

## **DIRECTIONS FOR GLUING DOWN HEAT SHRINKING POLYPROPYLENE SCREENING**

The heat shrinking screening is best attached to the mould using adhesives rather than staples or other non-continuous fasteners. Epoxy adhesives work best. Other adhesives such as silk screen frame adhesives will also work but they do not look as nice in the finished state. The epoxy used should be of a fairly lightweight consistency. Use a medium viscosity epoxy of 1,200 cps. which is the consistency of thick maple syrup. Pre-measured epoxy packages are available and must be used one at a time. There is enough epoxy in one package to cover approximately 200 lineal feet of mould edge, if applied correctly.

### **Procedure:**

Cut the screen one inch wider than the outside dimension of the mould. All excess will be trimmed off at a later stage. Place a release sheet (heavy sheet of polyethelene plastic) on a board and position the screen on the sheet with the curl towards the board. Place a small weight in the center to hold the screen flat.

Wipe the edges of the mould and screening with acetone to clean them. Apply the epoxy to the mould by spreading it out evenly with a small brush. Keep the excess away from the inner edge so that it will not flow into the open screen of the mould while being clamped. The outside corners should be a little thicker as they tend to want to peel back in use. Carefully position the mould (glue side down) onto the screen and lower into place. Once the mould has been set on the screen it cannot be moved, so be sure to position properly before making contact.

Next, remove the weight and place a sheet of wax paper on the back of the mould to minimize problems with excess glue. Place another board on the back of the mould. Grasping the boards tightly, flip the whole sandwich over so that the screen side is now up. Place the mould and boards in a press or use C-clamps to apply pressure. When the adhesive has hardened, remove the clamps, and trim the screen to the edge of the mould. Sand off excess adhesive. After final curing of the adhesive, the screen can be tightened by the application of heat. A hair dryer or heat gun does the job well. Be sure to keep the heat moving and about 8" away from the screen so that it tightens evenly.

### **Before Initial Use:**

Screening must be primed. Soak mould in water overnight, and then scrub screening with comet or other abrasive cleaning powder using a scrub brush or toothbrush. Rinse well, and the screening should now be ready for papermaking. This process can also be done before the screening is epoxied to the mould.