



### **MBA surface coverings Application Tips:**

More than four decades of MBA experience, continuous development and international marketing are the reasons for the worldwide success of self-adhesive MBA surface programs (coverings).

The MBA surface programs offer self-adhesive surface foils and textiles for various application possibilities. Choose between permanent adhesive or removable adhesive backing depending on the product group or series.

Select the appropriate surface coverings for the intended purpose under consideration of the "Technical Data" (see data sheet).

Only use one roll number (lot number) per color for coating work if possible.

Make sure the material is applied in the same running direction when used in further processing.

All self-adhesive MBA surfaces can be applied manually or automatically.

### **Processing instructions**

#### 1. Preparation

- The backing materials to be coated must be smooth, level and free of dust, dirt, oil, grease and separators.
- NOTE: Sweat from human hands contains salts and greases. These can cause blistering and unsticking of the surfaces as separators on plastic panels and metal sheets.

#### 2. Cleaning

- Sand wooden materials before coating depending on the condition of the surface, and remove all sanding dust.
- Hard fiber boards may contain paraffin as a separator. Make sure that hard fiber boards without paraffin separators are used on the surface.
- Plastic boards: Handling can apply salts and grease to the surface of the board. Clean the board surfaces with degreasing cleaners (e.g. cleaning alcohol etc.). Do not use cleaners containing solvents (nitro). Poly Olefin based plastic plates are unsuitable for self-adhesive coatings.
- Metal sheets: Only use metal sheets with a grease-free surface for coating. Oils / greases may be used as a corrosion protection depending on the type of material and the manufacturer.
- Painted surfaces: Depending on the manufacturer and paint recipe, oil paints and varnishes may contain additives which act as separators in the mid and long term and lead to unsticking of self-adhesive surfaces.
- Automotive paints are treated with wax and preservatives; these must be cleaned of all separators before sticking on MBA self-adhesive foils.
- Do not use solvents (thinners) for cleaning, residue from solvents attack removable adhesives, and the adhesive loses the property of removability and present a challenge when pulling the foils off.
- Use non-greasing household cleaner, alcohol or white spirit for smooth surfaces.

#### 3. Processing / Application temperature

- The adhesion strength is influenced by the processing temperature. Permanent and removable adhesives have a reduced adhesion strength when cold, this increases with rising temperature.
- The recommended minimum temperature of the backing material and the self-adhesive surfaces when coating is 18° - 21° C (65 – 70F)
- Do not process surfaces and backing material at room temperatures below 15° C (59 F).
- At low outdoor and indoor temperatures (Winter season), adapt surface foils and backing material to the minimum temperature after delivery by storing them in a temperature controlled area. Process surfaces and MBA foils should be of equal temperature.

#### 4. Surface coating (application by hand)

- Cut the self-adhesive surface about 3 – 5 cm bigger (longer and wider) than the area to be coated.
- Pull off the silicon paper from the back of the MBA foil about 3 – 5 cm, turn over and free the adhesive strip.
- Place the surface foil on the carrier plate, align, fix the adhesive strip to the carrier plate and press down without creasing.



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4. *Surface coating (application by hand) – Continued:*

- Coat the surface without blisters by rubbing down evenly with a clean, non-dyeing, soft cloth, foil squeegee or hard rubber roller.
- Pull off the silicon paper between the surface and the carrier plate slowly during coating.
- Perform the coating process very carefully to achieve a 100%, blister and crease free coating.
- In case of defective coating with blistering, pierce the blisters with a fine, pointed needle, stroke out the air and press down the surface firmly.
- Do not pull away surfaces again after the coating process because this can lead to poor adhesion and creasing due surface tension when re-applying.
- Cut off excess foil along the panel edge with a sharp knife, break the panel foil edge with sandpaper (grain 80-100) to remove any excess from the edges.
- Sand in the direction of the carrier plate to rule out lifting of the surface and contamination of the adhesive at the edges.
- Soiled adhesive areas lead to poor adhesion and unsticking at the edges.

5. Changing surfaces

- Do not pull off self-adhesive foils with a removable adhesive recipe at a sharp angle (180°).
- The layer of adhesive may tear at the crease and stay on the carrier plate.
- Pull off removable surface coverings at a close angle or roll off using a leftover foil core roller (cardboard roll).
- The close angle of removal prevents the adhesive layer from tearing
- Surfaces with a permanent adhesive coating are developed for permanent bonding and not for use as a removable surface
- When pulling off permanent adhesive surface coverings, the adhesive will remain on the carrier plates; particles of wood will be torn from wooden materials
- Permanent adhesive residue cannot be dissolved.
- milament metallic surfaces 2.601 – 2.701 – 2.805 are designed for indoor applications and not for outdoor use.

Remarks / Suggestions:

- Before processing self-adhesive surface coverings, check their suitability for the intended purpose.
- Make sure you keep the same running direction for further processing of metallic surfaces.
- The basic color of the carrier material can influence the colored appearance of bright surfaces (white, beige etc.). We recommend you to use only carrier plates of the same color.
- Do not pull or stretch textile MBA surfaces (mila-clett, milour-top) during coating, otherwise they might retract.
- MBA surface foils can be screen printed, coated with dispersion inks and stuck with self-adhesive texts, logos and signets.
- MBA surface coverings are easy to apply by hand when handled properly.
- MBA has developed mila-matic coating (laminating) machines which will allow passing widths of 1300 mm and 1400 mm for plate (panels) and will accept thickness up to 100 mm for coating carrier plates.
- mila-matic coating machines create blister and crease free conditions, consistent and economical coating results.
- The proper processing and suitability of the selected surfaces for the intended purpose is the responsibility of the processor and beyond MBA's area of influence.

If you have any questions or concerns about MBA Products, please contact us.

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