



BONDING RECOMMENDATIONS FOR SEAL & BOND MS50-2K

The following are recommendations only please always refer to the manufacturers data and instructions at <http://www.novatio.be/en>

1. Use a mild abrasive such as a "Scotch Brite" pad to slightly roughen the painted bonding surface area.
2. "Safety Clean" (solvent based) <http://www.novatio.be/en/product/safety-clean> to be applied first. This will remove any oils or grease. Make sure that there is no skin contact with the bonding surface.
3. Next apply "Multifoam" <http://www.novatio.be/en/product/multifoam> (Water based). This will remove any residue including human residue (finger prints, breath). For step 2 and 3 use only clean lint free paper towels. Wipe surface area in one direction only to ensure no residue is wiped back onto surface. Use paper towel only once and then discard. Make sure that there is no skin contact with the bonding surface.
4. Re-apply "Multifoam" to check that there is no grease (residue) left and clean off. If any grease is found than the you will need to repeat the cleaning process from the start with "Safety Clean" first. Make sure that there is no skin contact with the bonding surface.
5. Apply "High-Tech-Tape" <http://www.novatio.be/en/product/high-tech-tape> for positioning and creating adequate space for the bonding material. Position the tape on two outside perimeter lines. Make sure that there is no skin contact with the bonding surface.
6. Apply "Seal & Bond MS50 2-K" <http://www.novatio.be/en/product/seal-bond-ms-50-2-K>. Apply in a zigzag pattern as illustrated in photo below. *
7. Do not wait more than 4 minutes before applying parts. There is a danger that the bonding material starts to cure on the surface and the bonding will fail.
8. Check the manufacturers data sheet for curing times <http://www.novatio.be/en/product/seal-bond-ms-50-2-k>

Extract from the Novatio "Seal & Bond MS50 2-K" technical data sheet for the bonding surface area calculation ;

Tensile Strength : 210 N cm²

Tear strength : > 73 N cm² DIN 53507

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Further important notes:

It is highly recommended to produce a bonding test sample or prototype installation before proceeding. We suggest to consult a locally certified engineer for the calculation & specification of the required bonding surface area in accordance with the selected manufacturers bonding product technical data.

Bonding to a paint mask for tempered/toughened glass

Ceramic ink or also called glass ceramic frit is the preferred surface to bond to. Ceramic inks are highly durable coatings fired into the glass during the heat tempering process.

- Requires high temperature “firing” to fuse them to the glass/ceramic surface
- Very durable, excellent abrasion and chemical resistance

Bonding to a paint mask for annealed float glass

It is possible to bond to a automotive type paint surface. However it is critical that this process is executed correctly to avoid negative results.

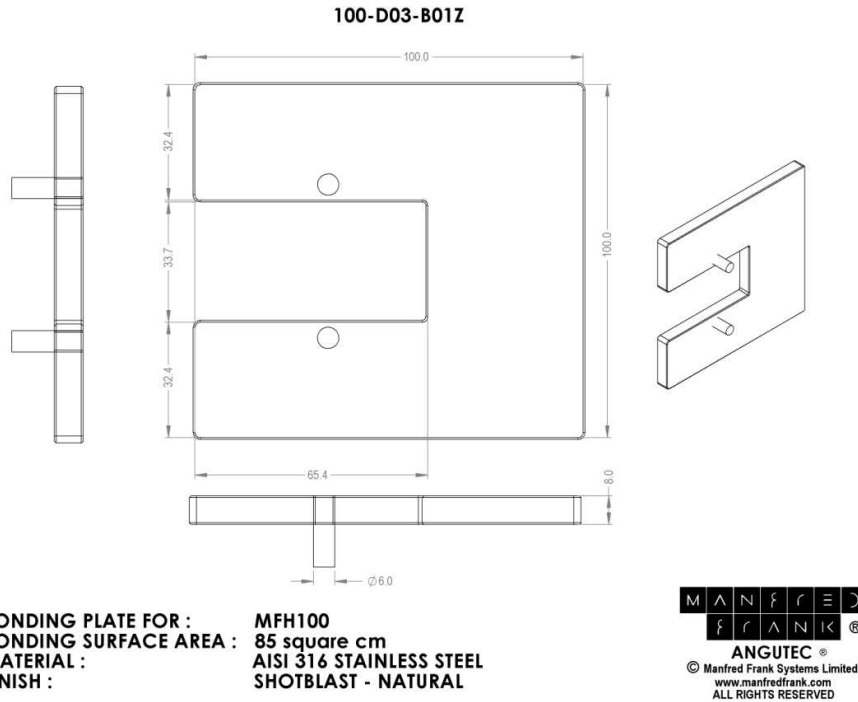
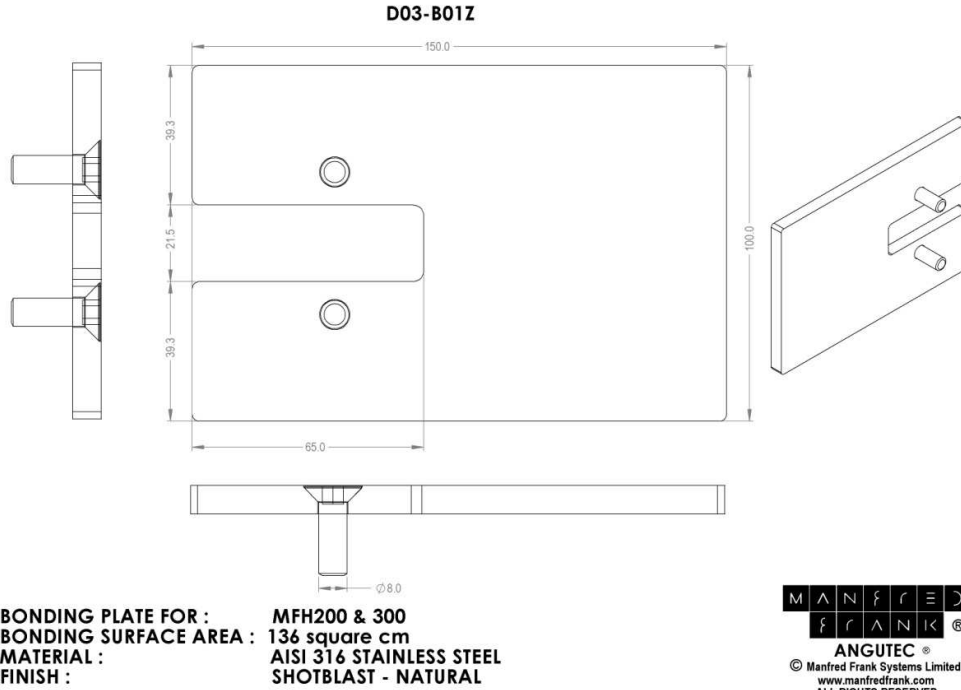
- Automotive paint (2 component) e.g. Hesse paint
- Low baked at 65 degree average
- Sample glass has to be painted at every run
- Paint adhesion test on each colour painted
- Adhesion can vary on different colours (pigments)
- Comply to curing time before bonding
- Cleaning of surfaces is most crucial before applying adhesive



High-Tech-Tape is visible with the red lines.



Standard bonding plate details can be found at <http://manfredfrank.com/documentation/> as well as below.



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