

## Direct bonding to MonoPan® with untreated/unpainted surface

Adhesive bonding to materials with low surface energy, like MonoPan® should only be done by properly trained personnel.

Following table shows a selection of possible adhesive systems:

Strength	Application	Manufacturer	System*	Processing	Remarks
+	Strips / Profiles	SABA	Cleaner 48 Primer 4518 Sealtack 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	Cured after cooling down. Tempering base materials possible necessary before bonding.
++	Small parts / Profiles	3M	DP8005 or DP8010	2-component-application system	Cured after 1-2 days Verarbeitungstemperatur +10 bis +30 °C
++	Small parts	Sichel	PowerPrimer Superglue 99	Low viscosity: manual application	Belastbar nach ca. 1-2 Tagen 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 column Remarks shows values from our experience, however gives no secure product properties and are without guarantee from WIHAG. Please follow the instructions provided by the adhesive manufacturer in all cases.

The SABA adhesive system has proved to be especially suitable for trucking applications. For this system the process information is given below:

### Process steps:

1. Clean with SABA cleaner 48
2. Prepare with surface primer with: SABA 4518
3. Bond with adhesive: SABA Sealtack 750 or 780

### Bonding details:

- Before applying the adhesive be sure to humidify the surrounding providing moisture for the adhesive to cure. Do not wet the bonding surfaces
- Apply adhesive
- Wait 2-3 Minute for adhesive taking up the Moisture
- Join parts.
- let cure (~3 days)

## Bonding after surface treatment

Surface treatments are very useful make effective preparations for bonding, e.g. Plasma-, Corona-treatment and flaming. For smaller parts fluorination is also very good.

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

## Bonding to a painted surface

Bonding to pre-painted MonoPan® is less critical than on unpainted. The Paint system with adhesion promotor 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 note, 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 (uncritical when rivets are use additionally) Application temperature +10 to +30 °C Cured after ca. 2 days Application temperature +10 to +30 °C
+	Strips / Profiles	Sika	Activator Sikaflex 254+Booster	2-component-application system	Cured after 1-2 weeks (uncritical when rivets are use additionally) Application temperature +10 to +30 °C Cured after ca. 2 days Application temperature +10 to +30 °C
+	Strips / Profiles	Kömmerling	Körabond HG 81 Körapop 225	1-component-gun / 1-component-application system	Fully cured after 1 week (uncritical when rivets are use additionally) Application temperature +5 to +30 °C
+	Strips / Profiles	Kömmerling	Körabond HG 81 Körapop 225 / 2K	MIXPAC®-2K- Pneumat gun or 2-component-application system	Cured after ca. 2 days Application temperature +10 to +30 °C
+	Strips / Profiles	SABA	Sealtack 750 oder 780	1-component-gun / 1-component-application system	Cured after 1 week (humidify surroundings!) Application temperature +15 to +30 °C

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

Die Angaben unter Hinweise können nur erste Erfahrungswerte vermitteln. Maßgeblich sind ausschließlich die Verarbeitungshinweise der Hersteller. Please follow the 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](http://www.saba.nl)  
[www.mmm.de](http://www.mmm.de)  
[www.sichel.de](http://www.sichel.de)  
[www.sika.de](http://www.sika.de)  
[www.titgemeyer.de](http://www.titgemeyer.de)  
[www.koe-chemie.de](http://www.koe-chemie.de)

For applications, treatment and storage please pay attention to the „Technical Data Sheet“ of the manufacturer.

The specifications in this data sheet represent the current state of our technical knowledge and its purpose is to inform about MonoPan® and its applications. The specifications therefore do not guarantee particular properties or suitability for a specific application. We reserve the right to make changes in accordance with technological processes and other developments. We guarantee faultless quality in accordance with our conditions of sale.