

To ensure durable and reliable adhesion of our Noiseflex® PU / MH polyurethane and melamine resin soft foam with our Winflex TFS or acoustic adhesive, the following application instructions should be noted and adhered to.

Storage:

Store cool and dry between + 5 °C and + 25 °C in unopened original containers.

Minimum shelf life in unopened original container: 9 months from date of manufacture.

Store Noiseflex® MH formed parts in a dry place. Before application, store the formed parts for three, better still five, days in a standard climate or in the climate of the application. The reason behind this is the sorption properties of melamine resin. The dimensions of the parts will change as they absorb or adsorb moisture.

Planning:

Material consumption: Depending on the substrate, approx. 10 m per 600 ml flow pack, 8 mm nozzle diameter, may be taken as a guideline. With an adhesive layer thickness of 1 mm, approx. 1 l / m² is used, i.e. a 600 ml flow pack is enough for about 0.6 m² glued surface.

Substrate preparation:

The substrate surfaces to be glued must be firm, stable, free of dust, grease and oil and must be dry and free of ice and frost. Avoid wet surfaces and ensure that surfaces are clean and dust-free.

If necessary, adhesion tests may be carried out by gluing a piece of our Noiseflex® PU / MH using Winflex TFS or acoustic adhesive from the flow pack to a critical spot. Then allow the adhesive to dry (at least 24 hours) and pull the Noiseflex® PU / MH off again. If the adhesive separates from the substrate or pulls away, taking with it substrate residues, then normal gluing is not possible.

Greasy surfaces or surfaces with a release agent must be pre-cleaned with thinners / cleaner. The flash off time of the cleaning agents and surface compatibility must be taken into account.

All substrate materials must be compatible with our adhesives pursuant to DIN 52 452, Part 1. Adhesion and compatibility with plastics should be tested on the plastic itself. Compatibility should first be tested before using on coated surfaces (e.g. water-repellent substrates). Loss of adhesion may, for instance, be a problem due to migration of softeners in case of acrylic coating materials.

Substrates:

Adhesion is possible on concrete, gypsum, natural stone, aluminium, steel, zinc, copper, glass, wood, MDF, tiles, ceramics or on solid mineral substrates. It is important for the surfaces to be abrasion-resistant, with good adhesive properties.

Treated surfaces must be fully cured prior to adhesion. With powder coating, process additives (e.g. waxes) may be released after some time, causing adhesion to fail. In this case, own tests should be performed or the coating manufacturer consulted.

Loose surface material should be removed. Prime porous, strongly absorbent and friable substrates with a primer. Our Multi Primer can be used for Winflex TFS. For acoustic adhesive, we recommend priming with a mixture of the adhesive and 3 parts water. Stir this priming mixture well before use. Always observe flash off time of the primer!

Oxidised metals or rust are not suitable as substrate and must be removed. In the case of very uneven substrates, holes and cracks, it is advisable to level the substrate with an appropriate filler to achieve an attractive finished appearance of our Noiseflex® PU / MH.

Application:

The temperature must not be less than + 5 °C.

Tools: The following working materials are adequate for reliable and simple application: flow pack hand pressure gun, cotton gloves, carpet knife, various spatulas, toothed spatula (tooth at least 6x6 mm).

Application: Apply a bead of TFS or acoustic adhesive to the substrate using a flow pack gun and nozzle (nozzle dia. at least 8 mm). Using the toothed spatula, spread the adhesive beads evenly for a smooth finish.

Place the Noiseflex® PU / MH soft foam on the fresh adhesive bed and press down evenly, by hand. We recommend wearing clean cotton gloves to prevent soiling of our Noiseflex® PU / MH.

After pressing down our Noiseflex® PU / MH, the adhesive layer should be at least 1 mm thick and without air pockets. Use up opened adhesive containers as soon as possible.

Cleaning:

With Winflex TFS, use Fasatan® Cleaner / Thinner to remove residues of adhesive that has not yet hardened from the substrate. Fasatan® Cleaner / Thinner can also be used to degrease the adhesion surface – check for compatibility! With the Acoustic adhesive, water can be used to remove not yet hardened adhesive residues.

Once hardened, the adhesives can only be removed mechanically.

Please refer to our current Safety data sheet for further information. Please also observe the relevant Technical data sheets!

Attention! Important Note:

Above information are based on best present knowledge of current technology, but do not guarantee faultless processing of our products. The information is based on practical results of our tests, but is not binding and does not constitute warranties of characteristics in terms of Federal Supreme Court jurisdiction. Our information does not constitute a legally binding assurance of certain properties or suitability for a specific purpose. Supplementary information by our specialists are merely recommendations, for which no liability is accepted.

Due to the many possible applications of our products, we recommend subjecting the project to a thorough suitability test on original materials before release for further application.

Since our information are non-binding we do not warranty their correctness. For this reason we accept no liability for possible improper processing based on information submitted by our employees.

These processing guidelines supersede all previous versions and are valid only until the publication of a new version, or until Dec. 31, 2024. Please request the latest version after Jan. 01, 2025.

Dr. Hermann, Anwendungstechnik / Application Technology, Gingen / Fils