



54 Elizabeth Street, Unit #10, Red Hook, NY 12571  
TELEPHONE 845 758 0700 FAX 845-758-2057

## How to Apply Heater Using Adhesive

### PSAs – Pressure Sensitive Adhesive System

CHR Inc. has two different Pressure Sensitive Adhesives which can be used to adhere our Silicone Heaters to the part to heated.

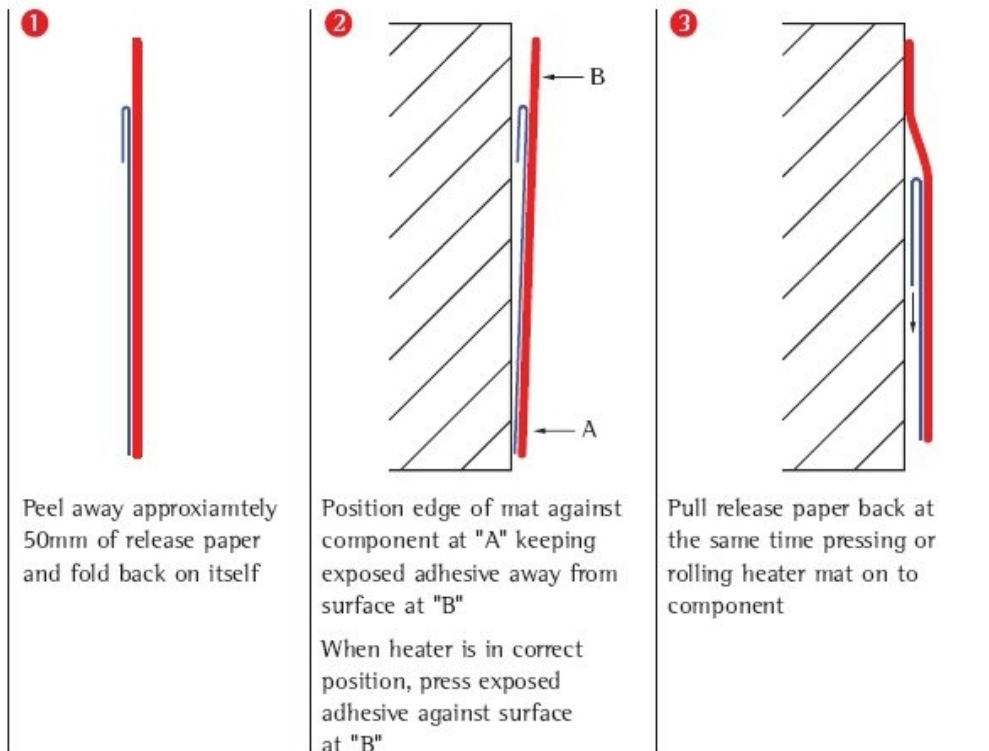
**Acrylic PSA-** rated to 356F/180C

**Silicone PSA** – rated from -100F to 500F (-73C to 260C)  
(the silicone heaters are rated to run a maximum of 446F/230C continuously)

### Installation of Adhesive Backed Silicone Heaters

Installation of adhesive backed silicone heaters will be most successful with the following procedure:

- Surface must be unified, dry and free of contaminants
- Firm pressure must be applied to maximize surface contact
- Time and temperature will increase the surface contact and adhesion values





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Recommended surface temperature is 70°F to 100°F (21°C to 38°C). Temperatures below 50°F (10°C) is not recommended for installation.

Prepare the surface of the part by cleaning with an appropriate agent to clean grease, dust and other contaminants from the surface.

Carefully remove the peel sheet from the adhesive assuring as little contact with the adhesive surface as possible.

Place the heater and press firmly in place

Allow the adhesive to cure for 24 hours

Do not allow adhesive to experience sustained temperatures in excess of 230°F

Place the heater and press firmly in place

- Allow the adhesive to cure for 24 hours
- Apply a bead of Silicone RTV around the perimeter of the heaters to prevent anything picking at the edges (once it begins to lose adhesion it is not possible to re-adhere without a silicone RTV being used to repair the issue)

Do not allow adhesive to experience sustained temperatures in excess of 230°F