When a major bus producer in Europe was facing challenges to reduce their assembly times bonding exterior panels to the frame of the vehicle, Bostik technical engineers were called in to audit their process and make adhesive improvement recommendations. Our engineers found that Bostik’s STR series adhesives and sealants could help them achieve their savings goals.

**THE PROBLEM**
The manufacturing assembly process of the original equipment manufacturer required pre-treatment of the surfaces with cleaner and primers prior to bonding. They then used a two component polyurethane to bond the panels in place. Once the panels were adhered in place on the frame, they were immediately clamped for four hours until the bond was strong enough for the fixtures to be removed. This process was very labor intensive and everything was manually applied with no automation other than the adhesive pumping system.

The STR series features excellent green strength and primerless adhesion on many substrates including: painted and unpainted steel, aluminum, composite materials and glass.

The bus manufacturer ran field trials and found they were able to reduce processing time significantly. The elimination of the primer step saved them 30 minutes of labor, the cost of the primers and the extra cost of consumables related to the priming step. The high green strength of the STR series, with the assistance of a temporary tape eliminated the need for clamping.

The manufacturer converted their facility over to Bostik’s STR series and was able to reduce their process time from 4 hours to 30 minutes for each assembly.

**THE SOLUTION**
Bostik reviewed and evaluated their process and recommended the STR 350A and STR 360A SKF.