

This guideline indicates how to use the Mobile Activation device from Q-Bond AB regarding settings for various cloth/fabrics. For all mentioned cloths or fabrics are the Q-Bonded joint stronger than the cloth itself. The joints shear-strength is higher than the teststripes shear strength.

For woven sailcloth the joint is covered with a woven polyester PSA-tape; a 100NT 25mm.  
For laminated sailfabrics the joint is covered with The Q-Edge Mylar Tape.

**Mylar film is temp sensitive. Shrinks at 190C**

D-P: Dimension-Polyant GmbH

B: Bainbridge

CF: Cuben Fiber

C:Contender BV

Yellow marked is tested with unit with weight distribution giving 1,1kg on sonotrode at 45 kg total load

Producer	Cloth/Fabric	Machine Weight	Work bench material	Surface Temp in C	Glue Temp in C	Q-Bond Tape	Width mm	Comments
<b>Dimension-Polyant Wovens and Sandwich Cloths</b>								
D-P	GPL 35	30kg	Solid beech 30mm	70	156	9mm *0,2	14	Test made with Mylar film covering the joint otherwise overheating of glue to 170-230C. Tempfactor 2,2
D-P	GPL 14	30kg	Solid beech 30mm	82	162	9mm *0,2	15	Test made with Mylar film covering the joint otherwise overheating of glue. Temp factor 2
D-P	DC 99 UVM	30kg	Solid beech 30mm	65-70	95-112	9mm *0,2	10	Temp factor: 1,5
D-P	DC 66 UVM	30kg	Solid beech 30mm	67	100	9mm *0,2		Temp factor: 1,9
D-P	410 AP MTO	30kg	Solid beech 30mm	60-80	130	9mm *0,2		Temp factor: 1,5
D-P	270 TNF MT	30kg	Solid beech 30mm	70-75	115-130	9mm *0,2	13-14	Temp factor: 1,6
D-P	180 HTP+	45 kg	Solid beech 30mm	58-63		9mm *0,2		
D-P	170 TNF MT	45 kg	Solid beech 30mm	60	115	9mm *0,2	10-12	Temp factor: 1,9
D-P	165 SQ HTP+ 3,9oz	30kg	Solid beech 30mm	60-65		9mm *0,2	15	
D-P	140B Optimist MTO 3,3oz	45 kg	Solid beech 30mm	60-65		9mm *0,2	13-15	very good peeling resistance
D-P	130SQ HTP Plus	30kg	Solid beech 30mm	60	140	9mm *0,2	15	Temp factor: 2,3
D-P	FLX 13 A 1,5 mil	32kg	particle board 25mm	74	93	9mm *0,2	14	Temp factor: 1,3
D-P	FLX 13 A 1,5 mil	45kg	particle board 25mm	64	84	9mm *0,2	16	Temp factor: 1,3
D-P	FLX 13 A 1,5 mil	34kg	Solid beech 30mm	50-60	117-144	9mm *0,2	11 - 12	Temp factor: 2,3
Producer	Cloth/Fabric	Machine Weight	Work bench material	Surface Temp in C	Glue Temp in C	Q-Bond Tape	Width mm	Comments
D-P	FLX 19 A 1,5 mil	34kg	Solid beech 30mm	64	142	9mm *0,2	11 - 12	Temp factor: 2,2
D-P	X 10 Alumashield 1,5mil 5,0 oz	30kg	Solid beech 30mm			9mm *0,2	15-16	
D-P	X 10 Alumashield 1,5mil 5,0 oz	45kg	particle board 25mm	80	156	9mm *0,2	18	Temp factor: 1,8
D-P	X 15 Alumashield 1,5mil 6,0 oz	45kg	particle board 25mm	79	99	9mm *0,2	17	Temp factor: 1,3
D-P	X 15T Alumashield 1,5 mil 7,3oz	34kg	Solid beech 30mm			9mm *0,2	16-17	
D-P	X 20T Alumashield 1,5mil 8,0oz	32kg	particle board 25mm	85	108	9mm *0,2	16 - 18	Temp factor:1,3
D-P	PX 10 1,5 mil 7oz	30kg	Solid beech 30mm	50	110	9mm *0,2		Temp factor: 2,2
D-P	PX 20 1,5mil 5,3oz	34kg	Solid beech 30mm			9mm *0,2	18-20	
D-P	PX 20 1,5mil 5,3oz	32kg	particle board 25mm	75	164	9mm *0,2	18-20	Temp factor: 2,2
D-P	PX 10 T 1,5 mil 5,0oz	30kg	Solid beech 30mm			9mm *0,2	15	
D-P	PX 15 T 1,5mil 7,3oz	34kg	Solid beech 30mm			9mm *0,2	16	
D-P	E06 1,5 mil 4,3oz	45kg	particle board 25mm	66	106	9mm *0,2	18-20	Temp factor: 1,6
D-P	E06 1,5 mil 4,3oz	30kg	Solid beech 30mm			9mm *0,2	18-20	
D-P	PM02 1,0mil 2,0oz	45kg	particle board 25mm	69	162	9mm *0,2	18	Temp factor: 2,3
D-P	PM02 1,0mil 2,0oz	32kg	particle board 25mm	66	145	9mm *0,2	16	Temp factor: 2,2
D-P	PM02 1,0mil 2,0oz	30kg	Solid beech 30mm			9mm *0,2	14-15	
Producer	Cloth/Fabric	Machine Weight	Work bench material	Surface Temp in C	Glue Temp in C	Q-Bond Tape	Width mm	Comments
<b>Cuben Fiber Laminate Fabrics</b>								
CF	CN 22	30kg	Solid beech 30mm	58	141	9mm *0,2 9mm *0,2	13	Temp factor: 2,4
<b>Bainbridge Laminate Fabrics</b>								
BB	CLX 65	34kg	Solid beech 30mm	55	150	9mm *0,2	11-12	Temp factor: 2,7
BB	GTT 09	34kg	Solid beech 30mm	69	200	9mm *0,2	12-14	Temp factor: 2,9
<b>Contender Laminate Fabrics</b>								
C	Maxx carbon 09, 1,75mil 3,9oz	32kg	particle board 25mm	82	145	9mm *0,2	16	Temp factor: 1,8
C	Maxx carbon 09, 1,75mil 3,9oz	45kg	particle board 25mm	73	120	9mm *0,2	17	Temp factor: 1,6
C	Maxx carbon 15 1,75mil 4,8oz	30kg	Solid beech 30mm	65	182	9mm *0,2	13	Temp factor: 2,8
C	Maxx pen 09 1,75mil 3,9oz	45 kg	Solid beech 30mm	65-80		9mm *0,2	15	
C	Maxx pen 15 1,75mil 4,9oz	30kg	Solid beech 30mm	50	122	9mm *0,2	11	Temp factor: 2,4

**Comparisons with Ultra Bond Hot Melt Glue applied with compressed air hot melt gun**

Glue temp in cartridge	Glue temp in nozzle	Glue temp surface	Glue temp pressing
165C	118	79	60
165C	120	85	67

**Q-Bond Tape Varieties and max theoretical joint with**

A 8mm tape, 0,20mm thick could be pressed out	16	mm
A 9mm tape, 0,20mm thick could be pressed out	18	mm
A 9mm tape, 0,25mm thick could be pressed out	22,5	mm