

## Heat Activated Adhesive

### Information Guide

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Schneller's HA211 is a thermoplastic heat-activated adhesive film. It is a factory applied adhesive selected for bonding Schneller decorative laminates to aircraft interior surfaces, including aluminum and epoxy or phenolic glass composites.

#### HA211 Features

- Self-extinguishing
- Adhesion to a variety of materials
- Non-tacky at ambient temperatures
- Moisture and chemical resistance

#### Typical Properties

COLOR	White
NOMINAL WEIGHT	< 2.9oz/yd <sup>2</sup> (<100g/m <sup>2</sup> )
THICKNESS	2.3mil
BOND STRENGTH	per ASTM 3167 or DMS 2291
- 25mm wide strip	
- strips peeled over wheel	
- substrate: MXB670-181	
- @ 73°F (23°C)	11 lbs./inch
- @ 158°F (70°C)	3.5 lbs./inch
SHELF LIFE	24 months from date of invoice <i>Material that has exceeded the shelf life can be tested by Schneller to determine the properties of the adhesive. Although Schneller cannot reissue a warranty statement, this data can be used to approve the continued use of the material.</i>
STORAGE	Store suspended in dry location at 40° - 80°F (4° - 27°C)

#### Application Guidelines

##### Surface Preparation

Surfaces must be clean and free of all dirt, grease, oil or other contaminants. For best results, aluminum and fiberglass should be dry sanded, wiped clean with alcohol or MEK and primed (see suggested primer sources\*) according to manufacturer's instructions.

##### Temperature for Vacuum Bagging

Application Temperature	212°F +/- 9°F (100°C +/- 5°C)
Vacuum	2 – 25" Hg depending on contour and composition of panel

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#### Removing Decorative Laminate Applied with Heat Activated Adhesive

The Schneller Heat Activated Adhesive system is a thermoplastic adhesive. It is possible to remove decorative applied with heat activated adhesive in the following manner:

1. The covered panel can be placed in a static oven or under a light bank. The panel is then heated to approximately 250°F. While the panel is still hot, the decorative can be stripped off the panel. This procedure may require several heating cycles because as the panel begins to cool, the difficulty in removing the old decorative increases.
2. It is also possible to use a heat gun to strip panels. Once again, a temperature of 250°F is recommended.  
**CAUTION: Care should be taken on composite panels that the outer skin is not damaged when stripping the old decorative off the panel.**
3. Once the decorative is removed, all residual adhesive must be removed. The residual adhesive can be removed with a rag/plastic scraper and acetone or MEK.
4. Panels shall be completely dry and have no detectable solvent odor prior to recovering. It is possible to place the panel in an oven to help accelerate the evaporation of solvent used to remove the residual adhesive.
5. Before recovering the panel, surfaces must be smooth and free from contaminants such as adhesive, solvent or sanding residues. Typically, panel surfaces are cleaned with isopropyl alcohol prior to starting the recovery process with new decorative laminate.
6. Panels shall be re-primed as necessary with special care taken to allow residual solvents in the primer to evaporate and recovered per one of the procedures mentioned earlier.
7. 3M manufacture a Scotch-Brite Molding Adhesive and Strip Removal Disk. These disks can be used to remove residual adhesive from many substrates without damaging the surface of the substrate. This product was developed for removing pin stripes from automobiles without damaging the paint surface. The disks can be purchased at most automotive retail stores. The disks are run on electric or air drills or tools. More information can be obtained from Scotch-Brite Surface Conditioning Products, 3M Abrasive Systems Division, 3M Center Bldg. 223-6N-01, St. Paul, Minnesota 55144-1000.