

VHB Bonding Process Checklist

Please ensure all of the items below are present
before the training session and start-up of the
VHB bonding process

- 1. 3M VHB SGT B23F or G23F in the appropriate width for the System- *3M Select Distributor*
- 2. 3M Adhesion Promoter 111, 3M Adhesion Promoter 115, or 3M Primer 94 per Adhesion Test Report results – *3M Select Distributor*
- 3. 3M Silane Glass Treatment AP115 – *3M Select Distributor*
- 4. 3M Adhesive Remover (citrus based) – *3M Select Distributor*
- 5. Isopropyl Alcohol (70% IPA/Water or concentrated diluted to ~70%) – *3M Select Distributor or Customer*
- 6. Kimberly-Clark WypAll X60, X50 or X80 Towels (white only) – *3M Select Distributor or Customer*
- 7. 3M Hand Tape Applicator – *3M Select Distributor*
- 8. J-Roller (Gundlach V300 J-roller or similar laminate roller) – *3M Select Distributor or Customer*
- 9. [Pressure Applicator Tool in accordance with 3M VHB Structural Glazing Tape Guidelines](#) – *3M Select Distributor or Customer*
- 10. Air Compressor capable of greater than 100 PSI (If applicable for pressure application guidelines) – *Customer*
- 11. Razor Blades – *3M Select Distributor or Customer*
- 12. Irwin Bar Clamp – *3M Select Distributor or Customer*
- 13. Glass Panels for Start-up Training (3) – *Customer*
- 14. Assembled Cassette Frames for Training purposes (3) – *Customer*
- 15. 1-part Neutral Cure Silicone Sealant for Corners – *3M Select Distributor or Customer*
- 16. Shop temperature and materials >60F – *Customer*
- 17. Carpeted Worktable or Other Appropriate Work Surface – *Customer*