Paneltack

Bonding system

for STENI Colour, Vision & Nature panels

indoor application

Product advantages

- Reliable blind fixing method
- Simple and fast mounting
- Optimal tension distribution

Product

Paneltack is a moisture curing elastic adhesive based on SMP (Silyl Modified Polymer)

Paneltack is solvent- and iso-cyanate free.

Applications

Bonding of STENI panels in indoor applications on several substrates like plasterboard, concrete and wood.

Paneltack features

- Durable and highly elastic with an optimal tension distribution.
- Bonded STENI panels is, regarding reaction to fire classified as B, s1, d0.
- Suitable for the bonding of larger panels; including the standard sizes 2995 x 1195 mm.
- Excellent mechanical strength.
- Quick and easy mounting.
- Optimal pre-treatment of the STENI panels with the unique Easy Prep Wipes or Cleaner 14.
Bostik indoor bonding system

The bonding system consists of:

- Paneltack elastic adhesive.
- EasyPrep Wipes or Cleaner 14 for pre-treatment of the bonding side of STENI panels
- Foam tape 12 x 3 mm for the initial bonding of the panels and to guarantee a sufficient mass.

Table

<table>
<thead>
<tr>
<th>Consumption indication per 100 m²</th>
<th>Number of units</th>
<th>Standard packaging</th>
</tr>
</thead>
<tbody>
<tr>
<td>Foamtape</td>
<td>12</td>
<td>25 meter roll</td>
</tr>
<tr>
<td>Paneltack</td>
<td>15</td>
<td>600 ml soft</td>
</tr>
<tr>
<td>Easy Prep Wipes</td>
<td>30</td>
<td>sachets</td>
</tr>
<tr>
<td>or</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Cleaner 14</td>
<td>2</td>
<td>1000 ml tin</td>
</tr>
</tbody>
</table>

Length of adhesive bead per cartridge: approx. 6½ m.
Method of use

Conditions prior to bonding

Prevent warp of the panels due to the influence of moisture.

_The panels should be stored indoors in order to acclimatize to the room temperature._

Panels must be evenly flat prior to bonding. Not warped. In this aspect large panels are more critical than small panels, therefore extra care regarding correct handling and storage is inevitable.

Ventilation

Accumulation of moisture behind the panels must be avoided.

Therefore it is recommended to have small openings/slots at both the top and the bottom of the bonded panels to create an open ventilated cavity of minimum 3 mm.

Thus entrapped water can get away via drainage and evaporation.

A horizontal and vertical joint between the panels with a width of 3-5 mm is recommended.

If ventilation is not possible the construction should be such that no water can accumulate behind the panels and the walls should be fully dry prior to the bonding.

In some special assemblies, air circulation is not possible because the construction requires that it be sealed/joint to the lower edge of the panel. In these cases the construction should be such that no water can accumulate behind the panels and the walls should be fully dry prior to the bonding.

Max moisture contents

- Concrete 5%
- Plasterboard 12%
- Wood 18%

Application conditions:

- Avoid condensation on both the panels and support construction.
- Apply between +5°C and +30°C.

1. Pre-treatment support construction

All substrates should be dry, clean, dust- and grease free.
Remove loose dust from the surface with a suitable brush.
If temperature differences and/or water loads are involved Primer MSP on concrete and Primer SX Black on untreated wood is advised.
2. Pre-treatment panel

Use Easy Prep Wipes to clean and pre-treat the bonding side of the STENI panel. Rub the panel firmly with the wipes over the full length and in widths of min. 10-15cm (where the adhesive beads ought to be). These ready for use non-woven cloths are more user- and environmental friendly than the usual solvent containing primers and cleaners. As an alternative to the Easy Prep Wipes, Cleaner 14 can be used. Min. drying time for EPW’s and Cleaner 14 10 minutes.

3. Application of Foamtape

Maximum distances between the foamtape: 300 mm.

Foamtape is applied only vertically to the support construction without any interruption. Press Foamtape firmly onto the support construction and cut it with a sharp knife. When deciding on the correct position and length of the tape also bear in mind the dimensions and function of the supports, the dimensions of the panels and the necessary space for the adhesive. Do not immediately remove the protective layer after application of the Foamtape. (See step 5).

4. Application of adhesive with special nozzle

Apply Paneltack only vertically and without interruption at approx. 2 cm besides the Foamtape. Use a hand- or an air pressure caulking gun. A special V-shaped nozzle has been packed with every cartridge Paneltack. This enables to apply a triangular adhesive bead with a width and height of 9 mm. Using t is special nozzle prevents the enclosure of air bubbles and unnecessary loss of adhesive.

Opposite the V-cut one can cut the nozzle obliquely.

5. Placing the panel

Now remove the protective layer from the Foamtape. Apply the cladding panel within 10 minutes after the application of the Paneltack adhesive. Fix the panel by gently pressing it onto the adhesive beads and, if necessary, correct its position. Correction is still possible until the panel touches the Foamtape. For good and easier positioning of the panel eventually use a joint spacer, supporting blocks or horizontal supporting laths. For easier handling a glass suction clamp can be useful. Once the panel is positioned correctly, the panel must be pressed down by gently rubbing over the entire length of the Foamtape. Avoid that the foam tape is pressed together. Now it is no longer possible to correct the panel position. See the detail drawings.

6. Cleaning
Uncured adhesive residues can be removed with a suitable cleaner such as Liquid 1. Use a clean, lint free and pigment free cloth or tissue paper. Test on a small scale if the cleaner does not attack or contaminate the STENI panel.

7. Removal of the protective foil from the STENI panel front side

Immediately after bonding the protective foil on the front side of STENI panel must be removed.
## Technical data

### Paneltack

<table>
<thead>
<tr>
<th>Property</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Basic material</td>
<td>SMP (Silyl modified Polymer)</td>
</tr>
<tr>
<td>Components</td>
<td>1</td>
</tr>
<tr>
<td>Type</td>
<td>elastic</td>
</tr>
<tr>
<td>Consistency</td>
<td>smooth, homogeneous paste</td>
</tr>
<tr>
<td>Shear strength</td>
<td>1.1 N/mm² (KOMO-certificate)</td>
</tr>
<tr>
<td>Tensile strength</td>
<td>1.1 N/mm² (KOMO-certificate)</td>
</tr>
<tr>
<td>Max. permissible displacement</td>
<td>4.3 mm (KOMO-certificate)</td>
</tr>
<tr>
<td>Specific gravity</td>
<td>1.4 g/ml</td>
</tr>
<tr>
<td>Flow resistance 25 mm</td>
<td>0 mm (at 20°C)</td>
</tr>
<tr>
<td>Skin formation (start)</td>
<td>15 minutes (at 20°C/50%RH)</td>
</tr>
<tr>
<td>Temperature resistance</td>
<td>-40°C till +90°C</td>
</tr>
<tr>
<td>Application temperature</td>
<td>+5°C till +35°C</td>
</tr>
<tr>
<td>Packaging &amp; Article code</td>
<td>290 ml cartridges art. code 131.670</td>
</tr>
<tr>
<td></td>
<td>600 ml sausages art. code 133.692</td>
</tr>
<tr>
<td>Colour</td>
<td>light grey</td>
</tr>
<tr>
<td>Storage stability</td>
<td>store cool and dry between +5°C and +25°C.</td>
</tr>
<tr>
<td></td>
<td>Can be stored for at least 12 months in unopened packaging. See code at the top of the cartridge: B(est) B(efore) mm/yy.</td>
</tr>
</tbody>
</table>

### Foamtape

<table>
<thead>
<tr>
<th>Property</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Description</td>
<td>two-sided self adhesive foam tape with a protective layer on one side</td>
</tr>
<tr>
<td>Application</td>
<td>for initial bond of the panel and a spacer for a sufficient mass and thickness of the adhesive bead</td>
</tr>
<tr>
<td>Specific gravity approx.</td>
<td>60 kg per m³</td>
</tr>
<tr>
<td>Shear strength</td>
<td>approx. 0.27 N/mm²</td>
</tr>
<tr>
<td>Tensile strength</td>
<td>approx. 0.27 N/mm²</td>
</tr>
</tbody>
</table>
Packaging 25 metre roll

Application temperature +5°C till +30°C

Storage stability Store cool and dry between +5°C and +30°C. Can be stored for 12 months in unopened packaging.

Colour black

Article code 30182771

**Easy Prep Wipes**

Description User friendly special cloth, impregnated with a special liquid, suitable for the pre-treatment of the bonding side of the Steni panels

Min. drying time 10 minutes

Packaging small carton with 10 sachets

Application temperature +5°C till +30°C

Flash point approx. 61°C

Storage stability Store cool and dry between +5°C and +30°C.

Can be stored for 12 months in unopened container. See code on container bottom B(est) B(efore) mm/yy.

Article code 30024252

**Cleaner 14**

Application cleaner suitable for the pre-treatment of the bonding side of the STENI panels

Min. drying time 10 minutes

Packaging & Article code 1 litre tins 022.100

Application temperature +5°C till +30°C

Flash point < -4°C

Storage stability Store cool and dry in unopened packaging between +5°C and +30°C. Can be stored for at least 12 months in unopened packaging.

**Application set and rollers**

Primer SX Black can be applied with a special application set: velvet brush rollers with handle and paint tray. The rollers offer low consumption and an optimal pre-treatment.
Further information

The following publications are available on request:

- Reaction to fire report P 801429A - SP Technical Research Institute of Sweden.