

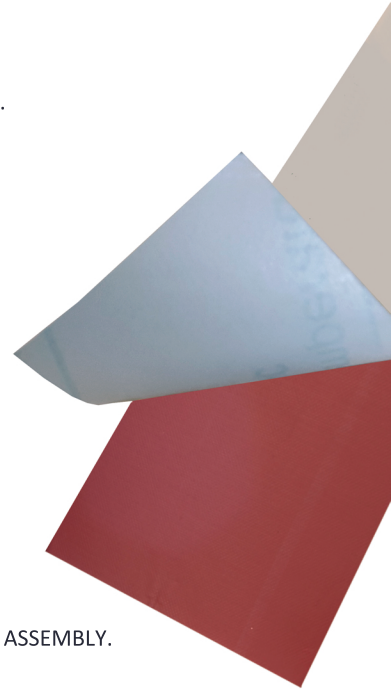
# Heater Mounting Instructions

## Preparation

It is of utmost importance that proper training exists for the team members assembling the heater sub assembly. They should follow the instructions below as best as possible.

## Instructions for mounting flexible heaters with silicone based adhesive

1. The ambient temperature during assembly should not be less than 10°C and  
The best application conditions are obtained at a temperature of 21°C ± 11°C and 50% ± 20% RH.
2. Ensure that the heat sink surface is completely clean from oil, dust, moisture and other contaminants.  
Wipe the surface with a lint-free cloth moistened with a suitable solvent such as isopropyl alcohol.  
NOTE: Use proper safety precautions for handling solvents.
3. With the PSA release liner still intact, place the heater onto the heat sink in the desired position.  
Once the desired position is achieved, peel off the release liner from one corner of the heater maintaining an angle as close to 180° as possible while leaving the remaining release liner intact. Tweezers may be helpful for lifting the liner. Avoid touching the exposed PSA. Apply the heater to the heat sink in its correct position, beginning at the corner edge of the exposed PSA using firm, even hand pressure.
4. Slowly peel off the remaining release liner from the PSA while adhering exposed PSA to the heat sink.  
Work from the adhered end outward to avoid trapping air. For flat surfaces it is recommended to use a rubber roller\* to press the heater onto the heat sink.  
NOTE: Trapped air can create hot spots and cause shorter lifetime of the heater.  
NOTE: If air bubbles occur, the heater is scrapped. DO NOT CUT INTO THE HEATER TO ALLOW AIR OUT OF THE ASSEMBLY.
5. We recommend leaving the lamination set for 24-72hours to ensure optimum bond.
6. Heating elements with silicone based Pressure Sensitive Adhesive should be stored at room temperature and 30-70% RH.



## Benefits silicone based PSA's

- High performance silicone adhesive
- Outstanding high/low temperature performance
- Polyester release liner
- Tear resistant liner

\* Examples of silicone rubber rollers:



Silicone based Adhesives

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