



### 221 Heat-activated Dry Film Adhesive

#### Technical Data Sheet

Thickness	.0006" and up	
Estimated cost (large volume)	Call or email for pricing.	
Width	≤ 76.5" breathable / acoustical / perforated ≤ 118.1" non-perforated	
Minimum glue line pressing temp.	284° F	140° C
Heat resistance	212° F	100° C
Wash resistance	140° F regular 86° F Fire retarded	60° C regular 30° C Fire retarded

#### Recommended bonding surfaces

Wood veneer, Particle board, Paper, Cork, Glass, Leather, Metals, Aluminum, PUR, PE, Poly Amids

DRIBOND Dry Film Adhesives  
Hot Pressing Tips for Platen Presses

#### Wood Veneer Pressing Instructions:

1. Check the press temperature and heat/temperature gauge accuracy.  
(Leave press at the normal settings and use Temperature Tape from Paper Thermometer, Inc.(603)547-2034 www.paperthermometer.com)
  - A. Place the temperature tape in between the normal surfaces to be bonded. Do not apply any adhesive! Apply 5 strips of temperature tape at the glue line location, one in each corner and one in the center. Put the two surfaces together with the temperature tape in between.
  - B. Press at your normal press time and press setting.
  - C. Remove and separate the surfaces and read the maximum temperature reached on each temperature tape. Compare each tapes reading to one another and to the gauge on your machine for accuracy. Make note if variation is found.
2. Select a DRIBOND Dry Film Adhesive that has a "minimum glue line bonding temperature" similar to your machines temperature from the Comparison Selection Chart.
  - A. Do not over heat glue line.
    1. Thermo Plastic Adhesive does not need a curing time. It simply needs to reach its required bonding temperature while under low pressure, 10 PSI is usually enough.
  - B. Surfaces must be in complete intimate contact.
    1. Press platens must be accurate
    2. Surfaces being bonded must have accurate thickness, the very thin DRIBOND Dry Film Adhesive must contact all surfaces being bonded.
    3. In some cases higher pressure must be used if adequate contact is not achieved.
    4. Press blanket of rubber/silicone or cotton fabric are often used if irregular thickness veneers/surfaces must be bonded. Press blankets normally range from 1/16" (.062") to 1/8" (.125"). Keep in mind press blankets often require a higher temperature heated press platens or longer pressing times since the heat transfer is slowed.
3. Check vapor/moisture content of surfaces to be bonded.
  - A. The lower the vapor heating potential from heating the better. Vapor comes from water in wood or from solvents in vinyls and plastics.
  - B. A moisture content of 4-8% based on oven dry weight is generally OK.
    1. Small cut-to-size panels are not so sensitive since there are easy vapor escape routes.
    2. Large sheets (4' X 8' -5' X 12') are more critical re vapor build up.
  - C. Larger high moisture content veneer/surfaces
    1. Pre-press surface hot (same as normal bonding press cycle and heat)
      - a. Moisture will steam off/flash off
      - b. Use low temperature (below 210° F) option.
    2. Breathe press at 1/3 time into pressing cycle. This can be done in normal press cycle with the adhesive between the surfaces.
4. Removing the panel from the Hot Press
  - A. Keep panel perfectly flat until cooled to approximately 150°F. (150°F is about as high of a temperature as uncovered hands can handle) ie touch the panel with a flat hand to determine if the panel is still to hot to move.
  - B. Panel is now ready to process or flex etc.

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