

Instructions for using ergo.® 1451/ 1093 Structural Adhesive / Accelerator

General:

This two-component no-mix system consists of an adhesive and an accelerator, which are each applied separately to one of the two mating surfaces so that they combine only when the two parts are brought together. The product is specifically designed for glass/glass, glass/metal, metal/metal combinations and can be used to fasten interior rearview mirrors in cars or metal handles to glass doors.

Application:

1. Mark the opposite side of the mating surfaces where appropriate, clean them thoroughly, dry them with a clean cloth or apply heat with a hot air gun to remove any moisture, and allow the glass panel to cool.
2. Use the brush attached to the cap to spread a thick layer of the accelerator on one of the mating surfaces.
For glass/metal bonds, apply the accelerator to the glass panel.
The accelerator is solvent free and needs to be in a liquid state for the curing process and therefore must not be allowed to dry.
3. Tear off the retaining ring and open the bottle by twisting the cap; apply a thin and even layer of the adhesive to the metal surface or the other glass panel.
4. Press and hold the component loaded with adhesive against the accelerator-coated area of the glass panel by applying light finger pressure for about 20 seconds. Remove any excess adhesive immediately with a cloth (at the latest 40 seconds after the bonding procedure). The bond achieves 50% bond strength after 15 to 20 minutes.

Attention:

Do not apply to surfaces exposed to sunlight or to very hot glass surfaces due to the risk of tension cracks.

The mating surfaces must be flat.

The adhesive does not have gap-filling properties.

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