



APPLICATION GUIDE

Stiffener Bars

External Factors



- When transporting and storing adhesive tapes ensure they do not come in contact with dirt, dust, grease, oil, moisture or other contaminants.
- When transporting and storing tesa® ACX^{plus}, all slit edges should be covered with suitable separators made of siliconized film. If several rolls are stacked two sheets per roll should be used.



- The recommended application temperature is between 15°C and 35°C.



- Appropriate cleaning solvents are acetone, 100% isopropyl alcohol, or our tesa® Industry Cleaner 60040.
- Use a lint-free cloth to clean the surface.
- You do not have to clean the full panel. Simply mark the bonding area and clean the designated section.

Tips & Tricks



- Avoid direct skin contact with the cleaning solvents and adhesion promoter – wear gloves.



- The workplace must be free of dirt, dust, grease, oil, moisture and other contaminants.



- Possible tape application tools are squeegees, rubber rollers, teflon edge tapers, and dispensers (manually or semi-automatic).
- Possible application tools for the tesa® Adhesion Promoter are a melamine sponge, application pen or a lint-free cloth.
- You do not have to prime the full panel. Simply mark the bonding area and prime the designated area.

Please contact your local tesa sales representative for more specific information about your application process.

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Process Steps



1 Clean stiffener with appropriate solvents using a lint-free cloth. Allow solvent to evaporate.



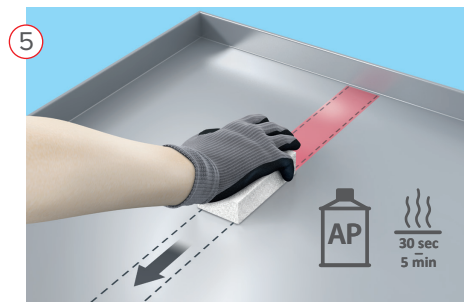
2 Shake the tesa® Adhesion Promoter can before opening. Apply tesa® Adhesion Promoter with a tool. Allow solvent to evaporate. Always close the can after usage.



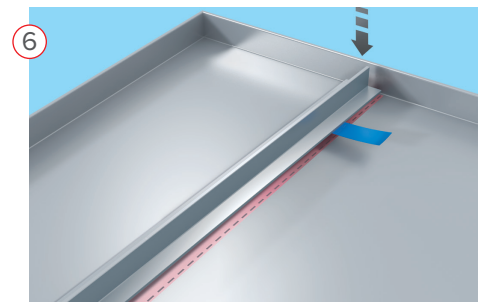
3 Apply tesa® ACX^{plus} onto profile.



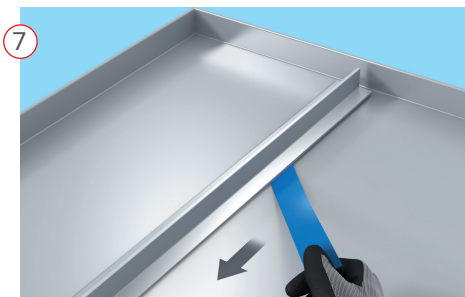
4 Clean panel in one direction with appropriate solvents using a lint-free cloth. Allow time for solvents to evaporate.



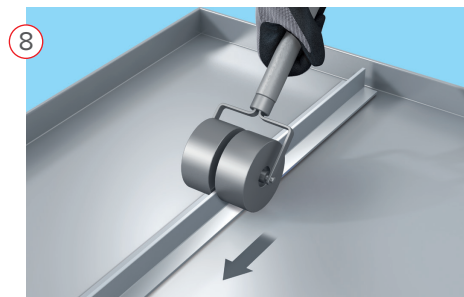
5 Shake the tesa® Adhesion Promoter can before opening. Apply tesa® Adhesion Promoter with a tool. Allow solvents to evaporate. Always close the can after usage.



6 Lift liner at one end and position profile.



7 Remove liner and apply light pressure by hand.



8 Apply sufficient pressure using a tool.