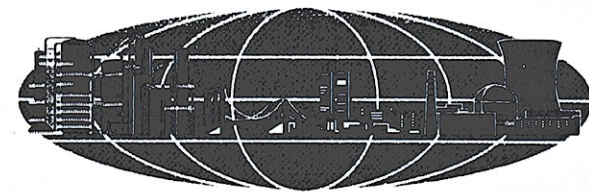


**AMSCOT**

A World of Structural Bearings  
and Custom Fabricated Metal Components.

241 E. Blackwell Street  
Dover, NJ 07801



**AMSCOT STRUCTURAL PRODUCTS - PREFORMED FABRIC PAD TO PTFE  
BOND PROCEDURE**

OK'D BY                      OK'D BY Jac  
RECEIVED  
JUN 26 2009  
RESUBMIT APPROVED                      DATE 7-8-09

**FACTORY BOND PROCEDURE:**

**Material preparation procedure as follows:**

1. Preformed fabric reinforced elastomeric pad (90 ± 5 Shore A Durometer) bond surface to be roughened by scoring full surface area with wire brush.
2. Substrate sheet to be either 1/16" phenolic sheet and shall be prepped by abrading both surfaces or 18 gauge steel sheet and shall be prepped by sand blasting both surfaces to a SSPC-SP10 classification.
3. All foreign materials to be removed from PTFE sheet, Substrate sheet (18 gauge steel and or Phenolic sheet), and Fabric Pad bonding surfaces.
4. Two part epoxy bond adhesive material; Armstrong style no. A-271 parts A and B shall be thoroughly mixed together as per manufactures mix ratio.
5. Mixed epoxy shall be applied with trowel providing uniformity of epoxy on all bonding surface areas.
6. PTFE (Polytetrafluorethylene)-(virgin, not reprocessed) shall be placed etched face surface with the applied epoxy coating against prepared substrate sheet. Epoxy coated substrate sheet opposite face shall be placed against preformed fabric pad material.
7. The fabric pad with substrate & PTFE shall be placed into hydraulic heated press for a duration of 15-20 minutes @ 180° F to allow proper cure time of epoxy material. (Longer time periods required when material pad thickness exceeds 1" thick).
8. Preformed reinforced Bearing pad bonded to PTFE shall be allowed to cool for 60 minutes before handling.
9. Excess PTFE shall be removed from perimeter of pad. Pad shall be sanded smooth on all sides.
10. Finished Preformed fabric bearing pad w/PTFE to be inspected by Q/C personnel prior to packaging for shipment.

**Recommended storage procedures:** PTFE materials shall be kept covered from direct UV light exposure for any long periods of time.

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