

Adhesive bonding to materials with low surface energy, i.e. the Omnia Panel should only be done by suitably qualified personnel.

The following table shows a selection of possible adhesive systems:

Strength	Application	Manufacturer	System*	Processing	Remarks
+	Strips, Profiles	SABA	Cleaner 48 Primer 4518 Sabatack 750 / 780	1-component-gun / 1-component application system	Cured after 1 week (humidify surroundings!). Application temperature +15 to +30 °C
+	Small parts Profiles	3M	Hotmelt: 3764 TC or 3748 TC	Hotmelt gun	Tempering base materials possibly necessary before bonding.
++	Small parts Profiles	3M	DP8005	2-component application system	Fully cured after 1-2 days. Application temperature +10 to +30 °C
++	Small parts	Sichel	Power Primer Superglue 99	Low viscosity: manual application	Fully cured after 1-2 days. Application temperature +10 to +30 °C

*: Surfaces to be bonded have to be clean and free of grease/oil, even if no cleaner is specified.

The "Remarks" column shows values from our experience; however it gives no guaranteed product properties. Please follow the instructions provided by the adhesive manufacturer in all cases.

The SABA adhesive system has proved to be especially suitable for transport applications. For this system the processing information is:

Process steps: Bonding details:

- | | |
|---|---|
| 1. Clean with SABA cleaner 48 | Before applying the adhesive be sure to humidify the surroundings, providing moisture for the adhesive to cure |
| 2. Prepare with surface primer SABA 4518 | Do not wet the bonding surfaces |
| 3. Bond with adhesive SABA Sealack 750 or 780 | <ul style="list-style-type: none"> - Apply adhesive - Wait 2-3 minutes for the adhesive to absorb the moisture - Join parts - Leave to cure (~3 days) |

Bonding after surface treatment

Surface treatments are very useful and effective as preparation for bonding, e.g. plasma or corona treatment and flaming. For smaller parts fluorination is also very good.

Please seek advice from companies providing these services or machinery concerning the mentioned surface treatments.

Bonding to a painted surface

Bonding to pre-painted Omnia panel is less critical than on unpainted. The paint with adhesion promoter already provides the necessary adhesion to the low surface energy material. However it is of utmost importance to use adhesive systems that are compatible with the paint system. The following list shows our selection of possible adhesives.

In case of 1-component adhesive please verify that the adhesive can cure (necessary access of humidity and air). In case of doubt please use a 2-component-adhesive system.

Strength	Application	Manufacturer	System*	Processing	Remarks
+	Strips, Profiles	Sika	Activator Sikaflex 252	1-component-gun / 1-component application system	Cured after 1-2 weeks (not critical when rivets are used in addition) Application temperature +10 to +30 °C
+	Strips, Profiles	Sika	Activator Sikaflex 254+Booster	2-component application system	Cured after approx. 2 days Application temperature +10 to +30 °C
+	Strips, Profiles	Kommerling	Korabond HG 81 Korapop 225	1-component-gun / 1-component application system	Cured after approx. 2 days Application temperature +10 to 30 °C
+	Strips Profiles	Kommerling	Korabond HG 81 Korapop 225 / 2K	MIXPAC -2KPneumat Gun or 2-component application system	Fully cured after 1 week (not critical when rivets are used in addition) Application temperature +5 to +30 °C
+	Strips Profiles	SABA	Sealtack 750 or 780	1-component-gun / 1-component application system	Cured after approx. 2 days Application temperature +10 to +30 °C

The above information details our experience with the adhesion systems; however please follow the applicable instructions provided by the adhesive manufacturer in all cases.

Further information on the adhesive manufacturers can be found on following Internet addresses:

www.saba.nl or their dealer in the UK:

www.chemique.co.uk

www.3m.com

www.sika.co.uk

www.titgemeyer.de

www.sichel.de

www.koe-chemie.de

For applications, treatment and storage please pay attention to the manufacturers' technical data sheets.

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