

Indura GTglas® Application Procedures For PSA PSGT Backing on Flat Surfaces & 2-D Parts

Application Guide July

2020• Page 1 of 4

Schneller's Pressure Sensitive Adhesive, PSGT, 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, phenolic glass honeycomb and gel-coated FRP.

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 Indura GTglas. The use of a template to cut the decorative to size is very useful. The decorative is usually cut slightly

larger than the panel for installation. After application, the GTglas is trimmed to the exact size by guiding a knife along with edges and all trim pieces.

- 2a. Brush apply a thin coat of the 3M Fastbond 30 contact adhesive to the edges and along all trim pieces. It is important to apply the contact adhesive uniformly and evenly since "heavy" application areas will take longer to dry and may cause delamination. Allow the adhesive to dry so that it becomes tack-free per the manufacturer's instructions. If using a water-based adhesive, drying time will be longer than using a solvent-based adhesive. Heat guns may be used to decrease the drying time, if necessary. This secondary adhesive will ensure an adequate bond along all edges.



Indura™
railcar interior decor

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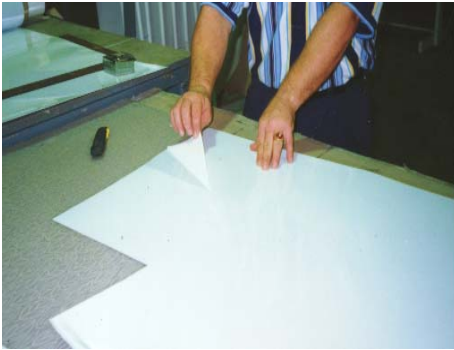
Indura GTglas® Application Procedures For PSA PSGT Backing on Flat Surfaces & 2-D Parts

Application Guide

September 2010 • Page 2 of 4

General Information (cont.)

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.



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 miss-alignment 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. Do not rush application.
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 rag can be used as well.
8. The use of heat is optional. Typically on flat surfaces when using the Indura GTglas, it is not necessary to use heat during the application. However, when applying the GTglas to a single-curvature panel, the use of heat will help to relax the material making it easier to bond. 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. Heat can also be used to shorten the drying time of the contact Fastbond 30 adhesive.



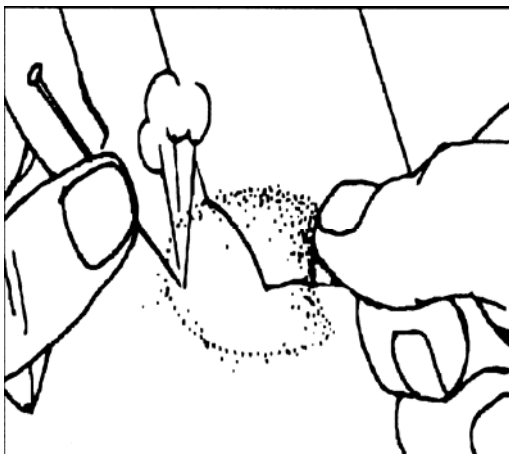
Indura GTglas® Application Procedures For PSA PSGT Backing on Flat Surfaces & 2-D Parts

Application Guide

September 2010 • Page 3 of 4

General Information (cont.)

9. The Indura GTglas 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 PSGT adhesive is low to allow for "minimal" repositioning. PSGT adhesive will build up adhesive strength as it ages on the panel. The adhesive will reach its maximum strength within 72 hours after application.
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 and durability of the GTglas product. Typically, it is possible to use the trim piece as a guide when cutting the material to exact size.

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 PSGT.



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

Indura GTglas® Application Procedures For PSA PSGT Backing on Flat Surfaces & 2-D Parts

Application Guide

September 2010 • Page 4 of 4

General Information (cont.)



Tools & Materials Needed

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