

## Adhesive Recommendations

### Basic Criteria

- Must adhere to polypropylene which is more challenging than adhering to wood or corrugated
- Failure mode is fiber tear (corrugated rips)
- Able to withstand supply chain (all temperatures)
- Must be able to be manually or automatically applied

### Loading Guidelines

Peel force: 0.4 lbs/inch

Horizontal shear force (“bulldoze”): 7 lbs/inch (0.3 coefficient of friction-OptiLedge and unit)

### Adhesives

We have successfully tested hot-melt and PSA hot-melt and recommend the following:

IFS ‘DURAPRO’ M-751. This is a hot melt with a long open time allowing for efficient application of the OptiLedge.

IFS ‘DURAPRO’ M-739. This is a PSA hot melt adhesive. It can be applied to the OptiLedges and it will remain tacky. You can use this with a release liner to create a “peel and stick” OptiLedge application.

Please contact <http://www.ifscos.com> to purchase.

### Application

Glue machinery suppliers can provide more detailed recommendations for use with these adhesives but we recommend spray equipment for efficient and quick application.