



## KUBE IR-Transmissive Plastics

### How to fix, glue and weld PIR plastic windows

All KUBE IR transmissive plastics (granulates, films, blanks) are made from polyolefins that cannot be glued with standard compounds such as epoxy or acrylics.

For mounting PIR windows, we recommend the following:

- Mechanical fixture:
  - Hold window between case and a mounting frame.
  - Use small pins in plastic case, punch holes in window and weld with heat or ultrasound.
- Tape fixture: use double side adhesive tape.  
Long term stable and very thin tapes are available from:

3M ([www.3m.com](http://www.3m.com)), such as

- type 950 (0.13 mm thick)
- type 927 (0.05 mm thick)
- types 9471LE (0.05 mm thick), 9472LE (0.13mm thick)
- types 4905, 4910, 4915, 4918

Dielectric Polymers Inc (USA) Type NT-988 (0.1 mm thick) [www.dipoly.com](http://www.dipoly.com)

In Europe, the following company can supply adhesive tapes, also die cut to customer specified shape: STOKVYS Tapes [www.stokvistapes.fr](http://www.stokvistapes.fr)

- Glue fixture:
  - Eclectic 6000 (weak bond)
  - 3M 4693 (strong bond)
  - Loctite 414 (strong bond)

Most standard KUBE films are surface treated on the inside (the way they are rolled) to improve adhesion of tapes and glue (Corona treatment to 44 dyn).