

Directions for use: Glue container

Preparation of the surface: The material to be bonded must be dry, dust and grease free. All materials must be conditioned before processing. It is advisable to allow the materials to acclimatise at 21°C with a relative humidity of 45 to 55% for 48 hours.

Application: Apply an equally distributed layer of adhesive all over both surfaces (approx. 80% coverage in the middle and 100% at the edges). If a combination of porous and non-porous materials is used, it is advisable to apply the adhesive to the non-porous material first. It is also advisable to spray with a glue cartridge aimed at right angles to the materials. Move the gun smoothly and avoid the adhesive building-up at one spot or making the surface too wet. One layer is generally enough for most surfaces but this does depend on the degree of porosity of the material. An extra layer of adhesive could be needed for porous material. Protect the adhesive from dust and dirt while drying. Allow the adhesive to dry completely. The adhesive is ready for bonding as soon as it no longer feels tacky.

Drying: The adhesive dries in approx. 2-5 minutes under normal conditions (21°C and 50% humidity). Higher humidity or lower temperatures could prolong the drying time. When the adhesive is dry the parts can be bonded, the joint can be made within one hour (open time!). The adhesive surface must be kept free of dirt such as dust, sawdust, wood particles or any other material. **Important!** The total number of square metres that can be bonded depends on the porosity of the material and the way the adhesive has been applied.

Indexing: spacers, such as splinter-free battens, can be used for positioning the materials to be bonded if you do not want an immediate bond. If this method is used, remove the spacers from between the surfaces to be bonded from the middle outwards and apply maximum/even pressure, starting in the middle and working out to the edges. For a good bond you should use a pressure roller or a hammer and block to apply maximum pressure to the entire surface and particularly the edges. Bonded joints can be processed immediately (sawing, milling, drilling, etc.).

Strength build-up of bonded joint: full strength is built-up within approximately 48 hours. A longer period of build-up is necessary in lower temperatures or higher humidity. Testing the strength of the bond by pulling at the edges must be delayed until the adhesive has completely hardened. If the adhesive joint is broken and then put together again the strength of the joint will be affected.

Cleaning: adhesive residue can be removed with thinner.

Storage and treatment: The adhesive should be stored at a temperature between 5°C and 20°C and away from direct sunlight. In view of the fact that cold rises up from concrete floors it is not advisable to place adhesive tanks directly on them, but preferably on a rack or a pallet. Use good equipment for transporting the tanks, prevent penetration or damage to full or partially full tanks. The tanks must not be re-used!

Shelf life: adhesive is good for 12 months when stored under the recommended conditions and in an unopened tank.

How the adhesive tank works: The adhesive tank is pressurised and no external pressure provision is needed. First assemble the gun. Open the tap completely, aim the spray head at the material to be bonded, keep the gun at a distance of approx. 30 cm from the surface and spray on an equal layer of adhesive. When work is finished lock the gun with the control knob. Keep the tap on the adhesive tank open and with that the pressure on the spray gun. Disconnect the hose with spray gun only when you can immediately re-connect it to a new full adhesive tank. Keep the spray head free of excess adhesive by rubbing off the hardened adhesive residue or dipping it in thinner. To prevent damage to the gun, do not stick anything sharp into the spray opening!

ALWAYS ENSURE GOOD VENTILATION AND CORRECT VAPOUR EXTRACTION IN SMALL OR ENCLOSED AREAS.

SHAKE TANK BEFORE USE!

PROTECT THE TANK FROM TEMPERATURES BELOW 0°C OR ABOVE 50°C.

CHANGING THE TANK

- The tank is almost empty when it begins to splutter during spraying.
- Turn off the tap when a new tank is available.
- Spray the hose until empty.
- Re-connect the hose to the new adhesive tank and open up the new tank's tap immediately. It is now ready for use.
- Allow the empty adhesive tank to completely empty in a well-ventilated place by opening the tap. The adhesive tank will continue to splutter for a while. Leave the tap open. A minimum amount of adhesive remains in the tank which will harden completely after approx. 48 hours.

Only completely empty tanks as described above can be punctured with a spike, via the special weak spots next to the tap. The waste disposer can then see that they are not pressurised and they can be treated as normal industrial waste.