

This guideline indicates how to use the Mobile Activation device from Q-Bond AB regarding settings for various cloth/fabrics. For all mentioned cloths or fabrics are the Q-Bonded joint stronger than the cloth itself. The joints shear-strength is higher than the teststripes shear strength.

For woven sailcloth the joint is covered with a woven polyester PSA-tape; a 100NT 25mm.
For laminated sailfabrics the joint is covered with The Q-Edge Mylar Tape.

Mylar film is temp sensitive. Shrinks at 190C

D-P: Dimension-Polyant GmbH

B: Bainbridge

CF: Cuben Fiber

C:Contender BV

Yellow marked is tested with unit with weight distribution giving 1,1kg on sonotrode at 45 kg total load

Producer	Cloth/Fabric	Machine Weight	Work bench material	Surface Temp in C	Glue Temp in C	Q-Bond Tape	Width mm	Comments
Dimension-Polyant Wovens and Sandwich Cloths								
D-P	GPL 35	30kg	Solid beech 30mm	70	156	9mm *0,2	14	Test made with Mylar film covering the joint otherwise overheating of glue to 170-230C. Tempfactor 2,2
D-P	GPL 14	30kg	Solid beech 30mm	82	162	9mm *0,2	15	Test made with Mylar film covering the joint otherwise overheating of glue. Temp factor 2
D-P	DC 99 UVM	30kg	Solid beech 30mm	65-70	95-112	9mm *0,2	10	Temp factor: 1,5
D-P	DC 66 UVM	30kg	Solid beech 30mm	67	100	9mm *0,2		Temp factor: 1,9
D-P	410 AP MTO	30kg	Solid beech 30mm	60-80	130	9mm *0,2		Temp factor: 1,5
D-P	270 TNF MT	30kg	Solid beech 30mm	70-75	115-130	9mm *0,2	13-14	Temp factor: 1,6
D-P	180 HTP+	45 kg	Solid beech 30mm	58-63		9mm *0,2		
D-P	170 TNF MT	45 kg	Solid beech 30mm	60	115	9mm *0,2	10-12	Temp factor: 1,9
D-P	165 SQ HTP+ 3,9oz	30kg	Solid beech 30mm	60-65		9mm *0,2	15	
D-P	140B Optimist MTO 3,3oz	45 kg	Solid beech 30mm	60-65		9mm *0,2	13-15	very good peeling resistance
D-P	130SQ HTP Plus	30kg	Solid beech 30mm	60	140	9mm *0,2	15	Temp factor: 2,3
D-P	FLX 13 A 1,5 mil	32kg	particle board 25mm	74	93	9mm *0,2	14	Temp factor: 1,3
D-P	FLX 13 A 1,5 mil	45kg	particle board 25mm	64	84	9mm *0,2	16	Temp factor: 1,3
D-P	FLX 13 A 1,5 mil	34kg	Solid beech 30mm	50-60	117-144	9mm *0,2	11 - 12	Temp factor: 2,3
Producer	Cloth/Fabric	Machine Weight	Work bench material	Surface Temp in C	Glue Temp in C	Q-Bond Tape	Width mm	Comments
D-P	FLX 19 A 1,5 mil	34kg	Solid beech 30mm	64	142	9mm *0,2	11 - 12	Temp factor: 2,2
D-P	X 10 Alumashield 1,5mil 5,0 oz	30kg	Solid beech 30mm			9mm *0,2	15-16	
D-P	X 10 Alumashield 1,5mil 5,0 oz	45kg	particle board 25mm	80	156	9mm *0,2	18	Temp factor: 1,8
D-P	X 15 Alumashield 1,5mil 6,0 oz	45kg	particle board 25mm	79	99	9mm *0,2	17	Temp factor: 1,3
D-P	X 15T Alumashield 1,5 mil 7,3oz	34kg	Solid beech 30mm			9mm *0,2	16-17	
D-P	X 20T Alumashield 1,5mil 8,0oz	32kg	particle board 25mm	85	108	9mm *0,2	16 - 18	Temp factor:1,3
D-P	PX 10 1,5 mil 7oz	30kg	Solid beech 30mm	50	110	9mm *0,2		Temp factor: 2,2
D-P	PX 20 1,5mil 5,3oz	34kg	Solid beech 30mm			9mm *0,2	18-20	
D-P	PX 20 1,5mil 5,3oz	32kg	particle board 25mm	75	164	9mm *0,2	18-20	Temp factor: 2,2
D-P	PX 10 T 1,5 mil 5,0oz	30kg	Solid beech 30mm			9mm *0,2	15	
D-P	PX 15 T 1,5mil 7,3oz	34kg	Solid beech 30mm			9mm *0,2	16	
D-P	E06 1,5 mil 4,3oz	45kg	particle board 25mm	66	106	9mm *0,2	18-20	Temp factor: 1,6
D-P	E06 1,5 mil 4,3oz	30kg	Solid beech 30mm			9mm *0,2	18-20	
D-P	PM02 1,0mil 2,0oz	45kg	particle board 25mm	69	162	9mm *0,2	18	Temp factor: 2,3
D-P	PM02 1,0mil 2,0oz	32kg	particle board 25mm	66	145	9mm *0,2	16	Temp factor: 2,2
D-P	PM02 1,0mil 2,0oz	30kg	Solid beech 30mm			9mm *0,2	14-15	
Producer	Cloth/Fabric	Machine Weight	Work bench material	Surface Temp in C	Glue Temp in C	Q-Bond Tape	Width mm	Comments
Cuben Fiber Laminate Fabrics								
CF	CN 22	30kg	Solid beech 30mm	58	141	9mm *0,2 9mm *0,2	13	Temp factor: 2,4
Bainbridge Laminate Fabrics								
BB	CLX 65	34kg	Solid beech 30mm	55	150	9mm *0,2	11-12	Temp factor: 2,7
BB	GTT 09	34kg	Solid beech 30mm	69	200	9mm *0,2	12-14	Temp factor: 2,9
Contender Laminate Fabrics								
C	Maxx carbon 09, 1,75mil 3,9oz	32kg	particle board 25mm	82	145	9mm *0,2	16	Temp factor: 1,8
C	Maxx carbon 09, 1,75mil 3,9oz	45kg	particle board 25mm	73	120	9mm *0,2	17	Temp factor: 1,6
C	Maxx carbon 15 1,75mil 4,8oz	30kg	Solid beech 30mm	65	182	9mm *0,2	13	Temp factor: 2,8
C	Maxx pen 09 1,75mil 3,9oz	45 kg	Solid beech 30mm	65-80		9mm *0,2	15	
C	Maxx pen 15 1,75mil 4,9oz	30kg	Solid beech 30mm	50	122	9mm *0,2	11	Temp factor: 2,4

Comparisons with Ultra Bond Hot Melt Glue applied with compressed air hot melt gun

Glue temp in cartridge	Glue temp in nozzle	Glue temp surface	Glue temp pressing
165C	118	79	60
165C	120	85	67

Q-Bond Tape Varieties and max theoretical joint with

A 8mm tape, 0,20mm thick could be pressed out	16	mm
A 9mm tape, 0,20mm thick could be pressed out	18	mm
A 9mm tape, 0,25mm thick could be pressed out	22,5	mm