

Technical data sheets



# DURABASE WS WARPSEAL



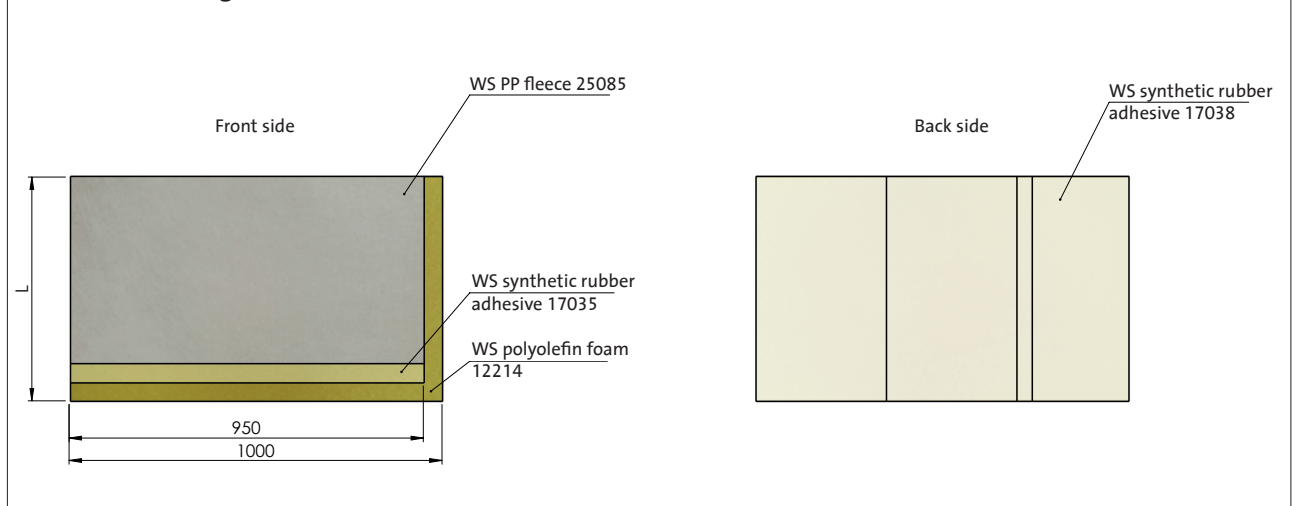
**Technical data sheet**

# DURABASE WS

## Sealing membrane

<b>Item code</b>	WS
<b>Description</b>	Composite seal for walls and floors in indoor areas
<b>Product group</b>	Matting systems, sealing
<b>Colour</b>	yellow
<b>Length</b>	5, 10, 30 m <sup>2</sup>

**Technical drawing**



Indications: For technical reasons, tolerances in colour effects of the materials and print are possible.  
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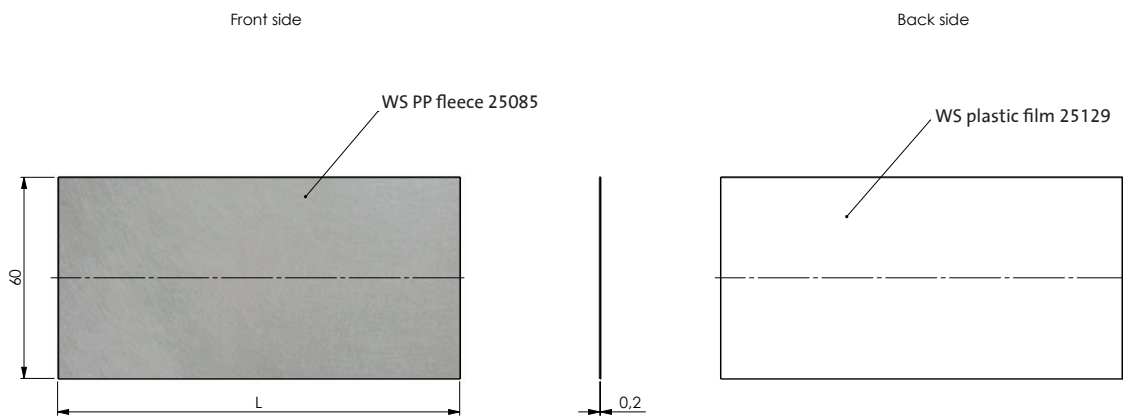
## Technical data sheet

# DURABASE WS

## Fleece strips/Finishing tape

Item code	WSVS 60-10
Description	Fleece strips
Product group	Matting systems, sealing
Colour	white

### Technical drawing

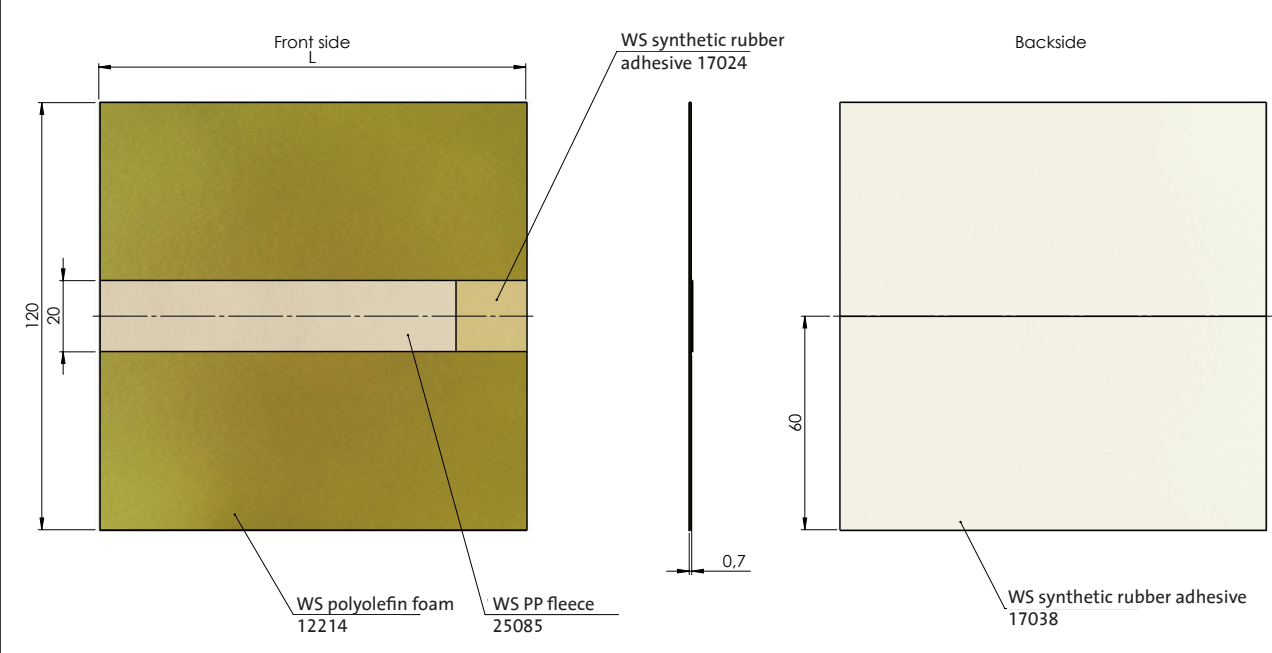


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## Technical data sheet

# DURABASE WS Corner tape

Item code	WSE120
Description	Sealing tape for the standardised covering of joints as well as wall and floor transitions with trowel protection
Product group	Matting systems, sealing
Colour	yellow
Length	10 m, 50 m
<b>Technical drawing</b>	
 <p>The technical drawing illustrates the construction of the DURABASE WS Corner tape. It includes three views: a front side view, a backside view, and a cross-section view. The front side view shows a total width of 120 mm, with a central adhesive strip of 20 mm. The backside view shows a total width of 60 mm. The cross-section view shows a thickness of 0.7 mm. The materials used are WS polyolefin foam (12214), WS PP fleece (25085), and WS synthetic rubber adhesive (17024 and 17038).</p>	

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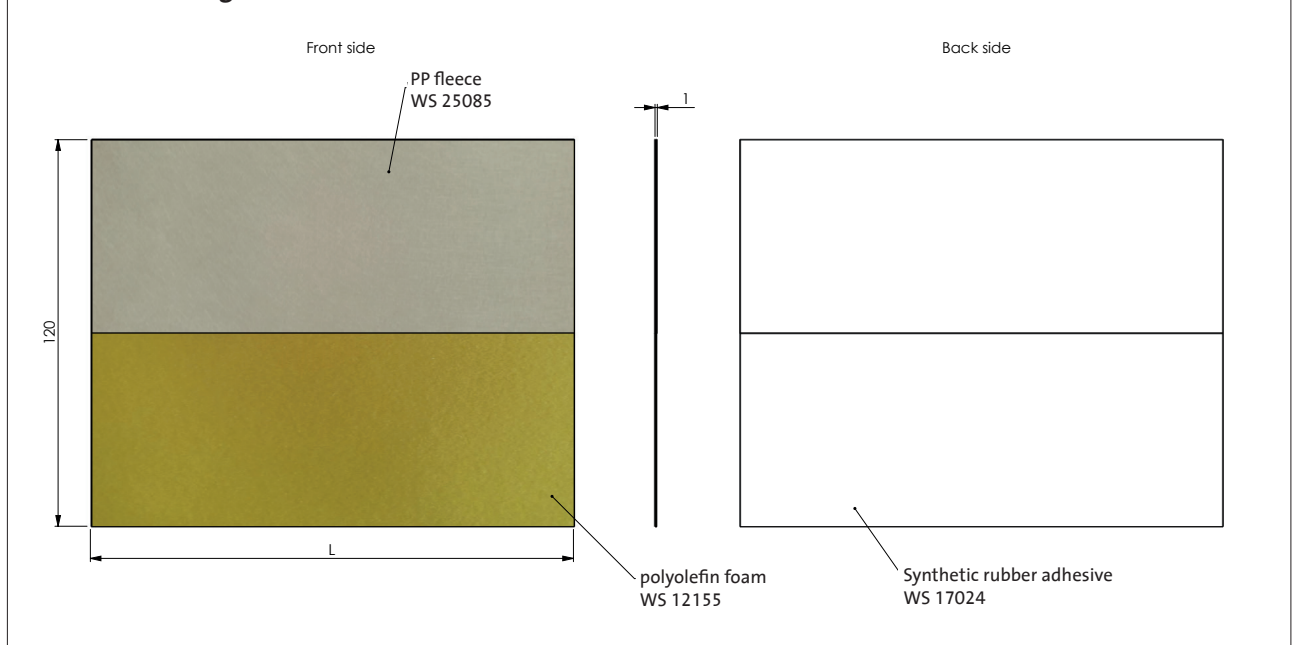
**Technical data sheet**

# DURABASE WS

## Base sealing

<b>Item code</b>	WSS 120-10/1 WSS 120-50/1
<b>Description</b>	Corner connector for tubs, wall-to-floor, floor-to-floor
<b>Product group</b>	Matting systems, sealing
<b>Colour</b>	yellow

**Technical drawing**



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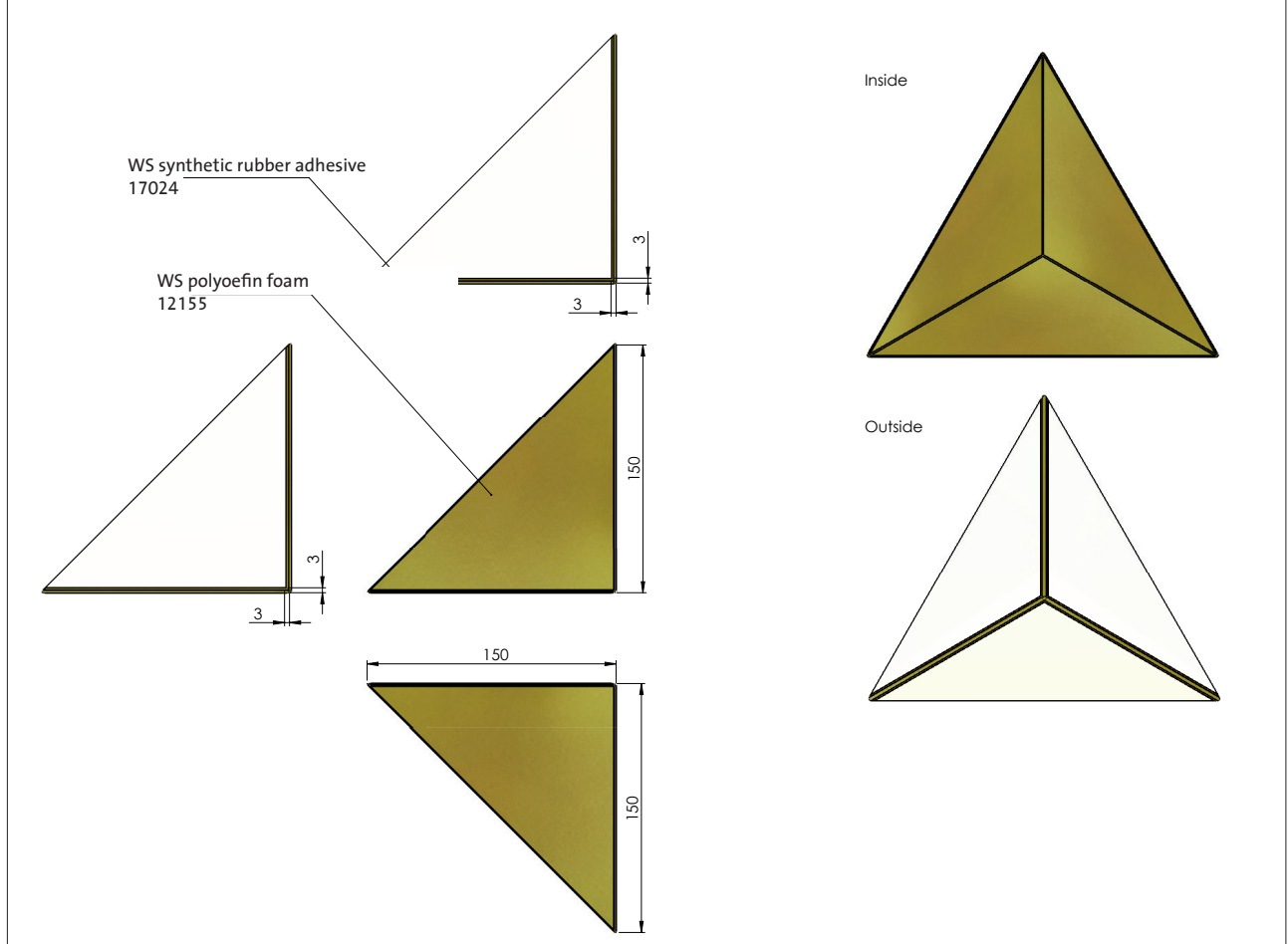
**Technical data sheet**

# DURABASE WS

## Internal corner

<b>Item code</b>	WSXI/3
<b>Description</b>	Corner connector for tubs, wall-to-floor, floor-to-floor
<b>Product group</b>	Matting systems, sealing
<b>Colour</b>	yellow

**Technical drawing**



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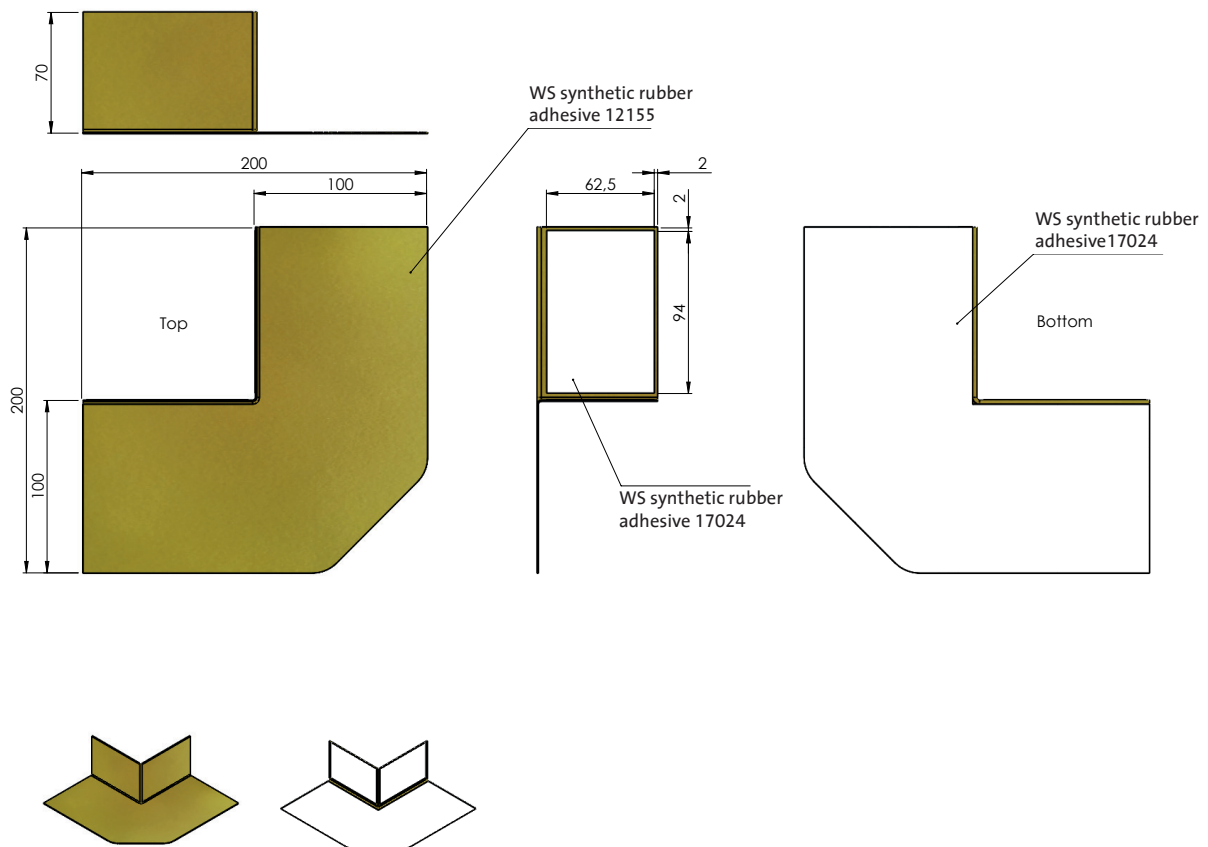
**Technical data sheet**

# DURABASE WS

## External corner

<b>Item code</b>	WSX/5
<b>Description</b>	External corner
<b>Product group</b>	Matting systems, sealing
<b>Colour</b>	yellow

**Technical drawing**



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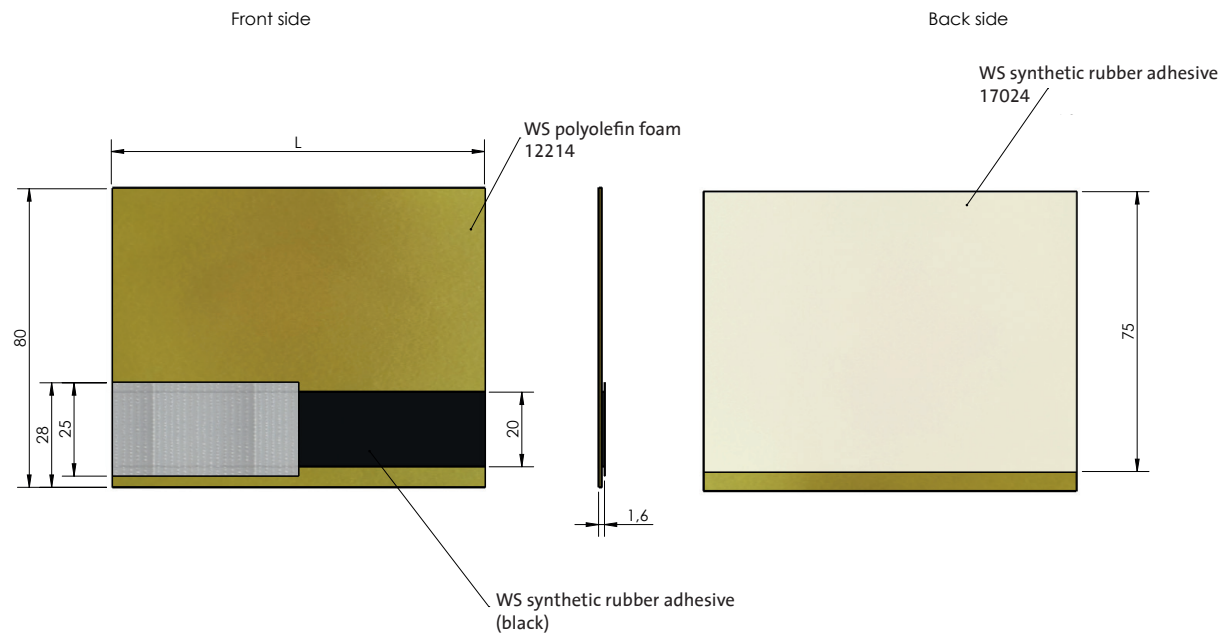
**Technical data sheet**

# DURABASE WS

## Sealing tape “tube”

<b>Item code</b>	WSW
<b>Description</b>	Sealing tape for tub/perimeter joint
<b>Product group</b>	Matting systems, sealing
<b>Colour</b>	yellow
<b>Length</b>	30 m

**Technical drawing**



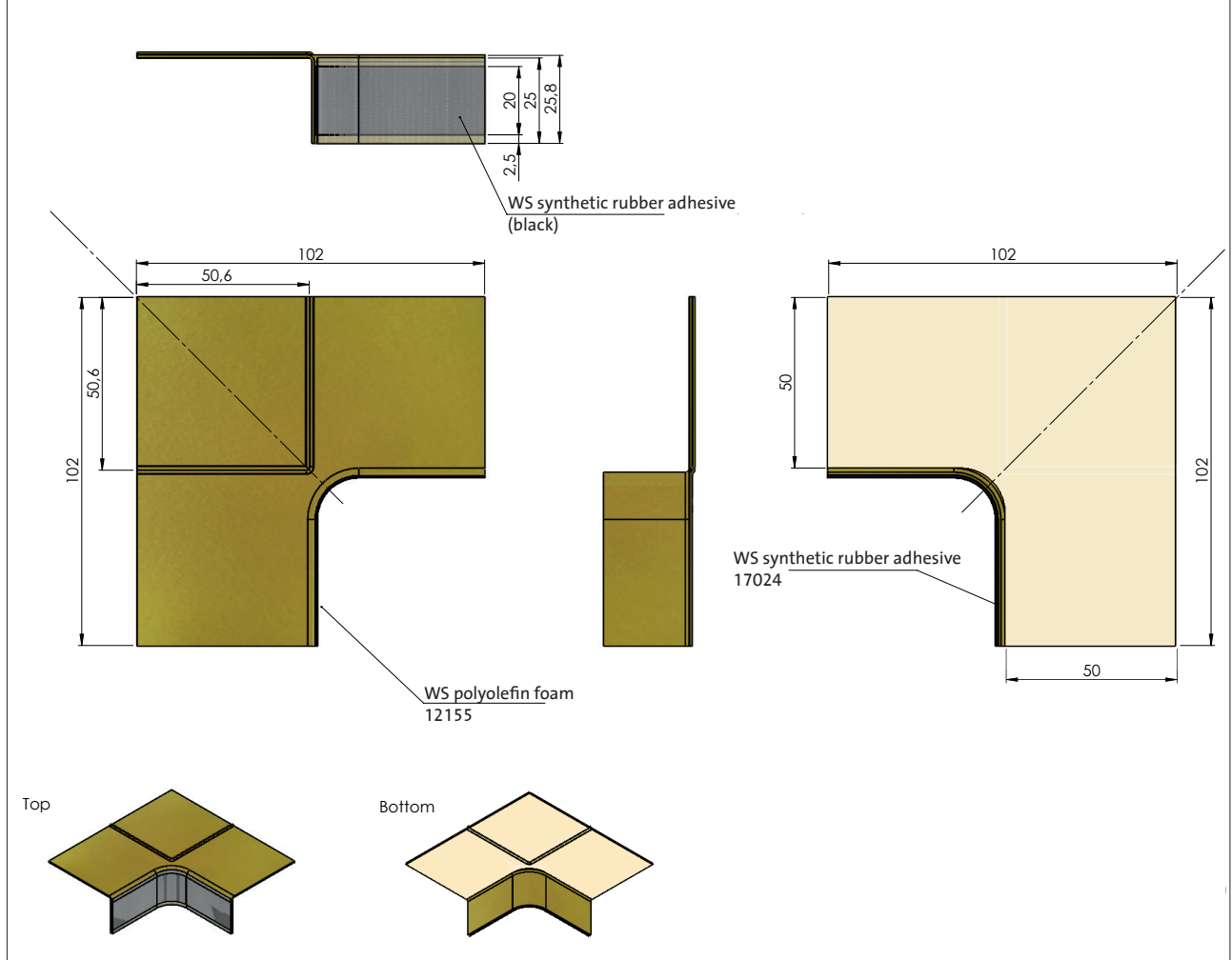
Indications: For technical reasons, tolerances in colour effects of the materials and print are possible. All information is based on the best of our knowledge and belief. No guarantee can be derived from this. We reserve the right to any technical changes if they are in the interest of progress or if they are production-related.

Technical data sheet

# DURABASE WS Flexible corner

Item code	WSXF/3
Description	Corner connector for tubs, wall-to-floor, floor-to-floor
Product group	Matting systems, sealing
Colour	yellow

Technical drawing



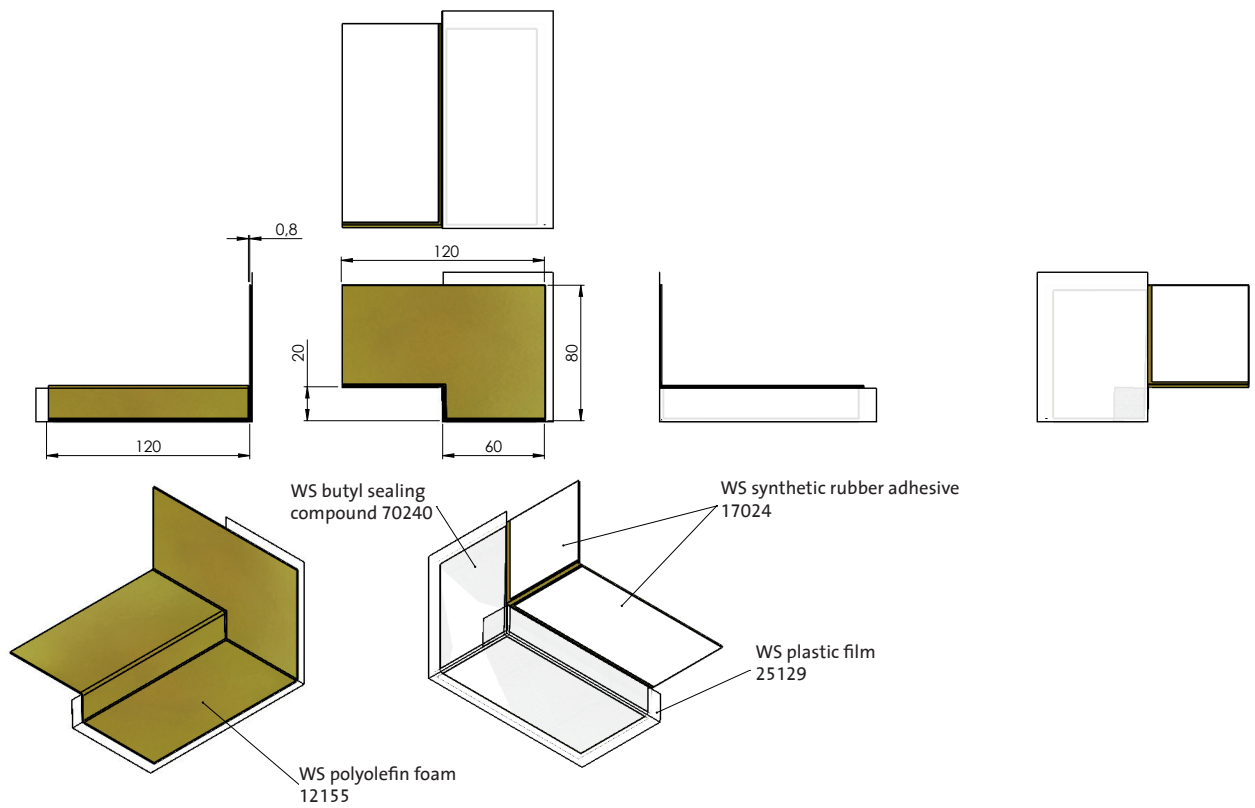
Indications: For technical reasons, tolerances in colour effects of the materials and print are possible. All information is based on the best of our knowledge and belief. No guarantee can be derived from this. We reserve the right to any technical changes if they are in the interest of progress or if they are production-related.

**Technical data sheet**

# DURABASE WS 3D left corner

<b>Item code</b>	WSKL 20/10
<b>Description</b>	3D corner
<b>Product group</b>	Matting systems, sealing
<b>Colour</b>	yellow

**Technical drawing**



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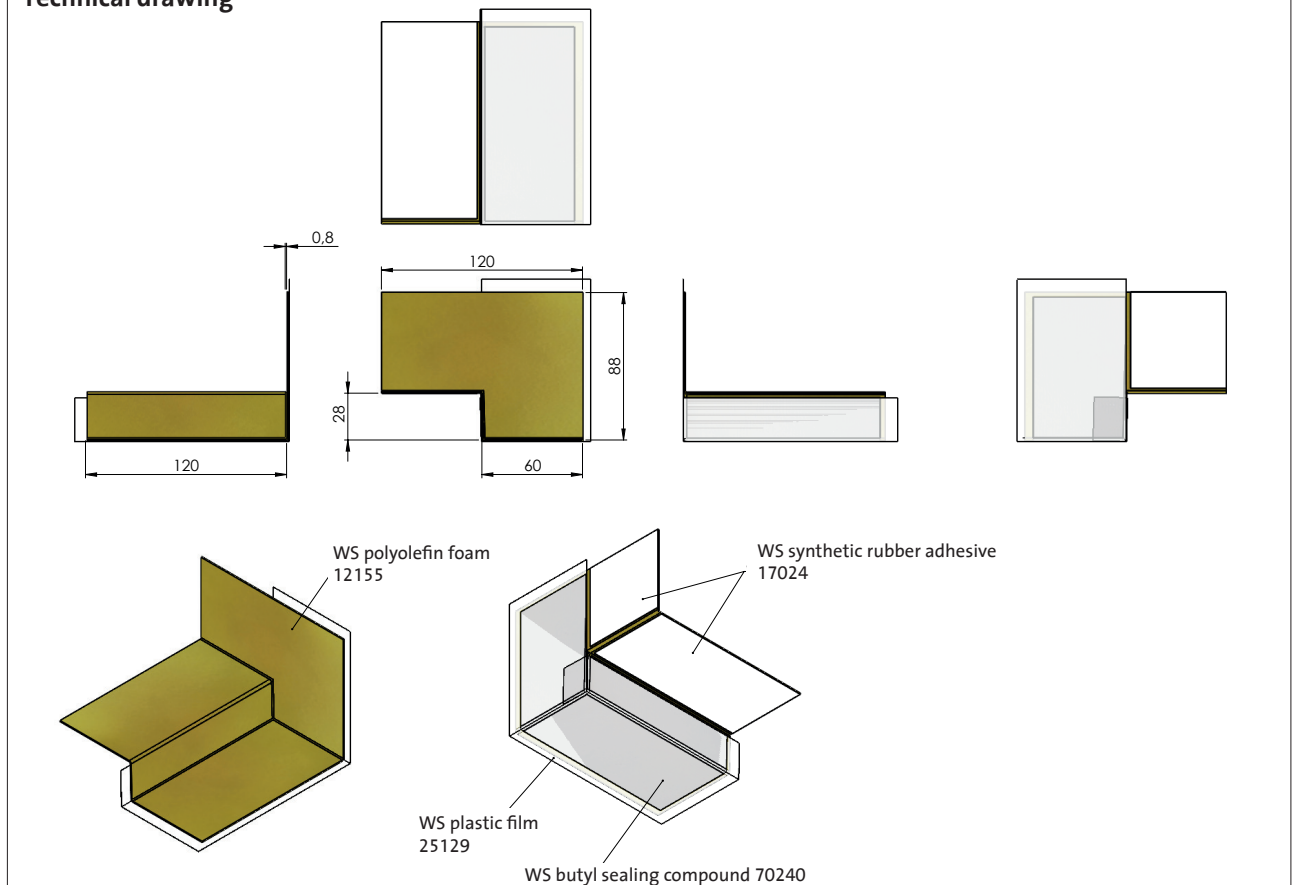
**Technical data sheet**

# DURABASE WS

## 3D left corner 28 mm

<b>Item code</b>	WSKL 28/10
<b>Description</b>	3D corner
<b>Product group</b>	Matting systems, sealing
<b>Colour</b>	yellow

**Technical drawing**



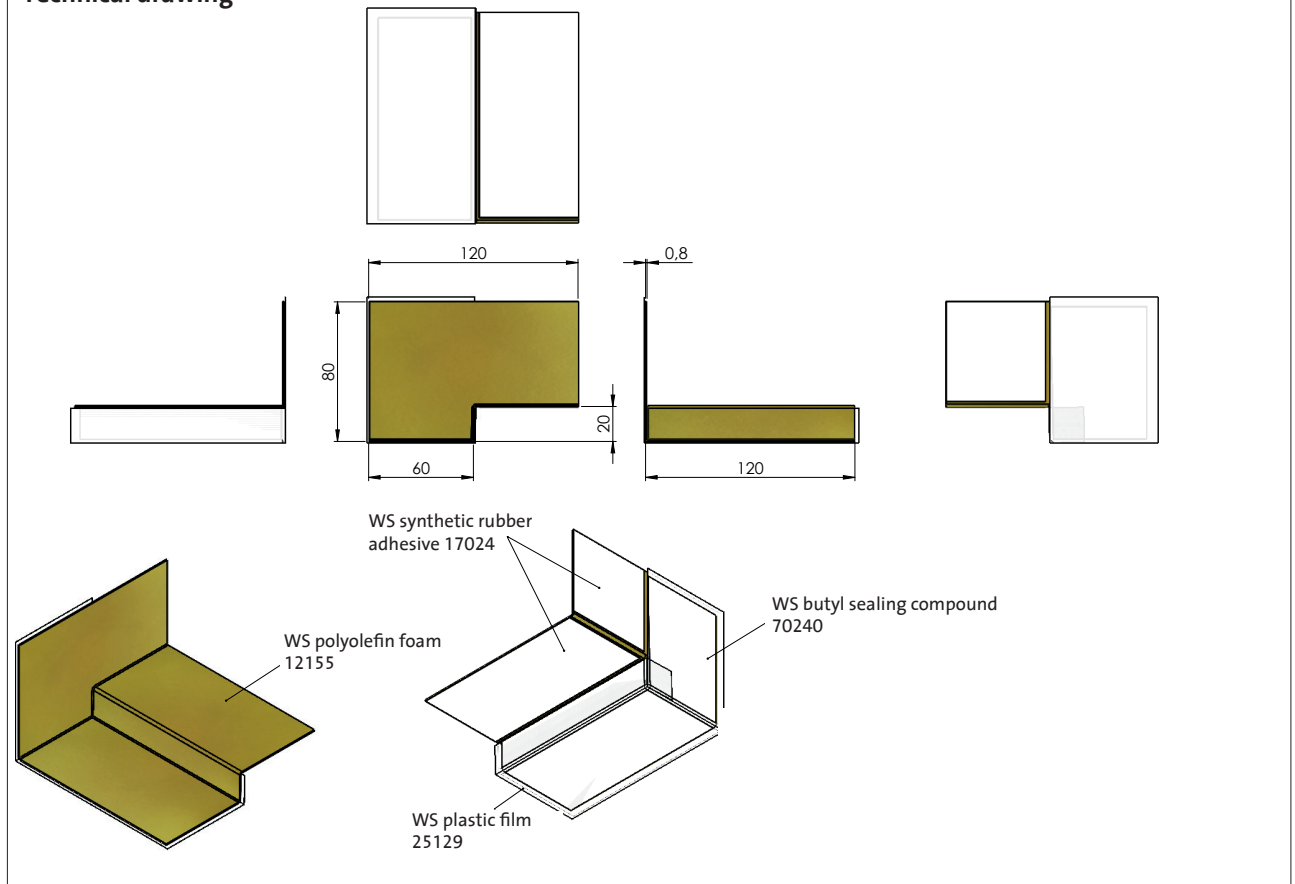
Indications: For technical reasons, tolerances in colour effects of the materials and print are possible.  
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**Technical data sheet**

# DURABASE WS 3D right corner

<b>Item code</b>	WSKR 20/10
<b>Description</b>	3D corner
<b>Product group</b>	Matting systems, sealing
<b>Colour</b>	yellow

**Technical drawing**



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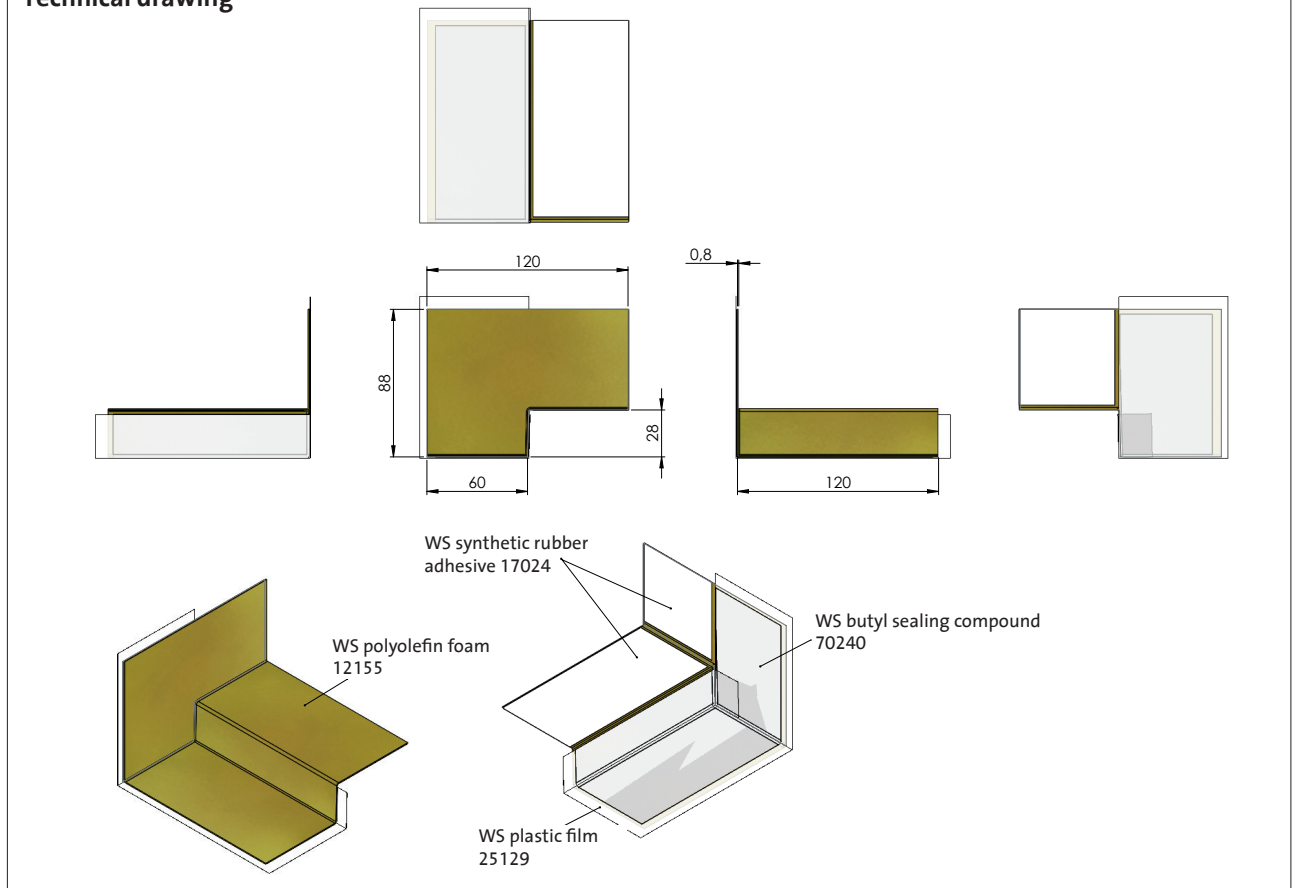
**Technical data sheet**

# DURABASE WS

## 3D right corner 28 mm

<b>Item code</b>	WSKR 28/10
<b>Description</b>	3D corner
<b>Product group</b>	Matting systems, sealing
<b>Colour</b>	yellow

**Technical drawing**



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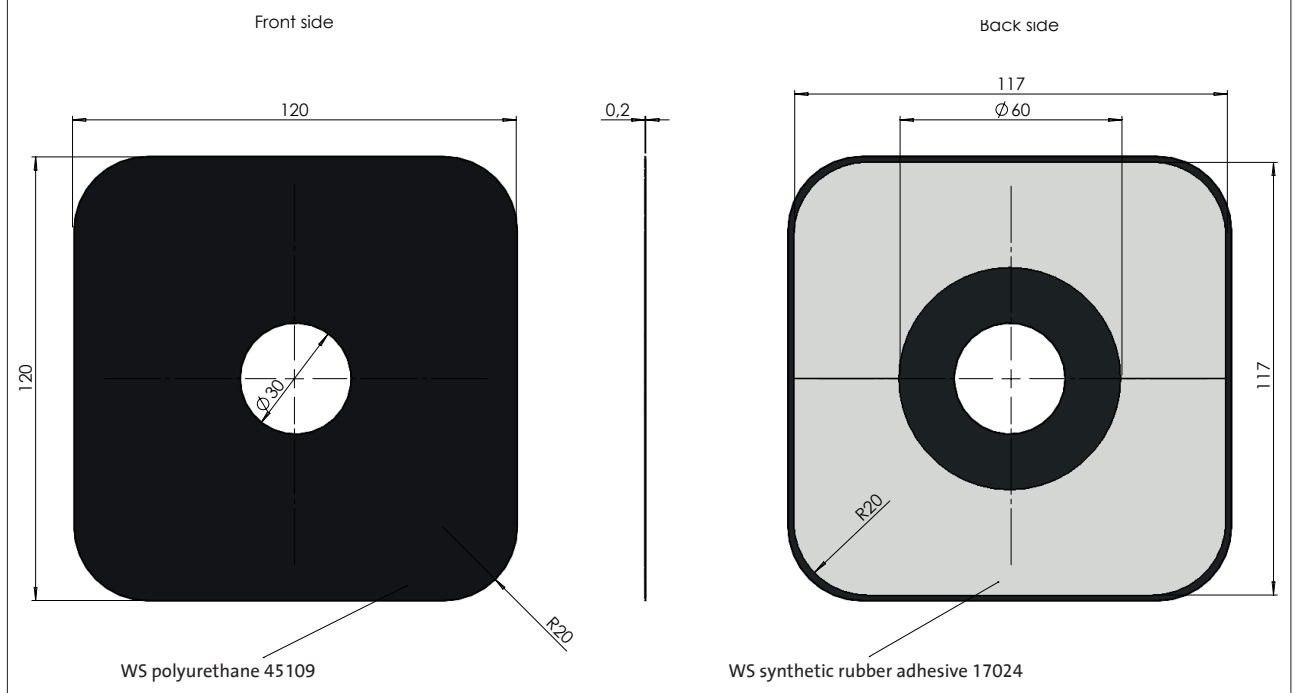
**Technical data sheet**

# DURABASE WS

## Wall collar DN50

<b>Item code</b>	WSWM50
<b>Description</b>	Liner expansion zones for DN50 pipe feed
<b>Product group</b>	Matting systems, sealing
<b>Colour</b>	black
<b>Diameter</b>	30 mm
<b>Dimension</b>	120 x 120 mm

**Technical drawing**



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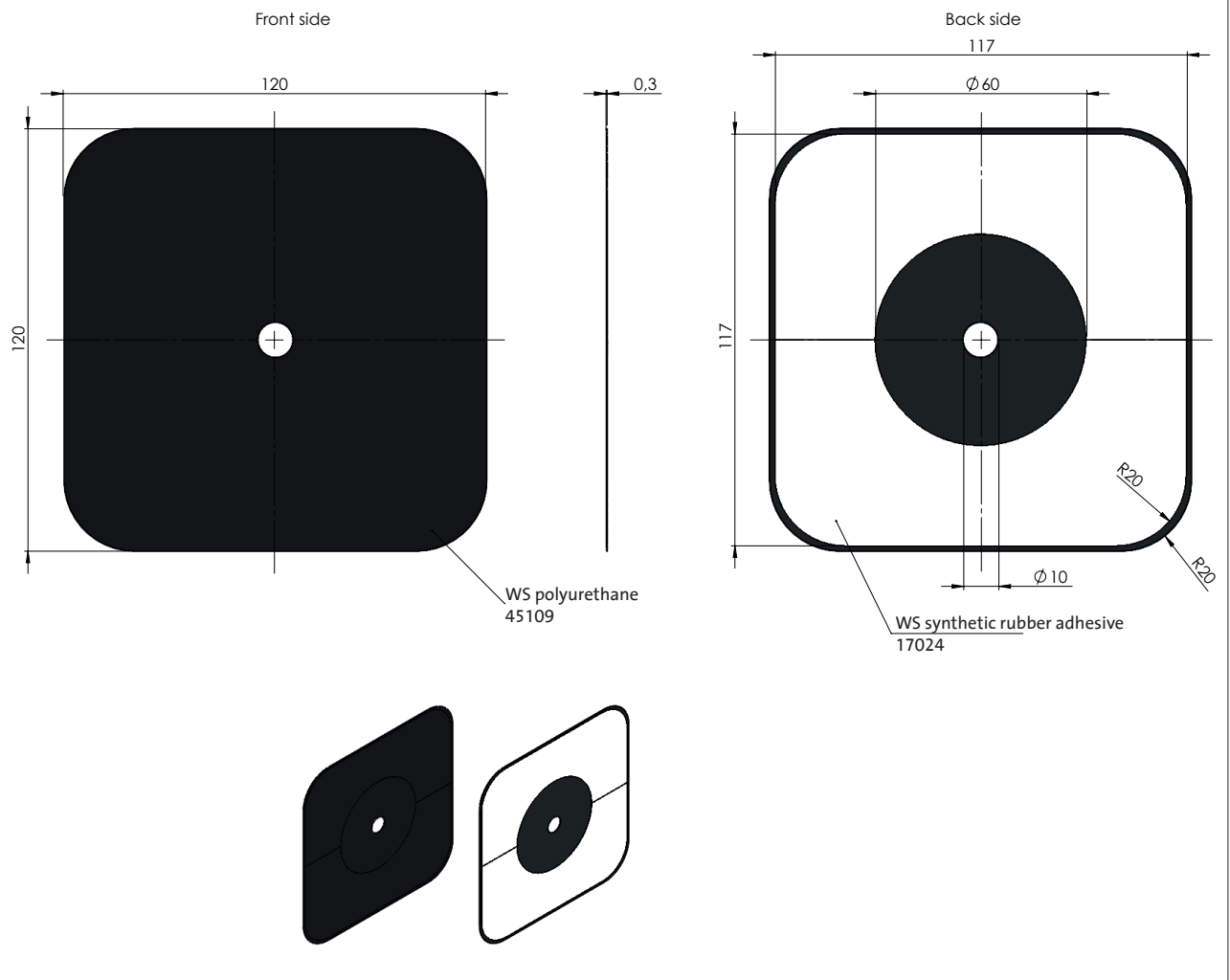
**Technical data sheet**

# DURABASE WS

## Wall collar 1/2

<b>Item code</b>	WSWM 1/2"/10
<b>Description</b>	Liner expansion zones for 1/2 pipe feed
<b>Product group</b>	Matting systems, sealing
<b>Colour</b>	black
<b>Diameter</b>	10 mm
<b>Dimension</b>	120 x 120 mm

**Technical drawing**



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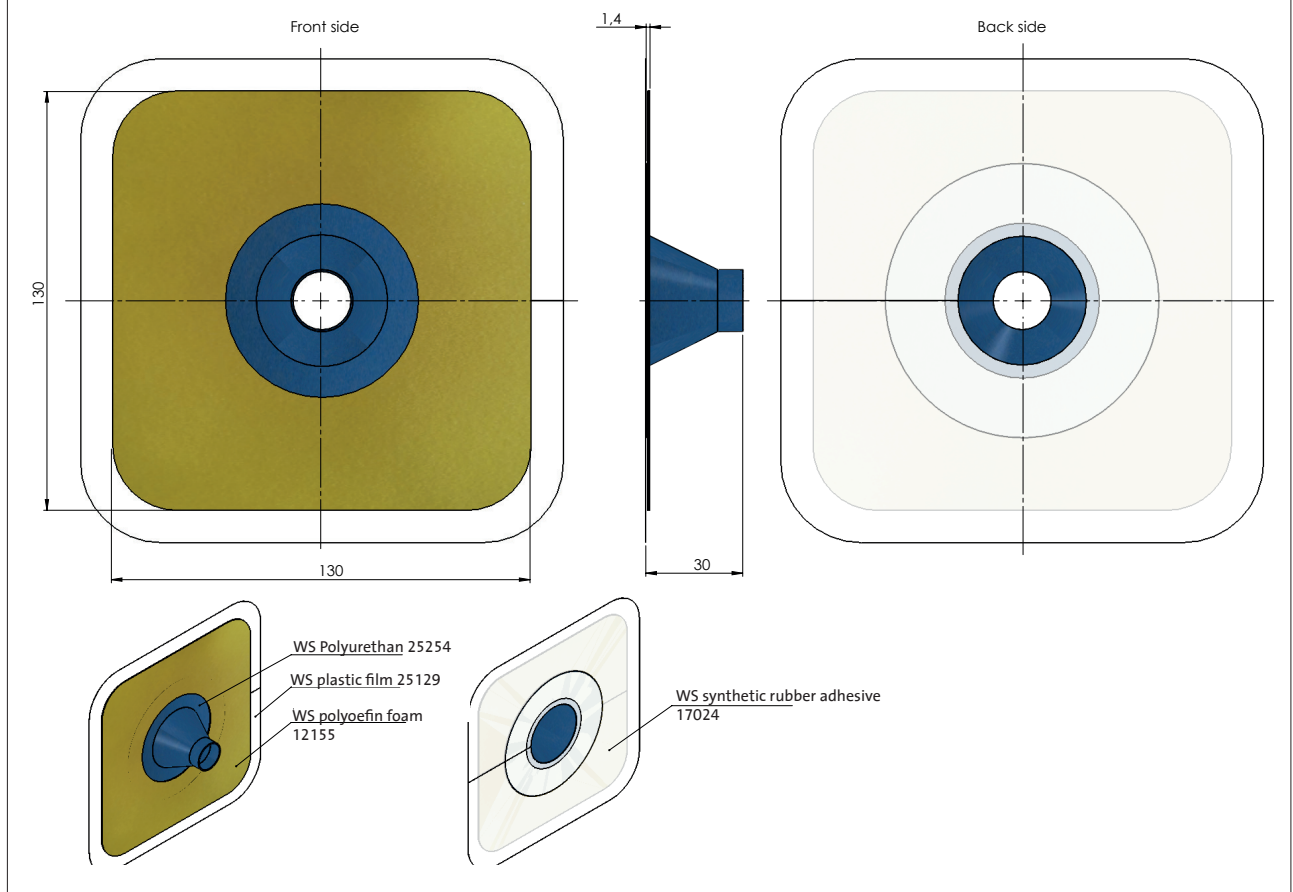


Technical data sheet

# DURABASE WS Drip

Item code	WSTS/2
Description	Drip protection
Product group	Matting systems, sealing
Colour	yellow/blue

Technical drawing



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**WS Polyurethan 25254**  
**WS Polyurethan 25254**  
**WS Polyuréthane 25254**

Properties / Eigenschaften / Propriétés	Standard / Norm / Norme	Unit / Einheit / Unité	Data / Wert / Valeur
<b>General / Allgemein / Généralités</b>			
Strength / Stärke / Épaisseur		$\mu\text{m} \pm 10 \%$	600
Hardness / Härte / Dureté	ASTM D2240	Shore	85 A
Depth / Tiefe / Profondeur		$\text{g}/\text{cm}^3$	1.20
Max. Width / Max. Breite / Largeur max.		$\text{mm} \pm 5$	500
Color / Farbe / Couleur			Blue / Blau / Bleu
<b>Elongation strength / Dehnfestigkeit / Résistance à l'allongement</b>			
	ISO 37	$\text{kgf}/\text{cm}^2$	400
<b>Elongation / Dehnung / Allongement</b>			
	ISO 37	%	530
<b>Tensile strength / Résistance à la déchirure</b>			
	ISO 6383/1	kgf	800
<b>Softening point / Point de ramollissement</b>			
	DIN 55316	°C	70/80
<b>Melting point / Schmelzpunkt / Point de fusion</b>			
	ASTM D3417		145
<b>Abrasion resistance / Scheuerfestigkeit / Résistance à l'abrasion</b>			
	Taber Test	$\text{mm}^3 \pm 20$	60
<b>UV-resistance / UV-Beständigkeit / Résistance aux UV</b>			
	ISO 4892-3		3



## Other / Sonstiges / Autres

Properties /	Free from latex, PVC, TBT, MBT, DBT.
Eigenschaften /	Frei von Latex, PVC, TBT, MBT, DBT.
Propriétés	Sans latex, PVC, TBT, MBT, DBT.
Storage conditions /	The material must not be exposed to temperatures that are too low or too high (+5 - +35 °C).
Lagerbedingungen /	Das Material darf keinen zu niedrigen oder zu hohen Temperaturen (+5 - +35 °C) ausgesetzt werden.
Conditions de stockage	Le matériau ne peut pas être soumis à des températures trop basses ou trop élevées (+ 5 – + 35 °C).

The information in our data sheet is given to the best of our knowledge, based on the results of practical experience and tests carried out. However, they are non-binding and do not constitute an assurance of properties in the sense of BGH jurisdiction. Due to the versatile application possibilities of our products, we recommend a thorough suitability test of the product on original materials before it is released for production. Our application technology department will be happy to advise you on this. All our products are subjected to strict quality control.

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**WS Polyolefin foam 12155  
WS Polyolefin-Schaum 12155  
WS Mousse polyoléfine 12155**

Properties / Eigenschaft / Propriété	Standard / Norm / Norme	Unit / Einheit / Unité	Data / Wert / Valeur
<b>Material / Material / Matériau</b>			
Density / Dichte / Densité	ISO-845	kg/m <sup>3</sup>	143
<b>Tensile strength at 23 ° C / Zugfestigkeit bei 23°C / Résistance à la traction à 23 °C</b>			
Longitudinal direction, at break / Längsrichtung, bei Bruch / Sens longitudinal, à la rupture	ISO-1926	kPa	2000-3200
Transverse direction, at break Querrichtung, bei Bruch / Sens transversal, à la rupture	ISO-1926	kPa	1500-2500
<b>Elongation at 23 ° C / Dehnung bei 23°C / Allongement à 23 °C</b>			
MD	ISO-1926	%	300-560
CMD	ISO-1926	%	330-610
<b>Stiffness / Steifheit / Rigidité</b>			
At compression of 25% / Bei 25 % Stauchung / Pour une déformation sous pression de 25 %	ISO-3386-1	kPa	100-180
At compression of 40% /Bei 40% Stauchung / Pour une déformation sous pression de 50 %	ISO-3386-1	kPa	140-260
At compression of 50% /Bei 50% Stauchung / Pour une déformation sous pression de 50 %	ISO-3386-1	kPa	200-360
<b>Compression set / Kompressionssatz / Taux de compression</b>			
Compression 25%, 1/2h after discharge / Stauchung 25%, 1/2h nach Entlastung / Déformation sous pression de 25 %, 1/2 heures après la décharge	ISO-1856-C	%	7-13
Compression 25%, 24h after discharge/ Stauchung 25%, 24h nach Entlastung / Déformation sous pression de 25 %, 24 heures après la décharge	ISO-1856-C	%	1,7-3,1

**WS Polyolefin foam 12214  
WS Polyolefin-Schaum 12214  
WS Mousse polyoléfine 12214**

Properties / Eigenschaft / Propriété	Standard / Norm / Norme	Unit / Einheit / Unité	Data / Wert / Valeur
<b>Material / Material / Matériau</b>			
Density / Dichte / Densité	ISO-845	kg/m <sup>3</sup>	143
<b>Tensile strength at 23 ° C / Zugfestigkeit bei 23°C / Résistance à la traction à 23 °C</b>			
Longitudinal direction, at break / Längsrichtung, bei Bruch / Sens longitudinal, à la rupture	ISO-1926	kPa	2000-3200
Transverse direction, at break / Querrichtung, bei Bruch / Sens transversal, à la rupture	ISO-1926	kPa	1500-2500
<b>Elongation at 23 ° C / Dehnung bei 23°C / Allongement à 23 °C</b>			
MD	ISO-1926	%	300-560
CMD	ISO-1926	%	330-610
<b>Stiffness / Steifheit / Rigidité</b>			
At compression of 25% / Bei 25 % Stauchung / Pour une déformation sous pression de 25 %	ISO-3386-1	kPa	100-180
At compression of 40% / Bei 40 % Stauchung / Pour une déformation sous pression de 40 %	ISO-3386-1	kPa	140-260
At compression of 50% / Bei 50% Stauchung / Pour une déformation sous pression de 50 %	ISO-3386-1	kPa	200-360
<b>Compression set / Kompressionssatz / Taux de compression</b>			
Compression 25%, 1/2h after discharge / Stauchung 25%, 1/2h nach Entlastung / Déformation sous pression de 25 %, 1/2 heures après la décharge	ISO-1856-C	%	7-13
Compression 25%, 24h after discharge / Stauchung 25%, 24h nach Entlastung / Déformation sous pression de 25 %, 24 heures après la décharge	ISO-1856-C	%	1,7-3,1

**Technical data sheet /  
Technisches Datenblatt /  
Fiche technique**



**WS Polyurethane 45109  
WS Polyurethan 45109  
WS Polyuréthane 45109**

Properties / Eigenschaft / Propriété	Standard / Norm / Norme	Unit / Einheit / Unité	Data / Wert / Valeur
<b>Material / Material / Matériau</b>			
Composition / Zusammensetzung / Composition			Polyester polyurethane
Thickness / Dicke / Épaisseur		μ	180 - 220
Colour / Farbe / Couleur			Black / Schwarz / Noir
Hardness / Härte / Dureté	ASTM D2240	Sh.A	80,75 - 89,25
<b>Elongation / Dehnung / Allongement</b>			
at 100%	ISO 37	N/mm <sup>2</sup>	3,6 – 4,4
at 300%	ISO 37	N/mm <sup>2</sup>	6,75 – 8,25
<b>Breaking load / Bruchlast / Charge de rupture</b>			
	ISO 37	N/mm <sup>2</sup>	36 - 44
<b>Elongation at break / Bruchdehnung / Allongement à la rupture</b>			
	ISO 37	%	371 - 689
<b>Tensile strenght / Zugfestigkeit / Résistance à la traction</b>			
	ISO 6383/1	N	50 - 110
<b>Melting point / Schmelzpunkt / Point de fusion</b>			
	ASTM D3417	°C	135 - 155
<b>Storage temperature / Lagertemperatur / Température de conservation</b>			
		°C	- 20 to + 40



**WS butyl sealing compound 70240  
WS Butyldichtmasse 70240  
WS Masse d'étanchéité à base de butyle 70240**

Properties / Eigenschaften / Propriétés	Standard / Norm / Norme	Unit / Einheit / Unité	Data / Daten / Données
<b>General / Allgemein / Généralités</b>			
Compound Type / Colour Mischung Typ / Farbe Type de mélange / Couleur			Double-Sided Butyl Rubber Adhesive / gray Doppelseitiger Butylkautschuk-Kleber / grau Colle double-face à base de caoutchouc butyle / gris
Standard Thicknesses Standard-Dicken Épaisseurs standard		mm	0,5 / 0,8
Solids Feststoffe Solides		%	100
180° Peel Adhesion 180° Peel-Haftung Résistance au pelage à 180° 180° Peel Adhesion @ 5°C on concrete 180° Schälfestigkeit bei 5°C auf Beton Résistance au pelage à 180° sur du béton à 5 °C	ASTM D 1000	N/cm	20
Probe Tack Klebetest Test d'adhérence	ASTM D 2979	N	8
Vertical Flow Vertikaler Fluss Flux vertical	ISO 7390	mm	0
Application Temperature Range Anwendungstemperaturbereich h Plage de température pour l'application		°C	0 / + 40
Service Temperature Range Betriebstemperaturbereich Plage de température pour l'utilisation		°C	- 30 / + 90



**WS butyl sealing compound 70240**  
**WS Butyldichtmasse 70240**  
**WS Masse d'étanchéité à base de butyle 70240**

**Storage / Lagerung /  
Stockage**

The quality and the characteristics of the materials remain unaltered for a long period of time.  
However, it is recommended to use the product within 12 months from production date.  
The product must be stored in the original and unopened packaging in a dry and well ventilated place at a temperature between + 5 °C and + 40 °C. Storage above 50 °C may lead to difficulties in removing the release liner when applying.  
The product is not affected by frost.

Die Qualität und die Eigenschaften der Materialien bleiben über einen langen Zeitraum hinweg unverändert.  
Es wird jedoch empfohlen, das Produkt innerhalb von 12 Monaten ab Produktionsdatum zu verwenden.  
Das Produkt muss in der originalen und ungeöffneten Verpackung  
an einem trockenen und gut belüfteten Ort bei einer Temperatur zwischen + 5 °C und + 40 °C gelagert werden.  
Eine Lagerung bei über 50 °C kann zu Schwierigkeiten beim Entfernen der Trennfolie bei der Verarbeitung führen.  
Das Produkt ist frostunempfindlich.

La qualité et les propriétés des matériaux restent inchangées pendant une période prolongée.  
Il est cependant recommandé d'utiliser le produit dans les 12 mois suivant la date de production.  
Le produit doit être conservé dans son emballage d'origine fermé  
dans un endroit sec et bien aéré à une température comprise entre +5 et +40 °C.  
Un stockage au-delà de 50 °C peut entraîner des difficultés au moment de retirer le film de protection lors de la pose.  
Le produit est insensible au gel.

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**Technical data sheet /  
Technisches Datenblatt /  
Fiche technique**



**WS PP Fleece 25085  
WS PP Vlies 25085  
WS PP Tissé 25085**

Properties / Eigenschaft / Propriété	Standard / Norm / Norme	Unit / Einheit / Unité	Data / Wert / Valeur
<b>General information / Allgemeine Informations / Informations générales</b>			
Material / Material / Matériau			PP-Vlies / PP tissé
Color/ Farbe / Couleur			White / Weiß / Blanc
Weight/ Gewicht / Poids			60
Thickness / Dicke / Densité	DIN EN 29073-1	g/m <sup>2</sup>	
		mm	0,2
<b>Tearing force / Reißkraft / Résistance à la rupture</b>			
MD	DIN EN 29073-3	N/5cm	145
CMD			110
<b>Elongation / Längenveränderung / Allongement</b>			
MD			75
CMD	DIN EN 29073-3	%	90

**Technical data sheet /  
Technisches Datenblatt /  
Fiche technique**



**WS Synthetic rubber adhesive 17024  
WS Synthesekautschukkleber 17024  
WS Colle à base de caoutchouc synthétique 17024**

Properties / Eigenschaft / Propriété	Standard / Norm / Norme	Unit / Einheit / Unité	Data / Wert / Valeur
<b>General / Allgemein / Généralités</b>			
Adhesive / Kleber / Colle			Hotmelt made of synthetic Rubber /Hotmelt Kleber auf Synthesekautschukbasis / Colle thermofusible à base de caoutchouc synthétique
Thickness / Dicke / Épaisseur		mm	0,11 - 0,13
Adhesive carrier / Trägersystem / Support			Foil, transparent / Folie / Film
Covering material / Abdeckliner / Protection			Silicone paper, white / Siliconpapier, weiß / Papier siliconé blanc
<b>Peel resistance / Schälfestigkeit / Résistance au pelage</b>			
	DIN EN 1939*	N/mm	> 30 N/ 25
<b>Shear resistance / Scherwiderstand / Résistance au cisaillement</b>			
	DIN EN 1943*	g/mm <sup>2</sup>	1 000 / 625
<b>Temperature resistance / Temperaturbeständigkeit / stance à la température</b>			
		°C	- 30 to + 80
<b>Recommended processing temperature / empfohlene Verarbeitungstemperature / Température de mise en œuvre conseillée</b>			
		°C	+ 10 to + 30
<b>Condensation resistance / Kondenswasserwiderstand / Résistance à la condensation</b>			
			Very high / Sehr hoch / Très
<b>Aging resistance / Alterungsbeständigkeit / Résistance au vieillissement</b>			
			Restricted / Begrenzt / Limitée
<b>Plasticizer resistance / Weichmacherbeständigkeit / Résistance aux plastifiants</b>			
			Restricted / Begrenzt / Limitée
<b>Adhesive Properties / Klebeeigenschaften / Propriétés adhésives</b>			
			Aggressively adhesive / Aggressiv klebend / Extrêmement adhésif

**WS Synthetic rubber adhesive 17035  
WS Synthesekautschukkleber 17035  
WS Colle à base de caoutchouc synthétique 17035**

Properties / Eigenschaft / Propriété	Standard / Norm / Norme	Unit / Einheit / Unité	Data / Wert / Valeur
<b>General information / Allgemeine Informations / Informations générales</b>			
Composition / Zusammensetzung / Composition			Polyolefine
Standard colour / Standard farbe / Couleur standard			transparent, white or black / Weiß oder Schwarz / transparent, blanc ou noir
Thickness / Dicke / Épaisseur		µm	6158
Weight / Gewicht / Poids	ISO 12127	ISO 12127	
<b>Physical data / Physikalische Daten / Caractéristiques physiques</b>			
Melting range / Schmelzbereich / Plage de fusion	ISO 11357	°C	72-82
Softening point / Erweichungspunkt / Point de ramolissement		°C	70
Viscosity / Viskosität / Viscosité		cc/10min	3-18
Strength at break/ Bruchfestigkeit / Résistance à la rupture		Mpa	9,2
Elongation at break / Bruchdehnung / Allongement à la rupture		%	496,7
<b>Storage condition / Lagerbedingungen / Conditions de conservation</b>			
Shelf life	>0°C -<40°C lagern. Trocken keine kein direktes Sonnenlicht. 12 Monate unter geeigneten Lagerbedingungen.  Conserver entre > 0 °C et < 40 °C dans un endroit sec, à l'abri des rayons directs du soleil. 12 mois dans des conditions de conservation adéquates.		Do not store below 0°C or above 40°C. Store in a dry place away from direct sunlight. 12 months after delivery under appropriate storage conditions and into ist original packaging.

**WS Synthetic rubber adhesive 17038  
WS Synthesekautschukkleber 17038  
WS Colle à base de caoutchouc synthétique 17038**

Properties / Eigenschaft / Propriété	Standard / Norm / Norme	Unit / Einheit / Unité	Data / Wert / Valeur
<b>General information / Allgemeine Informationen / Informations générales</b>			
Adhesive system / Klebesystem / Système adhésif			Hot melt
Thickness / Dicke / Épaisseur		mm	0,09 – 0,11
Adhesive carrier / Klebeträger / Support adhésif			no carrier / kein Träger / aucun support
Liner / Abdeckung / Protection			silicone-coated film, white Silikonbeschichtete Folie, weiß / film siliconé blanc
<b>Peel resistance / Schälfestigkeit / Résistance au pelage</b>			
	DIN EN 1939	N/25mm	> 30
<b>Shear resistance / Scherfestigkeit / Résistance au cisaillement</b>			
	DIN EN 1943	g/625mm <sup>2</sup>	500
<b>Temperature resistance / Hitzebeständig / Résistance à la chaleur</b>			
		°C	- 30 - + 80
<b>Recommended processing temperature / Empfohlene Verarbeitungstemperatur / Température de mise en œuvre conseillée</b>			
		°C	+ 10 - + 30
<b>Condensation water / Kondenswasserwiderstand / Résistance à la condensation</b>			
			very high sehr hoch / très élevée
<b>Aging resistance / Alterungsbeständigkeit / Résistance au vieillissement</b>			
			Limited Begrenzt / Limitée
<b>Plasticizer resistance / Weichmacherbeständigkeit / Résistance aux plastifiants</b>			
			Limited Begrenzt / Limitée
<b>Application area / Domaine d'utilisation</b>			
Major applications for this transfer tape without carrier are laminating and bonding of materials. Examples: metal, wood, foams, plastics, paper or cardboard. Hauptanwendungen für dieses Transferband ohne Träger sind das Kaschieren und Verkleben von Materialien. Beispiele: Metall, Holz, Schaumstoffe, Kunststoffe, Papier oder Karton. Les principales applications pour ces bandes de transfert sans support sont le masquage et le collage de matériaux. Exemples : métal, bois, mousses, plastiques, papier ou carton.			

## Applications:

The WS spray primer is used as a spray primer, e.g. for improving the adhesion of adhesive tapes on absorbent substrates such as masonry, concrete, plaster, wood etc.. Always test WS spray primer to check suitability for your particular application before using the product in your production. Surfaces must be free of dirt, dust and grease, as is usual with all adhesives. Use non-greasy solvents for cleaning.

## Advantages

- Easy to use
- Immediate liability
- Short flash off time
- High yield

## Specification

- Type: Spray Primer
- Basis: Synthetic polymer
- Does not contain dichloromethane
- Open time: approx. 30 minutes, depending on temperature and air humidity
- Flash-off time: 3-5 minutes, depending on temperature and air humidity
- Cover area: approx. 12-13 m<sup>2</sup>/kg
- Container size: 22 litre & 500ml spray can
- Colour: green
- Storage time: 15 months unopened

## Handling | Storage | Disposal

- Observe safety data sheet before use
- Optimum bonding results at +18 °C of Primer, environment and substrate
- Application temperature: min. +10 °C / max. 40 °C
- Do not store the container and hose on a concrete floor during application, as the cold affects the behaviour of the Primer.
- Do not store above +50 °C and do not expose to direct sunlight
- After connecting always keep valve open and hose under pressure
- Depressurise the hose before disconnecting it.
- Connect the hose to the new container immediately to prevent the Primer from drying out.
- Dispose of or recycle only completely empty containers according to local regulations.
- After the container has been emptied, open the valve completely; open the pre-punched pressure release opening on the depressurised container with a non-sparking tool so that any Primer residue dries out.

## Instructions for use

1. For professional use only. It is the responsibility of the user to test the Primer suitability before each application. Prepare the surfaces to be bonded and ensure that both contact surfaces are clean and free of dust and grease. If necessary, wipe clean with a good, non-greasy solution cleaner, e.g. acetone. When applying, the materials, the environment and the Primer should have a minimum temperature of 10°C.
2. To obtain a uniform spray pattern, open the spray gun only until a spray jet width of approx. 10-15 cm is achieved at a distance of 10-15 cm from the surface. At this distance from the surface, apply the Primer quickly at a constant speed without any swivelling. A uniform thread-like Primer wetting is formed. Release the lever briefly each time you change direction. The Primer should not form puddles or be wet. 80-100% Primer coverage must be achieved.

3. Optimum bonding is achieved when the surfaces to be bonded are sprayed at a 90° angle to each other, i.e. one surface in a vertical position and the other surface in a horizontal position. In the edge area or in places where tension occurs, apply Primer twice to ensure 100% coverage. Press down particularly well in this area to ensure optimum adhesive strength. The recommended application rate is approx. 75 g/m<sup>2</sup> per side.
4. When bonding absorbent materials, seal with a thin layer of Primer, allow to flash off and then apply the actual Primer. This ensures that enough Primer remains on the surface.
5. Allow the Primer to flash off (times may vary depending on humidity and temperature). Check the state of drying with the back of your hand: The surface should be tacky, but the Primer should not transfer to the skin. Remove accidentally sprayed puddles of Primer by spreading them out to avoid solvent entrapment.
6. Position the substrates correctly and press them together with adequate pressure.
  - a. Note: Once contact has been made, the Primer parts cannot be repositioned.

Checking the Primer strength by loosening one corner will result in permanent Primer deterioration at that point.

The information in our data sheet is given to the best of our knowledge, based on the results of practical experience and tests carried out. However, they are non-binding and do not constitute an assurance of properties in the sense of BGH jurisdiction. Due to the versatile application possibilities of our products, we recommend a thorough suitability test of the product on original materials before it is released for production. Our application technology department will be happy to advise you on this. All our products are subjected to strict quality control.

