



Heat Activated Foamboard



InSite Heat Activated (HA) foamboard features a smooth clay-coated paper on one side and a pH neutral heat activated adhesive surface on the other. Heat Activated foamboards are designed for use in mechanical and hot vacuum presses as well as heated roll laminators. Since InSite HA comes with a layer of smooth, evenly applied, neutral pH, adhesive that creates a permanent bond in the press as all layers reach activation temperature. It is ready for mounting right from the case eliminating the need for additional rolled mount tissues or film, saving both production time and money for either a single custom mounting or large production operations.

InSite HA bonds at 160°F in 15-45 seconds in a mechanical press; at 160°F in 4 minutes in a hot vacuum press; and 280°F-290°F at a speed of 1-1/2 to 3 feet per minute (fpm) using a hot roll laminator. Available in white or black it is ideal for heat tolerant paper, newspaper, poster images and RC photographs. It is available 1/8" to 3/16" thick, in sizes ranging from 24"x36" to 48"x96".

Mounting Instructions for Presses

InSite HA is formulated to activate and bond at 160°F as the press. Thicker, larger and heavier items being mounted may require additional time for full activation and bond. Since permanent adhesives bond under pressure while in the press all of the layers of the mount package must reach full temperature to active and fuse. It is not advised to raise the temperature, but rather increase the time within the press if full fusion did not occur. Any item not fully bonded after the first run may be run a second time by adding additional time to the original setting (such as 1 minute + added time). Excessive temperatures can damage the polystyrene foam center and should be avoided.

Mechanical Press

1. Preheat press to **160°F** temperature.
2. Reduce and control moisture by pre-drying when necessary.
3. Remove liner and align image face up on the adhesive side of the board.
4. Cover the entire board, including any exposed adhesive, with release liner.
5. Place in press and lock closed for **15-45 seconds**.
6. Remove from press and cool under weight.
7. Trim to size and fit into frame.

Hot Vacuum Press

The draw time of a vacuum press varies depending on manufacturer and overall size of the press, but an average draw+dwelt time is 4 minutes in a vacuum press. Since InSite HA bonds with a shorter dwell time the suggested vacuum time is 3-4 minutes. A 2 minute mount time allows for a 1 minute draw of the air and moisture from within the press and 1 minute dwell time to activate and bond the layers. Release boards are never required for any technique in a vacuum press. Use of one will require additional time.

1. Preheat press to 160°F temperature.
2. Remove liner and align image face up on the adhesive side of the board.
3. Cover the entire mount board and image with release paper to protect the platen.
4. Close lid, activate the vacuum and run a full 3-4 minutes (including draw time).
5. Remove from press and cool under weight.
6. Trim to size.

[Mounting Instructions for Roll Laminators – page 2](#)

WARNING: Foamboard is combustible and may constitute a fire hazard if improperly used. Do not expose to flame or other ignition source as this product may burn rapidly. For more information and MSDS sheet call Gilman Brothers Company at 800-852-4220 (IHAI-091814)



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InSite HA bonds at 160°F in 15-45 seconds in a mechanical press; at 160°F in 4 minutes in a hot vacuum press; and 270°F-290°F at a speed of 1-1/2 to 3 feet per minute (fpm) using a hot roller. Available in white or black it is ideal for heat tolerant paper, newspaper, poster images and RC photographs. It is available 1/8" to 3/16" thick, in sizes ranging from 24"x36" to 48"x96".

Mounting Instructions for Roll Laminator

InSite Heat Activated foamboard bonds equally well in a heated roll laminator. Manufacturer suggested temperature is 280°F at 2 feet per minute. The speed may be adjusted to better accommodate the type and weight of the print being mounted. The temperature may be increased but it is always better to decrease the roller speed before increasing temperature.

Hot Roll Laminator

It is important to feed the board with the sealed liner edge entering the roller nip first to ensure smooth alignment and no ripples of the release liner.

1. Warm roller to 280°F temperature and set fpm speed.
2. Using a sticky roller, clean the board of all dust particles.
3. Center image on board, adhesive side up.
4. Adjust rollers to substrate thickness.
5. Place release paper over top of the image and board covering all exposed adhesive.
6. Nip end into rollers and allow it to feed through on automatic.
7. Remove, cool and trim to size.

Laminating films may be applied over a print while mounting if the roller has that capability.

The reason that hot rollers require a higher temperature to activate and mount the same board product than mount presses is directly related to the actual dwell time between the rollers. A dry mount press holds a the HA board under pressure for a duration of time determined by the size and weight if the image and release paper used in the mount package. A roll laminator required a higher temperature in order to activate the permanent adhesive as the board is pulled beneath the heated roller which less than a second to activate the layers and create the bond. It is the shorter duration of the exposure to the higher temperatures that protects the board and image from heat damage.

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