

Pressure Sensitive Adhesive

Technical Data Sheet

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Schneller's PSLHR is a fire-retardant, acrylic pressure sensitive adhesive. PSLHR is a factory-applied adhesive used to bond Schneller's decorative laminates to aircraft interior surfaces, including aluminum, phenolic and epoxy.

Features

- Self-extinguishing
- Adhesion to a variety of materials
- Lower initial tack that allows minimal re-positioning during application
- Maximum adhesion is reached 48-72 hours after application
- Compatible with most solvent-based and water-based contact adhesives

Properties

Typical Properties

Color:	White
Thickness:	0.002" (0.05mm) +/- 10%
Weight:	100 g/m ² +/- 15%

Typical Bond Strength

Aluminum substrate per ASTM D3167 tested at 21°C

- AerFilm LHR® with PSLHR = 2.3 pounds/inch
- AerTrim™ LW with PSLHR = 2.3 pounds/inch

Shelf Life

12 months from date of invoice

- Material that has exceeded the shelf life can be tested by Schneller to determine the properties of the adhesive. Although Schneller cannot re-issue a warranty statement, this data can be used to approve the continued use of the material.

Storage

Store suspended in a dry location at 40°F-80°F (4°C-27°C). Decorative laminates with PSLHR must be stored in the original packaging container until used.

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Removing Decorative Laminates with Pressure Sensitive Adhesive

It is possible to remove decorative laminates laminated with Pressure Sensitive Adhesive (PSLHR) by one of the following methods:

1. The existing decorative can be stripped using a heat gun. Temperatures less than 150°F (65°C) should be used. The hotter the adhesive is heated, the more “gummy” it becomes.
 - A. Citrus-based cleaners have also been determined to be effective in removing residual PSA. Once the existing decorative has been removed, the citrus cleaner is sprayed onto any remaining residual adhesive and allowed to set for a minimum of 15-20 minutes. The residual adhesive can then be removed by using a plaster scraper. This procedure may need to be repeated until all remaining residual adhesive has been removed from the panel surface. The panel should be wiped down with alcohol prior to starting the recovery process with new decorative laminate.
 - B. Once the decorative is removed, 3M Safest Stripper Paint and Varnish Remover has been found to be a good way to remove residual adhesive. The 3M product is available at all hardware stores. The Safest Stripper is brushed on the residual adhesive in a thick coat. Depending on the amount of adhesive that remains on the panel, the Safest Stripper should be allowed to set for one hour or overnight. The stripper remains active as long as it is wet; therefore, at times it is necessary to wrap the panel in polyethylene to keep from evaporating. The residual adhesive can be removed by gently scrapping with a putty knife and scrubbing with a 3M stripping tool. A 3M Heavy Duty Stripping Pad dampened with the stripper will then remove all residual adhesive. Panels should be rinsed down with alcohol and allowed to dry thoroughly before recovering.
2. 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.
3. A box filled with dry ice which has aluminum sheet on the bottom is passed over the decorative as if ironing fabric. Shortly after passing the surface, it is very easy to remove the decorative laminate without damaging the honeycomb. Residual adhesive was also easily removed.