

Instructions for using 1039 (adhesive) + 1090 (activator)

General:

This two-component product, so-called "no-mix system" which is characterised by the fact that the adhesive and activator are applied separately – adhesive 1039 on one joining part and activator 1090 on the other – so that the components do not mix until the joining process. During the joining process, the adhesive and activator react.

Application:

1. Mark the opposite side of the mating surfaces where appropriate, clean them thoroughly (e.g. with metal cleaner 9190), dry them with a clean cloth or apply heat with a hot air gun to remove any moisture / cleaner, and allow joining parts to cool.
2. In the first step 1039 is applied over the entire surface, either directly from the bottle, with a brush, with a squeegee or a foam roller.
In the second step, the activator 1090 is applied to the other surface, either with a brush or with a foam roller, so that the surface is well wetted. The activator is solvent free and needs to be in a liquid state for the curing process and therefore must not be allowed to dry.
3. Immediately after both component surfaces have been wetted, the parts are joined and held in position for approx. 30 seconds by light pressing. After this time, the components are fixed and the components can be moved. The bond achieves 50% bond strength after 15 to 20 minutes.

Attention:

The mating surfaces must be flat. The adhesive does not have gap-filling properties.

Precautions:

For your own safety, please refer to the information of the concerned MSDS and for the correct handling the "technical datasheet".

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