Installation Procedure For DuraSurf STS on Slider Bed

Supplies Needed

Lacquer thinner, wiping cloths, tape measure, box knives, Sharpie marker, 2 spacers based on the width between strips (can be made from cardboard and adhere a piece of DuraSurf to one side to aid in sliding the spacers), 3/16" pop rivets, pop rivet tool

Note: For new slider bed or powder coated slider bed, a wipe down with lacquer thinner to clean the slider bed may be sufficient. If working with a bed that is older and experiencing a lot of rust or oxidation as well as contamination, the degreaser cleaner with the floor scrubber is recommended.

I. Surface Preparation on Slider Bed

When working with products that are pressure sensitive in nature, proper surface preparation is imperative. We recommend using a Lacquer Thinner to clean the bed as it does not evaporate too quickly and does not leave a residue.

Step 1

Air blow the slider bed to remove dust and dirt particles, especially in the seams and along the sides. A wire brush or wheel can be used to remove any heavy buildup of reversion or corrosion. This can help speed up the cleaning process.

Step 2

Wearing latex gloves liberally apply the lacquer thinner to a wiping cloth and thoroughly wipe down the slider bed, turning the wiping cloth frequently to avoid recontamination. If the slider bed is severely contaminated, a second solvent wipe may be needed. If contamination continues to appear on the cloth, continue with the solvent cleaner until the cloth is coming up virtually clean**.**

II. Installing the DuraSurf Strips

The following steps are to assure proper alignment of the Durasurf strips and prevent contamination of the adhesive backing.

Step 1

Make Reference Marks using a Sharpie marker and a tape measure, go down the slider bed and make reference marks based on the gap between the first strip and the side pan. The reference marks should be made about every 24 inches down the slider bed.

Step 2

Once the reference marks are in place, take a roll of the DuraSurf STS material and roll out the entire roll down the length of the slider bed. Line the product up to the reference points. Doing your best to **refrain from contact with the adhesive with your fingers,** remove the release liner from the first 12” or so of the STS material and press in place.

Step 3

Begin with the downward taper or the leading edge of the slider bed and using a roller, apply pressure to help hold in place. We recommend installing two pop rivets in the leading edge to eliminate any possible catch point or leading edge.

Step 4

Begin removing 24” – 36” of release liner, line up to reference marks and press in place. Continue this process down the entire length of the slider bed.

Step 5

If at any point a seam or joint needs to be made in the STS material, overlap the new roll about 3” over the end of the previous roll. Using a razor knife, cut through both roll ends. They should marry together almost perfectly. Once you arrive at the end of the slide bed, cut the STS material about 1” from the end of the slider bed. Repeat the process for all additional strips. Using the spacers, butt the spacer against the first installed strip and use as a guide for all additional strips.

Step 6

Once all of the strips have been applied, it is important that mechanical pressure be applied. Remember, these are PRESSURE SENSITIVE adhesive systems – they want to see mechanical pressure. In fact, by using a roller, you will literally double the bond strength to the substrate. We recommend an extension wall roller (Crain #333 or equivalent). Thoroughly apply pressure on all strips. Pay additional attention to leading edges and seams where a potential catch point may occur. There is no defined time line when pressure needs to be applied. Typically, once the strip is installed and is in place, apply pressure. Crown also stocks these rollers and can be purchased with the material.

III. Replacing the STS Material

Step 1

Removing the DuraSurf STS Material, when removing the DuraSurf material from the slider bed, using a knife or screwdriver, pry up one corner of the material. Using a pliers or vice grip, secure the lifted corner and slowly begin to pull at a 45 degree angle. You will want to keep as much of the adhesive on the DuraSurf as possible. If you pull too quickly, you risk leaving a significant amount of adhesive on the substrate adding to the time and labor to remove the excess adhesive. Repeat this process for each strip.

Step 2

The adhesive system that is used is an Avery Dennison HPA 1905 high performance acrylic adhesive. It is very chemical, solvent and moisture resistant. Therefore, no solvent will break it down. If there is any adhesive residue on the bed pan, you can apply the new strip over the old adhesive.

Step3

Surface Preparation – Once the DuraSurf material and has been removed, follow the standard installation procedure beginning with the surface preparation step.

V. Additional Points

Avery HPA 1905 is a high performance acrylic adhesive that is very resistant to spills and chemicals. The adhesive will actually cure to the substrate so adhesion will increase over the first 24 hours. Always try to refrain from contact with the adhesive when possible. Make sure the DuraSurf is properly aligned before pressing into place. The HPA 1905 is repositionable but it is always best to remove the liner and press into place in 24’’ increments to help ensure alignment.

Material Spacing – Spacing of the strips on the slider bed may vary depending on load and belt width. Our standard spacing recommendations are as follows:

24” Belt – 4 strips of STS spaced 4” apart, star from side pan
36” Belt – 5 strips of STS spaced 5” apart, start 1/2” in from side pan
42” Belt – 6 strips of STS spaced 4.5” apart, start 3/4”in from side pan
48” Belt – 6 strips of STS spaced 5.5” apart, start 2” from side pan
60” Belt – 7 strips of STS spaced 6” apart, start 2” from side pan