



An Oshkosh Corporation Company

Technical Information Bulletin Reference: TIB 17-06

Date: December 7, 2017

To: JLG Service Managers and Service Providers

Models Affected: Combustion powered boom and scissor lifts

Subject: Procedure for proper installation of replacement insulating foam

Description of Issue: The following procedure should be followed when replacing damaged or missing hood insulating foam

A GUIDE TO INSTALLING PRESSURE SENSITIVE ADHESIVES

Surface Preparation: It is absolutely essential that the substrate surface be scrupulously clean.

- A. Remove any dust, dirt, oil, grease, rust, mold-release agent, etc. from the surface.
- B. Abrading or roughing the surface by wire-brushing, sandblasting, abrasive paper, etc. is recommended for highly polished surfaces to obtain the best possible bond.
- C. Any of the above steps should be followed by a degreasing step, using a solvent wipe of acetone, toluene, trichloroethylene, dichloromethane, xylene, pentane, or "ACRYLI-CLEAN" by PPG.

Pressure Sensitive Adhesive:

- D. For sheet materials, cut to shape with a sharp knife, scissors, shears, die, etc. **MAKE SURE THE TEMPERATURE OF SUBSTRATE AND ADHESIVE BACKED PART IS AT LEAST 65°F BUT NOT MORE THAN 110°F BEFORE TRYING TO ADHERE PART TO SUBSTRATE.**
 - 1. Start by peeling the product away from the release liner, not the liner away from the PSA package, by grasping the product at the corner or along the edge below the PSA/liner interface and PINCH the product together at the corner. This will cause the adhesive to release from the stiffer release paper and start the separation between the two.

2. Grasp the release liner where separated from the adhesive and pull the release liner away from the material.

3. Use a smooth continuous pulling motion to avoid tearing the release liner.

- E. Apply part in the exact position desired, since repositioning will be difficult, if not impossible as pressure sensitive adhesives are **extremely aggressive**.
- F. For best adhesion, it is important to ensure during the application of material that the maximum possible pressure be applied to the entire surface to prevent air pockets being trapped between the material and the substrate. For foams, with or without film facings, thicker than 1", foam/barrier, or foam/damper composites, additional pressure is necessary to assure the adhesive has "wet out" the substrate surface. Reinstall any mechanical fasteners or hangers as well.
Use of a hand roller is recommended whenever possible; otherwise, substantial hand or finger pressure can be used if applied over the entire surface. This is to ensure the adhesive has "wet out" the substrate surface and 100% of the PSA is in contact with the substrate.

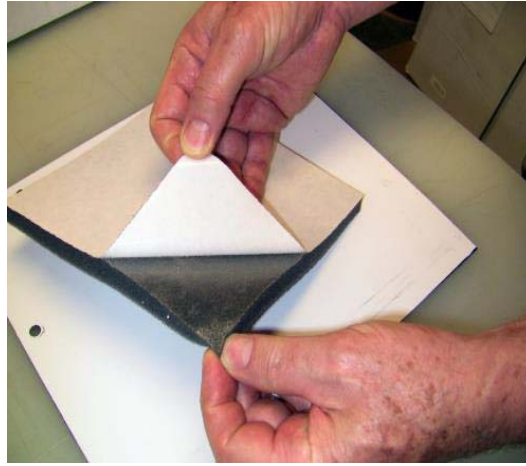
Contact-Type Adhesives: (Recommended for: All Sheet products when a pressure sensitive adhesive is not recommended.)

ALWAYS FOLLOW THE MANUFACTURER'S INSTRUCTIONS IN THE USE OF ANY ADHESIVE.

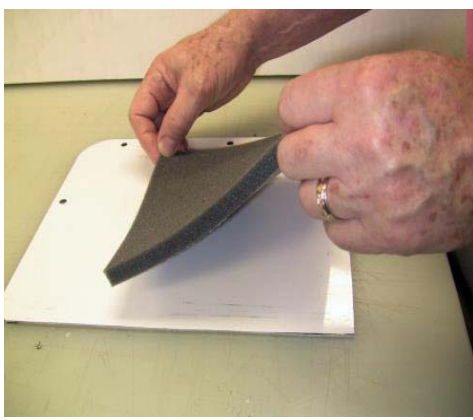
- A. Apply a generous coating (0.010" wet) of the adhesive to the cleaned substrate and insulating sheet material by method suggested by adhesive manufacturer, i.e. brush, spray, roller.
- B. Wait the recommended open time (per the manufacturer's instructions) prior to mating the two surfaces. A rough guide to determine the right moment for bonding is when the adhesive feels tacky but does not transfer to the knuckles of one's hand
- C. Apply maximum practical pressure by a nip roller, hand-roller, etc. Make sure the entire part, especially corners and edges, receives pressure.
- G. Normally, enough strength has developed at this point to permit further handling.



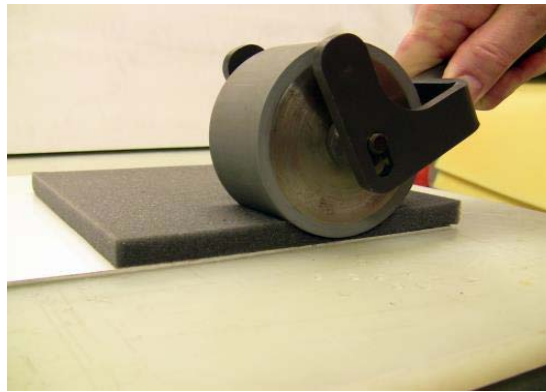
Pinch to start



Peel liner from foam



Apply to panel



Compress while rolling

JLG Customer Support

North America @ 1-877-554-5438
Europe, Africa & Middle East @ +31 (0)23 569 8751
Australia @ 61 2 6581 1111