**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](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.