

T-E-Klebetchnik

Anwendungs-, Verfahrens- und Dosiertechnik

Causes of incorrect bonding

Adhesive-related misbonding due to:

Adhesive sedimentation

Frost damage

Solvent loss

Adhesive overlay

Mixing up the adhesive

Incorrect adhesive selection

What can be done about it?

Check received goods after delivery. Observe storage conditions according to the manufacturer / supplier specification. For adhesives that exceed their MHD, a test bonding should be carried out.

Process related misbonding due to:

Insufficient mixing ratio

Incorrect cure time

Incorrect cure temperature

Flash off time too short

Too much or too little contact pressure

Exceeded pot life

No pre-treatment

Temperature fluctuations

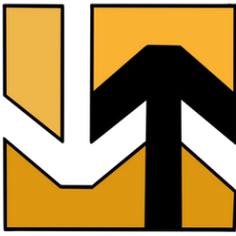
How do I avoid incorrect bonding?

Each adhesive comes with a technical data sheet. It contains all the important parameters required for perfect bonding. Recommendation: Follow the processing instructions in the technical data sheet.

<u>Invoice address</u>	<u>Cust. Center + Delivery address</u>	<u>Phone</u>	<u>Mail</u>	<u>Banking account</u>	<u>Banking account</u>
T-E-Klebetchnik	T-E-Klebettechnik	HQ +49 (0)511 353982-0	infotek@t-e-klebettechnik.de	Nord-LB	Postgiro
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Vahrenwalder Str. 131	Eckenerstr. 9	<u>UJST-ID-No.:</u> DE 358948140	<u>Internet:</u>	<u>0000 0101 0403 27</u>	<u>0030 0244 1893 00</u>
D-30165 Hannover	D-30179 Hannover	<u>EORI-No.:</u> DE 5193265	www.t-e-klebettechnik.de	BIC: NOLADE2HXXX	BIC: PBNKDEFF

The Supplier's headquarters is the place of execution. The goods remain the property of the supplier until full payment has been received.

General terms and conditions of purchase are valid and can be downloaded at www.t-e-klebettechnik.de/Images/AGB or AEB.



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Design-related misbonding due to:

Fractures due to stress peaks	Problematic design
Ageing factor	Surface design
Material properties	Peeling load
Static, dynamic, thermal and chemical loads	

How can I avoid design-related misbonding?

A joint listing of your requirement parameters with an adhesive technician minimizes the possibilities of faulty bonding.

Our experience enables us to show possible solutions in a mutual discussion.

Material related failed misbonding due to:

Low-energy surfaces	Moisture influences
Structural changes	Cavity inclusions
Ageing damage	

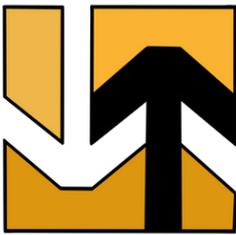
How can I avoid misbonding related to the material?

Check the materials to be bonded for the above points.

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Human error:

Personal influences of the respective employee (daily form and state of mind) can lead to different results.

How can I avoid human error?

We recommend that you document the workflow in order to improve repeatability even with employee rotation. Repeatable bonding should take place under the given conditions to ensure the same result. Ensure that the process is according to the work instructions.

Unpredictable causes:

Air humidity changes

Temperature fluctuations

What can I do about it?

We recommend that you carry out bonding processes in air-conditioned rooms if possible. For processing instructions, see the manufacturer's technical data sheet.

The information given here for the causes of incorrect bonding is of a general nature. No legally binding assurance of specific properties or suitability for any pretreatment of your Individual Materials can be derived from this information. The information given here is based on our current experience and knowledge. They do not constitute instructions for action.

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