(USA) **Installation**

ADB covering strips must not be used with damping carriage RUDS.

Covering strips should be attached only on properly mounted guideways.

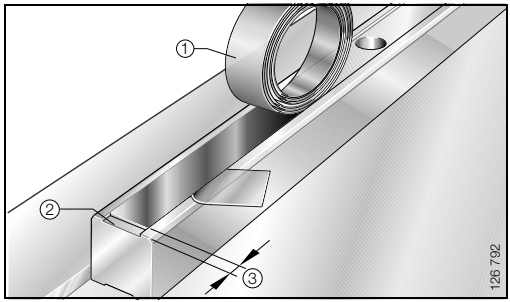
The strips are fixed by adhesive means in the groove on the top of the guideway, which must be clean, dry, and free of any lubricant residue.

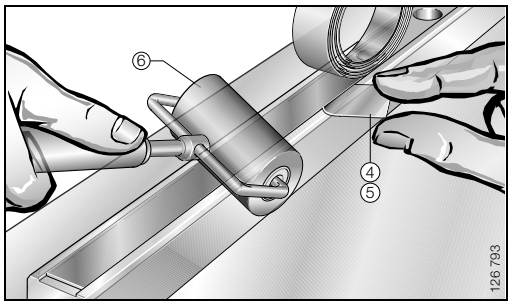
Refer to instructions on the back of this page for working with 3M-brand adhesive tape.

Affixing the covering strip must not damage or impair the function of the lip seals on the carriages.

- Unroll a short length of the covering strip ① and place it, adhesive side down, in the groove ② on the top of the guideway.
  - Set the beginning edge of the covering strip approximately 2 mm in from the end of the rail ③.
- Peel back about 30 mm of the protective backing from the covering strip ④ and fold it over diagonally ⑤.
- Align the strip correctly in the groove and press it onto the guideway – using, for example, a pad roller ⑥.
  - Bond strength is dependent on the pressure exerted.
- Continue removing the protective backing ④ and pressing the covering strip until the guideway is completely covered.

The final bond is set after about 72 hours at room temperature.





Instructions for Working with 3M-Brand Adhesive Tape

Adhesive tape must be handled with care before and after use and should be affixed only in accordance with the following guidelines.

Adhesive connections with materials such as polyolefines (polyethylene, polypropylene), rubber, silicone, and powder-coated materials are especially critical.

Chemical Cleaning of the Bonding Surface

The bonding surfaces must be dry and clean, and the materials to be bonded must be inherently stable. The surfaces should be cleaned of all impurities, such as dust, oils, oxides, stripping agents, etc., using clean, lint-free paper towels. Bonding should be performed immediately after cleaning, and the surfaces should be protected from any new contamination, such as fingerprints.

A mixture of equal parts isopropyl alcohol and water, or cleaning agents such as acetone and heptane may be used to remove these types of contaminants; however, the suitability of a solvent is always dependent on the specific material to be cleaned.

Cleaning must be carried out in compliance with the applicable legal regulations governing the handling of cleaning agents (manufacturer specifications, work safety regulations, environmental protection laws, etc.), and procedures for the proper disposal of used cleaning materials must be followed.

Mechanical Cleaning of the Bonding Surface

In some cases, involving oxides, stripping agents, and powder-coated materials for example, a clean surface can not be achieved using the cleaning agents described above.

To obtain a clean bonding surface in such cases, the surface can be cleaned with an appropriate cleaning agent and lightly ground. After grinding, the surface must be thoroughly cleaned of grinding swarf – if the surface is plastic or painted, compatibility with the cleaning agent must be checked beforehand.

Ideal Operating Temperature

Best results are obtained with adhesive tape when the (object and ambient) temperatures are between +15 °C and +25 °C.

Special care must be taken to avoid condensation, which can be caused by a temperature change when moving from a relatively cooler storage temperature to a warmer temperature in the production area.

Bond Strength

The bond strength depends on the contact between the adhesive and the bonding surfaces. Heavier pressure – applied with a pad roller or a squeegee – results in good surface contact.

Final Bond

Depending on the adhesive system used, curing to a final bond requires up to 72 hours – for example, in applications involving acrylates. However, by applying pressure and/or warmth, which improves the flow properties of the viscoelastic adhesive, this curing process can be accelerated.

Storage

Unused adhesive tape can be stored as follows:

- Up to six months after receipt by the customer, in the original packaging, at a relative humidity of 50% and a storage temperature of +20 °C.