



The D.S. Brown Company  
300 E. Cherry Street  
North Baltimore, Ohio 45872  
419.257.3561  
Fax: 419.257.2200  
e-mail: dsb@dsbrown.com  
www.dsbrown.com

Equal Opportunity Employer

### Recessed Sheet PTFE to Steel Bonding Procedure

The bonding process for laminating PTFE to steel is as follows:

The steel surface to be bonded is prepared for lamination by blasting and degreasing. A two-part structural epoxy is then applied per the manufacturer's instructions. The PTFE used must be etched on one side. The PTFE is cut slightly undersized to fit within the steel recess. The PTFE is then applied to the prepared steel recess, with the etched face of the PTFE facing the steel, and mild pressure is applied to the PTFE for the necessary time period.

Once the epoxy has cured, pressure is removed and any excess epoxy is removed from around the steel recess. Quality control will review the bond to ensure that it is satisfactory.

TRANS  
RECEIVED  
OK'D BY \_\_\_\_\_ OK'D BY *Jux*  
JUN 03 2008  
RESUBMIT \_\_\_\_\_ APPROVED \_\_\_\_\_  
BY *RW* DATE *6/6/08*