

Correct Procedure for Gluing Preciosa Stones

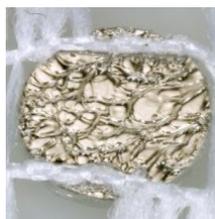
When using new untried adhesives or applying the stones to unknown carrier materials, it is recommended to run a **peeling test** first, at the same time strictly observing technical instructions given by the adhesive's manufacturer.

Achieving optimum joint strength

To achieve optimum joint strength, it is necessary to glue the stones only onto suitable carrier materials, offering a sufficient contact area that ensures the required adhesion of the stone.



Sufficient contact area



Insufficient contact area

The thickness of the adhesive's layer is an important factor and, therefore, it should be adapted to different parameters of the stones as well as carrier materials used.

The amount of the adhesive used

Optimum amount of the adhesive - Each stone size requires a corresponding amount of the adhesive. To achieve top quality of the glued joint, we recommend using adhesive dispensers. These help you to choose the optimum dose of the adhesive, ensuring the best possible adhesion.

The lack of the adhesive results, as a rule, in too thin a layer of the adhesive, or in the adhesive unevenly covering the stone's back. This may cause the adhesion to decrease and so the probability that the stone may detach is higher.

Larger than optimum amount of the adhesive may stain the fabric around the stone, the reverse side of the textile carrier material or the surface of the stone. This is characterized by a distinctive strip of the adhesive irregularly surrounding the stone, or by an unsightly great smudge on the reverse side of the textile material.

Useful advice:

When gluing larger stones, mind that the adhesive slightly surrounds the stone's girdle after having been pressed onto the carrier material. Otherwise, the sufficient joint strength is not guaranteed and it is more than likely that the stone will detach.



An excessive amount of the adhesive



A protective strip of the adhesive around the stone's girdle



An adhesive dispenser

Gluing stones onto elastic carrier materials

Before gluing fashion jewellery stones onto elastic, i.e. "stretch" materials (knitted fabrics, fabrics containing polyurethane fibres, e.g. Lycra, nylon stockings etc.), it is advisable to pre-stretch them slightly first. This simple technique helps decrease the forces that could cause future adverse joint stress.

Follow the recommended procedure:

1. Prepare the carrier material.
2. Check the stone for cleanliness; if it is not clean, clean it.
3. Make sure that the selected adhesive is suitable for the carrier material used, meeting technical requirements specified in the instructions given by the adhesive's manufacturer.
4. To test the adhesive, select a scrap piece of surplus carrier material. If it is not available, try to find an unseen part of the material used, where you can carry out the test without fear of spoiling the final product.
5. Apply an appropriate dose of adhesive to the carrier material or to the stone's back according to the manufacturer's instructions.
6. Applying gentle pressure, press the stone onto a drop of adhesive placed on the carrier material.
7. Let the adhesive set according to the manufacturer's instructions.
8. After the adhesive has set, it is advisable to run a peeling test. If the results are satisfactory, you can continue gluing the remaining stones.

For more information, please visit www.preciosa.com or contact us at info@preciosa.com