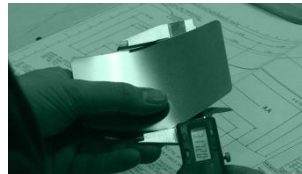


Fitting CLD's

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Packaging Alternatives

- CLD's normally come in the form of Kits
- Alternatively Full Sheets are available
- Standard Sheet Sizes are 2x1, 2x1.25 & 2.5x1.25

Fitting CLD's

- A Clean surface is **Very Important**
- A temperature greater than 10 Celsius is **Very Important**
- A consistent application pressure over the whole surface is **Very Important**
- The rest is easy!!!

Tools



Fitting Orientations

- Horizontal Down e.g. Floor
- Vertical e.g. Bodyside
- Overhead e.g. Roof

FAQ

- Can CLD's be fitted onto a painted surface? **Yes but the paint must be suitable and the bond strength is only as good as the weakest link which may be the bond strength of the paint. Check the compatibility. E.g. Silicone-No, Epoxy-Yes**
- What do I do if I am having trouble bonding the CLD? **Check the surface sometimes surfaces are contaminated with invisible coatings e.g. Silicones. Is there anything preventing the CLD coming into contact with the surface e.g. Weld Spatter. Use heat to improve the "instant grab" of the CLD.**

FAQ

- Can I weld through CLD's?

Low intensity welding process such as spot, brazing , TIG and MIG can be used with thin CLD's. The polymer in the CLD will vaporise and there will be a void around the weld. Good fume extraction is needed and the process should be fully tested.

- Can we paint over CLD's?

Yes

- Can we cut CLD's ourselves?

Yes but you must ensure that there is a very good cut edge as any Burrs or Distortion of the CLD will prevent Bonding.

Positioning of CLD's

- Alignment is not critical to performance but it looks “neat”
- Simple positioning “jigs” are useful
- Large or long CLD's may require 2 people
- Remove liner in one corner to position then check that remainder is aligned.
- Remove remaining liner and tack in place by hand

Bonding

- As soon as practical after the CLD has been positioned it should be bonded by the application of Pressure using a suitable roller.
- Reasonable hand pressure is adequate but it should be applied at a steady speed over the whole area.
- After bonding other manufacturing operations can proceed even though full bond strength is not attained for 24 hours.