

## Technical Code DVS 3320-2

# Quality requirements for the use of pressure sensitive adhesive tape for permanent bonded joints

Technical Committee of the DVS

Working Group V 8 "Adhesive Bonding Technology"

Sub-Group V 8.2 "Pressure Sensitive Adhesive Tapes"

This publication has been drawn up by a group of experienced specialists working in an honorary capacity and its consideration as an important source of information is recommended. The user should always check to what extent the contents are applicable to his particular case and whether the version on hand is still valid. No liability can be accepted by the DVS – Deutscher Verband für Schweißen und verwandte Verfahren e.V., and those participating in the drawing up of the document.

**Content:**

<b>1.</b>	<b>Foreword</b> .....	<b>3</b>
<b>2.</b>	<b>Purpose of this guideline</b> .....	<b>3</b>
<b>3.</b>	<b>Technical scope</b> .....	<b>4</b>
<b>4.</b>	<b>Definitions and terms</b> .....	<b>4</b>
4.1.	Product composition and functional components.....	4
4.2.	Product properties and test parameters.....	5
4.3.	Other relevant terms .....	7
<b>5.</b>	<b>Adhesive bonding personnel</b> .....	<b>9</b>
5.1.	General .....	9
5.2.	Production personnel .....	9
5.3.	Supervisory personnel .....	9
<b>6.</b>	<b>Design of bonded joints</b> .....	<b>10</b>
6.1.	General .....	10
6.2.	Selection of the adhesive system, substrates, and surface treatment.....	10
6.3.	Validation .....	11
<b>7.</b>	<b>Storage and care of materials</b> .....	<b>12</b>
7.1.	Incoming goods' inspection .....	12
7.2.	Storage conditions .....	12
7.3.	Conditioning of materials prior to processing.....	13
<b>8.</b>	<b>Cleaning and pretreatment</b> .....	<b>13</b>
8.1.	Cleaning .....	13
8.2.	Mechanical pretreatment.....	14
8.3.	Physical pretreatment .....	14
8.4.	Chemical pretreatment.....	14
8.5.	Adhesion promoters and primers .....	15
8.6.	Combinations of processes.....	15
<b>9.</b>	<b>The bonding process</b> .....	<b>15</b>
9.1.	Adhesive tape application to the first substrate.....	16
9.2.	Removal of the line .....	16
9.3.	The joining step.....	16
9.4.	Further processing after the joining step.....	16
9.5.	Features of manual processing.....	17
9.6.	Features of machine processing .....	17
<b>10.</b>	<b>Quality assurance</b> .....	<b>17</b>
10.1.	Quality monitoring and testing.....	17
10.2.	Corrective measures .....	18
10.3.	Calibration.....	18
<b>11.</b>	<b>Standards and guidelines</b> .....	<b>18</b>