

# INSTRUCTIONS



SPI Supplies  
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## Use Instructions for Crystalbond™ 509\*, 555, 555-HMP and 590

1. Using a hot plate or oven, heat a ceramic or glass mounting block to the flow temperature of the selected Crystalbond™ adhesive. Make sure to work in a well-ventilated area, and do not overshoot the flow temperature, otherwise, the adhesive will begin to decompose, degrading its strength.
2. Apply a uniform layer of adhesive to the heated mounting plate and place the substrate over the adhesive. Using a weight, apply even pressure to the substrate to remove air bubbles and to ensure that the substrate is parallel to the plate. Apply a fillet of adhesive around the perimeter of the substrate to increase the holding strength.
3. Remove the mounting plate from the heat source and allow it to cool slowly to room temperature until the adhesive is hardened. Cool for 20-30 minutes before processing.
4. Dice or process the substrate as required, then remove the parts by re-heating the mounting block to the flow temperature. Use a tool to slide the substrate off the mounting plate.
5. For detailed cleaning procedures for Crystalbond™ 509 and 590, refer to the pages for Crystalbond™ 509-S and 590-S Strippers. For Crystalbond™ 555 or 555-HMP, follow the Process Diagram for cleaning, substituting water for the other strippers.

**Crystalbond™ 509** can be applied as a thin, uniform film by dissolving it into a sprayable liquid. This can be accomplished by crushing the adhesive stick into a powder and mixing it into a solution of 80 parts acetone to 20 parts 509 by weight. Spray the solution onto the parts and allow the solvent to evaporate for a minimum of 5 minutes. Use a heat gun for one minute at less than 250 °F to evaporate further, then press the parts together and cool at room temperature for at least 30 minutes.

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