

THE FOLLOWING ARE RECOMMENDATIONS ONLY.  
PLEASE ALWAYS REFER TO THE MANUFACTURERS DATA AND INSTRUCTIONS AT  
<https://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) <https://www.novatio.be/en/product/safety-clean> to be applied first. This will remove any oil or grease. Make sure there is no skin contact with the bonding surface.
3. Next, apply "Multifoam" <https://www.novatio.be/en/product/multifoam> (water based). This will remove any residue including finger prints or breath.
  - For steps 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 the surface. Use paper towel once and then discard. Make sure there is no skin contact with the bonding surface.
4. Re-apply "Multifoam" to check there is no grease residue left and clean off. If any grease is found then you will need to repeat the cleaning process from the start with "Safety Clean" first.
5. Apply "High Tech Tape" <https://www.novatio.be/en/products/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 MS 50 2-K" <https://www.novatio.be/en/products/seal-bond-ms50-2-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 <https://api.novatech.be/files/13948.pdf> for curing times.





#### FURTHER IMPORTANT NOTES:

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

##### Bonding to a paint mask for tempered/toughened glass:

Ceramic ink aka 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 an automotive type paint surface, however it is critical that this process is executed correctly:

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

##### Manfred Frank Bonding plates

For full information on MFH bonding plates please visit:

<https://manfredfrank.com/documentation/> - under "Drilling / Bonding / Routing Details & Templates"

#### DISCLAIMER OF LIABILITY:

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