhesion to a variety of substrates including aluminum, stainless steel, vinyl, epoxy, and phenolic.

### General Information

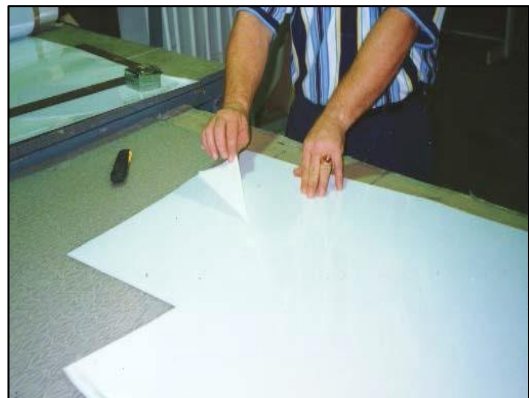
1. The surface of the panel to be covered must be clean and free of all dirt, grease, oil, or other contaminants. For best results, panel should be dry and wiped clean with isopropyl alcohol or Methyl Ethyl Ketone (MEK). Application temperature should be above 50°F (10°C).



2. Application procedures require at least two or more people (depending upon size of panel to recover) to apply, squeegee, and support the AerFilm LHR®. The use of a template to cut the decorative to size is very useful.



3. Peel the protective liner away from the decorative laminate back for approximately 2-4 inches (5-10cm) along one end or one edge of the material. Carefully align decorative to the panel if a design is present.



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#### General Information (cont.)

4. Hand squeegee exposed strip to the panel. Alternately, the release liner may be removed completely and the decorative may be touched down in the center of the surface to be covered. By initially adhering the decorative in the center of a large panel the chances of distortion and misalignment are minimized. After tacking in the center, squeegee to the top and to the bottom, one end at a time.
5. A second person should hold the free end of the decorative laminate taut and away from the panel surface. Progressively, pull the protective liner away and very slowly squeegee the decorative onto the panel surface.
6. Force all air from between the adhesive and panel surface by using **short overlapping strokes** with the application squeegee. All the air must be forced out as the material is first laid. It is not possible to go back and easily squeegee out trapped air.
7. Squeegee may be of nylon or Teflon (a non-scratching plastic) approximately 1/8 to 1/4 (3-6 mm) inch thick with tapered smooth edges to exert an even pressure across the edge of the squeegee. A clean cloth can be used as well.
8. The use of heat is optional. It should be used only if it is not possible to achieve a good bond at room temperature. A hot air blower (similar to a hair dryer) may be used for a heat source. Exceeding a glue line temperature of 125° F (52° C) will cause the pressure sensitive adhesive to become gummy.



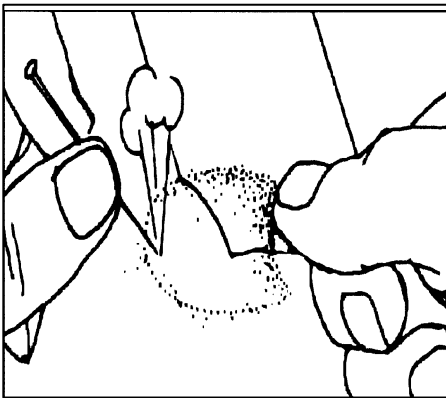
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#### General Information (cont.)

9. The AerFilm LHR® with PSLHR adhesive backing generally cannot be repositioned after application. The adhesive has no reinforcing carrier so it will stretch if repositioning is attempted. If air bubbles do occur, a pin, needle or other sharp instrument may be used to vent the air. Squeegee or finger press the air progressively around the bubble to remove the entrapped air.



AerTrim®LW, AerTrim®LHR and AerGlas LHR™ products are more user-friendly due to the stabilizing effect the glass reinforcement has on the product. Therefore, it is sometimes possible to reposition the decorative after application. If air bubbles do occur, a pin, needle or other sharp instrument may be used to vent the air. Squeegee or finger- press the air progressively around the bubble to remove the entrapped air.

10. The initial tack level of PSLHR adhesive is low to allow for “minimal” repositioning. PSLHR adhesive will build up adhesive strength as it ages on the panel. The adhesive will reach its maximum strength within 24-72 hours after application, depending on environmental conditions.
11. Edge trimming may be done with a razor knife or similar cutting device. A very sharp instrument is necessary due to the very tacky nature of the adhesive.
12. Contact adhesive is recommended for edge wrapping. The adhesive should be applied to the substrate and allowed to dry until tack-free per the manufacturers recommendations. The two surfaces can then be brought into contact with one another. It is not necessary to apply contact adhesive to the decorative with PSLHR.





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#### General Information (cont.)

13. A heat gun can be used to warm the decorative until it is soft and pliable. Once softened, the AerFilm LHR® can be wrapped over the edge of the panel and adhered to the backside of the panel.



#### Tools & Materials Needed

- Isopropyl alcohol and/or acetone
- Clean towel
- Masking tape
- Razor knife
- Template
- Contact adhesive
- Heat gun
- Squeegee
- Tape measure