

Adhesive Application and Best Practice Guide



Abrasives



Cleaners and Primers



Structural Adhesives



Liquid adhesives



Sealants and contact adhesives

Surface preparation may involve one or more steps depending upon material.

- 1. Surface preparation – Abrading:** Using a light grit abrasive or abrasive cloth, work the area to be bonded in small crisscross motions until adequate scoring is visible.
 - a. Surface preparation – Cleaning:** Clean area with a low lint cloth* and Isopropyl alcohol (IPA). Allow to dry for 30-60 seconds.
 - b. Surface preparation – Priming:** If priming is required, apply primer to a lint free cloth* and prime required surface(s). Allow to dry for 30-60 seconds.
- 2. Bonding – 2 part adhesives:** When using 2 part adhesives through a static mixer nozzle, it is vital that you 'burp' the cartridge by removing the lid then locating the cartridge in the gun and applying a little pressure to the trigger until each side of the adhesive (A&B) is uniform. Then fix the static mixer nozzle and ensure part A&B are mixing correctly when trigger is squeezed. It is also advised to dispense a small amount of adhesive to waste to ensure it has mixed correctly prior to bonding. Apply adhesive to one surface in either bead or dot form. When applying the second surface, ensure at least 0.5mm of product thickness is left between both surfaces. Once product is in correct position it is important not to disturb the bond for the length of time it takes to gain handling strength. Once handling strength is gained, the product is still curing and as such should not be moved too much otherwise the bond will be weakened. Allow product a full 24 hours to cure prior to exposing to temperature change or any stress.
- 3. Bonding – Single part liquid adhesives:** Depending upon the viscosity of the product, the application will vary. If water like consistency, application may be made using a syringe for a wicking type bond or dipping into a dish. If thicker, a syringe may still be used for a fillet bond. Most single part liquid adhesives are fast curing, however it is important not to disturb the bond during this process. For UV curing adhesives, please refer to the UV data sheet.
- 4. Bonding – Single part sealant type adhesive:** Apply using a skeleton gun in dots or beads.* If working with a moisture curing product, apply in bead, but do not close the loop if applying in a picture frame style as the inner areas will not cure properly. Most single part adhesives require 24 hours to fully cure, so avoid weight loading or disturbing the bond during this time.
- 5. Removal:** In the event of adhesives needing to be removed, please consult with our technical team as this will depend on the adhesive and substrates.
- 6. Health and Safety:** Always refer to the MSDS sheet for the adhesive, cleaners and primers being used.

* When applying either IPA or primer, it is important to work in one direction, turning the cloth regularly so as not to deposit contaminant back to surface.

When bonding materials together using any adhesive based product, it is important to ensure the surfaces are clean, dry* and free from dust and grease and also that they are compatible with the adhesive to be used.

*SIGNBONDER and some other single parts in the INDASOL range can be used in wet conditions. Please ask for further details.

*SIGNBONDER is best applied in bead form.

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