

CX6 ADHESIVE BONDING GUIDELINES

GENERAL GUIDELINES

- Bonding conditions will vary for each application and material type. These guidelines are intended to provide a starting point to determine the best process for your application.
- CX6 can be bonded to leather or other materials using a variety of adhesives which may work for your application.
 - Bonding is achieved by combination of time, temperature, and pressure.
 - Processing conditions are important to achieve optimum bonding and to avoid surface appearance (glossing) changes to CX6 material and the mating material. Increasing temperature will decrease time, but may contribute to glossing or material softening.
 - Bemis 3218 adhesive 5MIL has been used successfully; this type of adhesive has a relatively low bonding temperature and is available in various thicknesses.
- Process development guidelines:
 - Adhesive can be applied in 2 ways:
 - Bond adhesive to CX6, then quickly bond adhesive to mating material.
 - Bond mating material to adhesive, then quickly bond adhesive to CX6.
 - Recommended temperatures:
 - 170°F to 240°F (use lowest possible temperature for application to achieve proper bonding and to avoid glossing surface).
 - CX6 should be farthest from heat source. For example, if using a single platen heated press, the CX6 material should be away from the heated platen.
 - Material type and thickness will impact the heat transfer and optimum process.
 - Utilize press release papers and/or silicone pads when pressing to avoid glossing carbon surface.
 - Process Example:
Material: Bond CX6 to leather using Bemis Sewfree adhesive.
Temp/Pressure: 180°F (82°C) / 5 PSI using single heated platen press. Time: 10 to 30 seconds
Patina release paper is used to prevent transfer of platen surface finish to CX6.