TECHNICAL BULLETIN

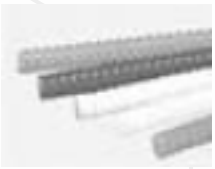
Hot Melting Technique for Adhering Edges of ALPOLIC/fr Core Products

An edge of ALPOLIC/fr can be connected to another edge through a hot melt applicator or hot gun. The connected point is usually less strong, so we advise reinforcement after adhering of the core.

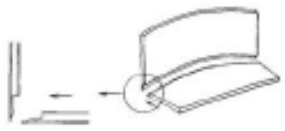
1. a. Example of hot melt applicator

b. Example of a hot jet gun

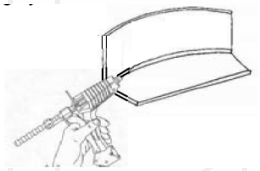
2. Adhesive



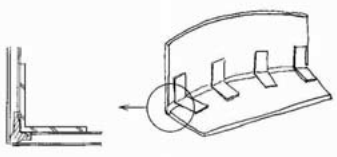
3. Milling for adhering



4. Adhering by hot melt



5.Support plate



1. Tools for adhering

a. Hot melt aplicator or glue gun (i.e. 3M Polygun for hot melt)
b. Hot air supply machine: hot jet gun for thermoplastic resin. A dryer for residential use can also be used with a small nozzle attachment.

2. Adhesive for adhering

Hot melt adhesive rods, such as 3M Scotch Weld may be used

3. Milling for adhering

Mill our route ALPOLIC/fr panel edge with grooving or routing machine to fit to adhering.

4. Adhering

Prior to adhering, pre-heat the tip of the hot melt adhesive rod and ALPOLIC/fr core surface with hot jet gun. When the ALPOLIC/fr core surface becomes wet, slide the nozzle of the hot jet gun with a feeding speed of 10 to 15cm (4 to 6 inches) per min. Then apply hot melt glue by the applicator.

Note 1: The temperature of the air blown from the hot jet gun is approx. 130°C (270°F) around the adhering area.

Note 2: Heating too much will cause a thermal decomposition of the core material, and the hot melt will not adhere to the core.

5. Reinforcement with support plate

Finally, adhere a support plate of ALPOLIC/fr or aluminum sheet with a suitable adhesive or a both-sided tape, to reinforce the adhered point.

Note 3: In case adhesives are applied for the reinforcement, pre-testing is necessary to confirm that the adhesive does not cause a distortion on the surface side, since some adhesives will cause a distortion due to shrinkage after hardening.

Need assistance?
Contact our on-staff Technical Support Team by calling 800.422.7270 or by emailing them at technicalservices@alpolic.com