
Bonding nora® EVA sheets

product advice & information sheet

Bonding recommendation for nora® EVA sheets

Grind or roughen the two materials you want to stick.

Spread with neoprene adhesive or polychloroprene adhesive, and leave to air for a sufficient time, at least 10 minutes.

Additional activation to approx. 50° C will reinforce the adhesive effect.

Bring the adhesion partners together, and apply light pressure to bond them.

In the case of soft, lightweight materials like nora® Lunairmed and Lunairflex, work with carefully quantified pressure, so as to avoid any compression of the materials, which will impair their elasticity.



Activation:

For successful bonding and thermoplastic forming, proper warming of the EVA is vital. Enclosed heat sources, such as an oven, should always be given preference.

One-sided warm-up by means of a hotplate should be used only up to material thicknesses of 8 mm, since otherwise even warming throughout the entire material cannot be assured.



Temperatures:

110° - 130° C: Lunairmed, Lunairflex, Lunalastik

120° - 170° C: Lunasoft SLW, Lunasoft SL, Lunasoft AL, Lunalight A und Lunacell A

The temperatures stated will vary in dependence on the thickness and density of the material involved.

Cooling:

The cooling process after thermoplastic forming can be accelerated by applying a cold, moist rag or cloth.

Copyright © Freudenberg Bausysteme KG 2003