

Recommendations for the use of insulation materials with adhesives (Kerafix 2000® Classic, Kerafix® Flexlit)

Insulation materials with a **one-sided adhesive** allow a more rapid, clean and economic installation as compared to other fixing systems. Please read the following recommendations carefully and take advantage of this system.

Condition of the surface

Surface must be dry and free from dust, oil, fat, oxides, release agents and other contaminations. Avoid moisture on the surface as caused by condensation on cold materials in warm surroundings. Best bonding results on closed surfaces.

Cleaning of the surface

For cleaning the surface use clean and lint-free one-way cloths only. When using solvents such as benzine, alcohol, ester or ketones make sure they do not leave residues on the surface or do not affect it. When using solvents, safety instructions of the manufacturer must be observed. Do not touch the surface. After cleaning allow some time for vaporization of the solvents and then put elements together quickly in order to avoid new contamination (dust/finger prints).

Notice: During vaporization, solvents tend to withdraw warmth from the surroundings so that the workpiece cools down. Thus, condensation might occur so that bonding should be started only after the material had regained surrounding temperature.

Mechanical cleaning of the surface

If solvents do not work, surface should be slightly grinded as for oxides, release agents or powder coated surfaces. Clean surfaces after grinding. Check solvent tolerance of varnish and plastic.

Critical Surfaces

Critical surfaces are polyolefins, rubber, Teflon, silicones and powder coated materials. Also materials containing plasticisers are critical as they may change properties of the glue. Thus, detailed tests for critical surfaces are recommended.

Temperature

Best temperature for bonding is between 18 °C and 25 °C in dry rooms. Temperature of the material and the surroundings should be the same to avoid condensation. Avoid temperatures beneath 10 °C.

Notice: Low temperatures make glue too hard for bonding, high temperatures make it too soft.

Pressure

Adhesion of an adhesive is depending on the contact with the surface. Allow the surfaces to be pressed together.

Notice: Tools and hands must be free from release agents!

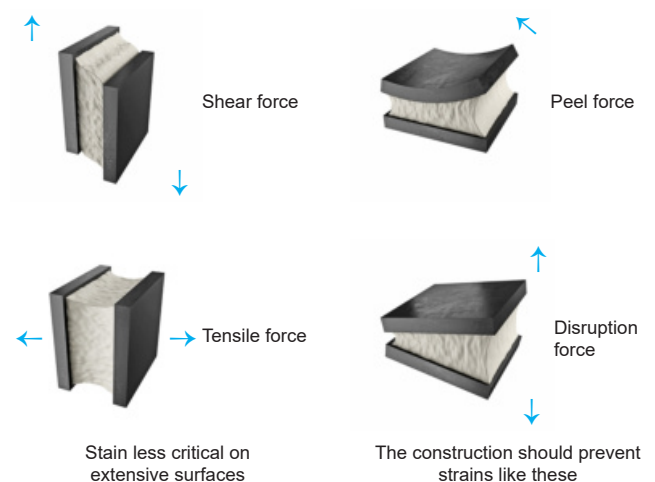
Final tack

Until full tack is reached allow 24 hours resting time. Pressure and warmth accelerate this process, as these conditions have a positive impact on the viscoelastic flow of the adhesives. Only then building components may be stored in the exterior, transported or strained.

Contact surface

Make sure that the complete adhesive is stuck on the contact surface. Avoid bonding the material onto corners, neither inner nor outer corners.

Notice: Continuous tension affects bonding. Bonded parts should be strained after 24 hours only.



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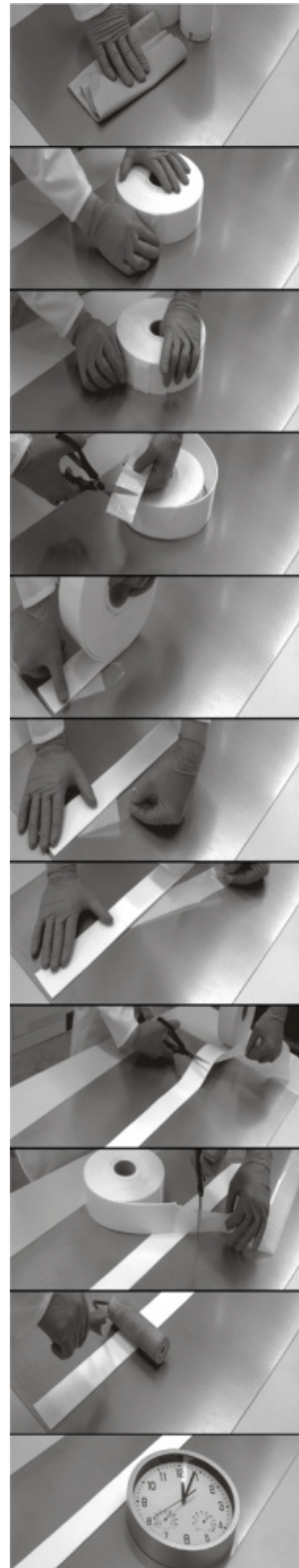
Finish of the strip material with one-sided adhesives

Avoid lifting off the liner and any contamination of the glue when cutting the material. Firstly cut the liner, then the glue and finally the building material.

Lift off the little part of cover strip in an acute angle (180 ° approximately) and afterwards use it to lift off the cover strip of the adhesive strip. At the beginning of each roll there is no glue applied to it. Lift off a bit of the cover strip and then cut off the beginning of the roll where there is no glue. Apply the beginning of the roll in its place and then carefully tear off

the cover strip in a flat, acute angle using a bit of pressure. When it's finished, cut the roll material leaving a bit of the cover strip which will be used as little cover part for the next application. Apply a bit of pressure with a pressure roller.

Notice: Avoid unnecessary strain (tension/buckling). Best tack is achieved after 24 hours.



1. Clean/dry
2. Lifting off the cover strip
3. Lifting off in an acute angle of 180 °
4. Remove the part with no adhesive
5. Adjustment
6. Tear off the cover strip
7. Application
8. Cut off without cutting the cover strip
9. Cover strip's beginning
10. Pressure
11. Waiting for final tack

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Storage

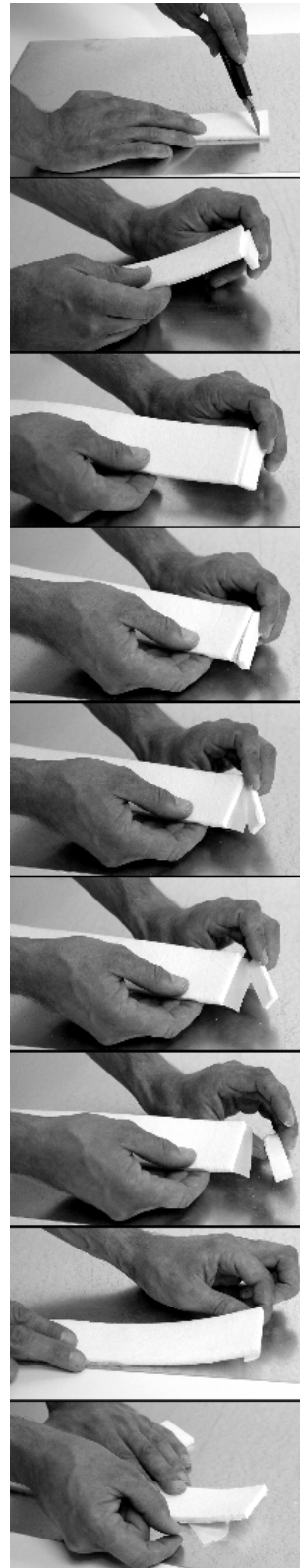
Insulation materials with one-sided adhesives should be stored in their original package at temperatures between 18 °C and 25 °C and humidity between 50 and 70 %. Keep away from direct sun light (ultraviolet light). Under these conditions, the material can be stored for 1 year approximately.

Strain

For the construction, any disruption strain and shear tension should be avoided. Shear and tensile strains must be diverted throughout the whole area. Avoid buckling and tension on the ends of both parts to be bonded.

How to regain bit of a cover strip

In case the whole strip material has been cut erroneously, tear off a bit of the cover strip on the edge and cut the insulation material to 2 cm approximately.



1. Cut through insulation material and glue

2. Bending

3. Control of the cut off part

4. Remove the cut-off piece

5. Removal

6. Cover strip still stuck in place

7. Complete cut-off

8. Bit of a cover strip

9. Continue as described