

Bonding Rear View Mirror Brackets to Windshield Glass

Objective Heat steel, stainless steel, nickel chrome rear view mirror brackets and adhesive are to be bonded onto a section of windshield glass.

Material Steel, Stainless Steel, and Nickel Chrome rear view mirror brackets measuring 1"(25.4mm) in diameter and 1/8" (3.2mm) thick. A 6" by 6"(152.4mm x 152.4mm) section of windshield glass.

Temperature 300°F(148.9°C)

Frequency 135 kHz

Equipment

- Ambrell 3kW induction heating system equipped with a remote workhead.
- An induction heating coil designed and developed specifically for this application.

Process A unique four over four double wound pancake coil is used for the bonding application. A temperature of 300°F(148.9°C) is applied for 5 seconds to bond the adhesive to the mirror bracket and glass.

Results/Benefits Induction heating provides:

- Provide high strength bond upon cooling
- Low temperature avoids damage to components
- Minimal energy and time

