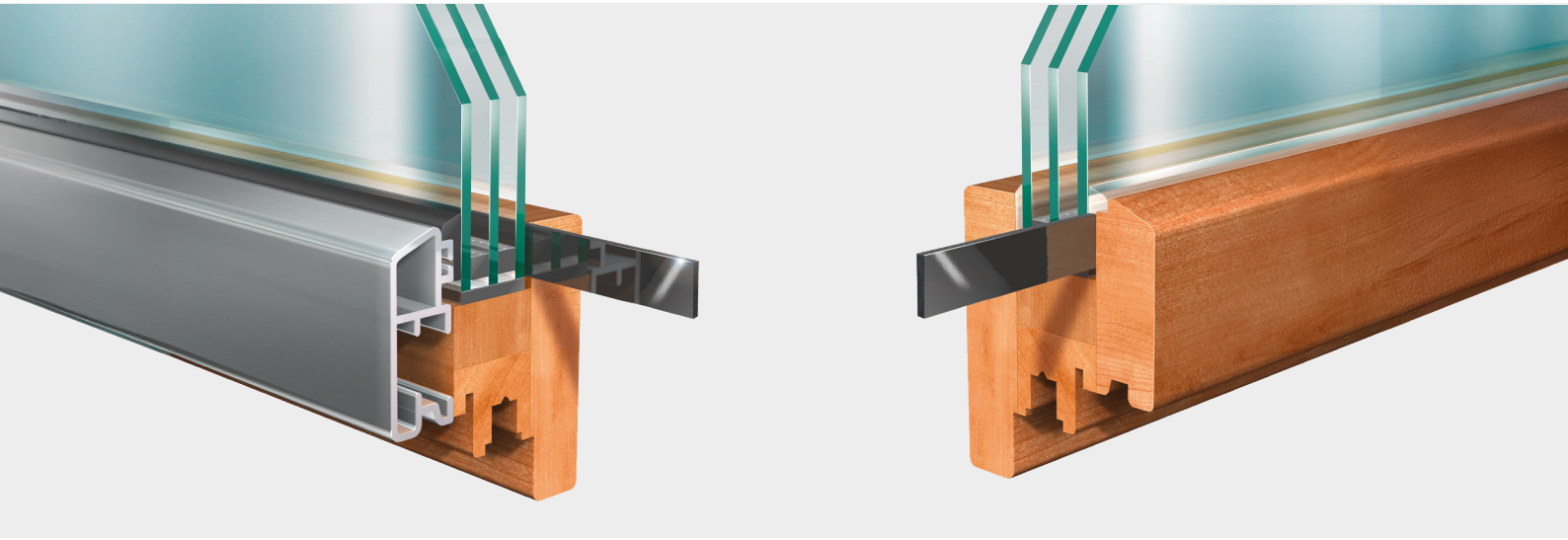
Addition to the Processing Instructions for Double-sided Pressure-sensitive Adhesive Tapes



Processing guidelines for using DuploCOLL 56056.1 / 56057.1 in prefabricated wooden window frames

In addition to the general LOHMANN processing instructions, the following processing guidelines must be observed when using Lohmann adhesive tapes for „direct glazing“ in wooden window constructions:

The basics of using the adhesive tapes

- Glazing directive DIN 18545 as well as „technical guideline of the glazier trade“
- Direct glazing according to current standards
- Without further testing of lacquered surfaces, we can only recommend the use on paint systems that have only been certified together with Lohmann adhesive tapes.

Requirements for use in window frames

It must be ensured that only profiles from a single batch are assembled to form a window element. This will exclude possible deviations in the form and positional tolerances of different profiles. In addition, the rectangularity or plane parallelism between the surface to be covered when mounting the profiles and the adhesive surface is to be observed.

Bonding the insulating glass to the window casement

- Condensation caused by the use of cold glass or profile must be avoided.
- In order to ensure a secure bond, silicone or silicone-containing sealants must not be allowed to contaminate the surfaces to be bonded.
- The surface tension of the insulating glass must be checked with a suitable testing pen (e.g. Arcotec) before bonding.The surface tension of the glass must be at least 36 mN/m. By using DuploTEC Primer G the glass surface can be optimized.
- Residues of secondary sealants and adhesive tapes or other contaminants must be removed from the glass. The bonding may only be carried out on the glass surface itself. A secure bond cannot be guaranteed on cover foils of the insulating glass edge seal or glass.

Addition to the processing instructions for double-sided pressure-sensitive adhesive tapes

Bonding the insulating glass to the window casement

The glass surfaces must be clean, dry and free of grease. For this purpose, the glass surface to be bonded must be cleaned with a suitable cleaning agent (DuploTEC Cleaner U, isopropanol, petroleum ether, alcohol or ester) and with the help of clean, lint-free cloths. If necessary, the glass surface must be pretreated with a primer.

- Visually check the adhesive tape for damage to the adhesive surface and/or peeling-off of the liner before bonding.
- The protective liner must be removed immediately before bonding the glass.
  There must be no contamination of the adhesive surface before mounting the glass.
- After application, the adhesive tape must be pressed on circumferentially with a laminating roller with a force of approx. 10 - 15 N/cm².
- The processing temperature must not lie below 18°C.
- At a storage temperature of 18 - 25°C, the bond has reached its full strength after 24 - 48 hours.
- Load-bearing supporting blocks are to be used. In this case we refer to the glazing directive DIN 18545 as well as to the „technical guideline of the glazier trade“.
- After inserting the glass, the full-surface contact with the tape must be ensured by suitable pressure.
- Since the use of the adhesive tape is only intended for „direct glazing“, we take it for granted that additional mechanical safety measures will be taken.
- The compatibility of all materials in the vicinity that are in direct or indirect contact with each other must be checked among one another!

Measures for quality assurance

- The window manufacturer documents the manufactured window and insulating glass data (make, type, dimensions, number, batch, etc.) for each customer order.
- Before bonding, the surface tension of the insulating glass is controlled in accordance with the instructions for use and noted in the customer order as a control point (>36mN/m).
- The window manufacturer must take appropriate measures to ensure that the self-adhesive equipped profiles are processed within the specified storage period.
- In the event of a complaint with a window casement, traceability back to the tape raw material over a period of 10 years is guaranteed, provided the window or customer order and the batch number of the processed profile are advised.
- The window manufacturer must ensure that the processing personnel have been instructed in the use of the self-adhesive window profiles.
- The area in which glass and profile are bonded must be protected against harmful substances and external influences. These include, for example, lubricants, aggressive cleaning substances, which are used in the further processing of the profile with fittings or mounting materials.

These specifications are based on the experiences made with the previous window system developments. We reserve the right to make changes based on the knowledge and possible future guidelines in window technology. This processing guideline reflects the state of the art at the time of issue and is not a guarantee of use in the legal sense. With the continual collation of new application parameters, these are subject to a constant update. The processor is required to assure himself that he is using the latest edition of the processing guideline at the time of processing.

Processing of Wooden Profiles



Remove soiling from the edge of the pane,
e.g. with a glass scraper.



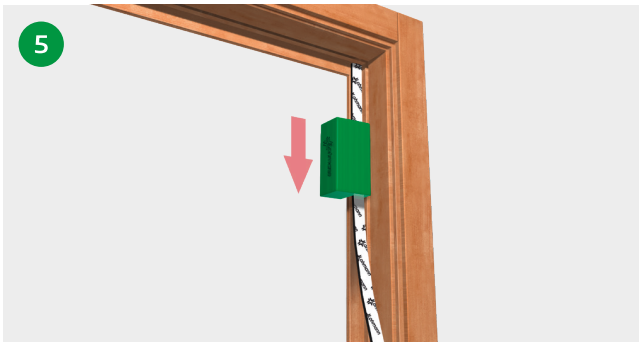
Cleaning the glass surface with DuploTEC Cleaner U.



Clean the lacquered wooden surface to be bonded
with DuploTEC Cleaner.



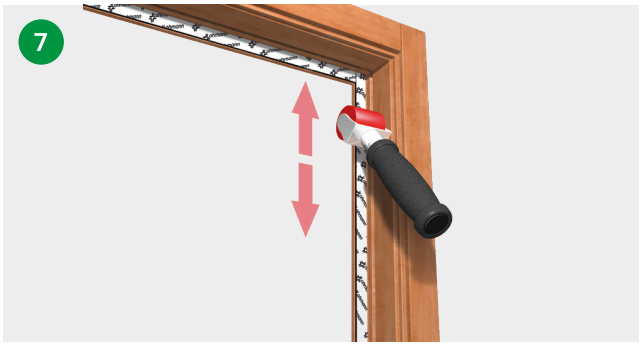
Apply DuploCOLL 56056.1 / 56057.1
using the hand applicator.



Corner formation can be made end-to-end,
mitered or slightly offset *.



*Insert an Additional sealant point in this case.

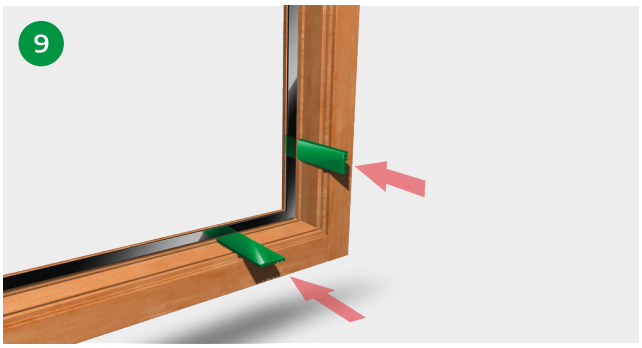


Pressing the adhesive tape with the aid of
a pressure roller.

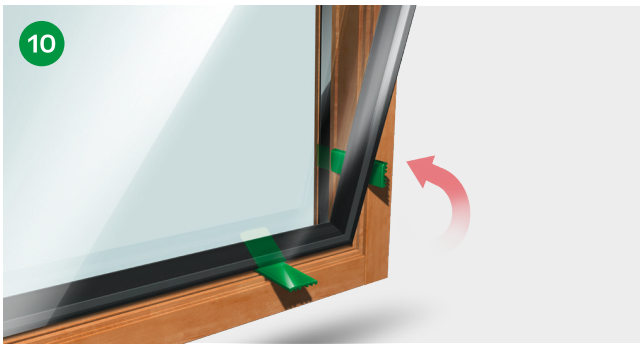


Remove the liner.

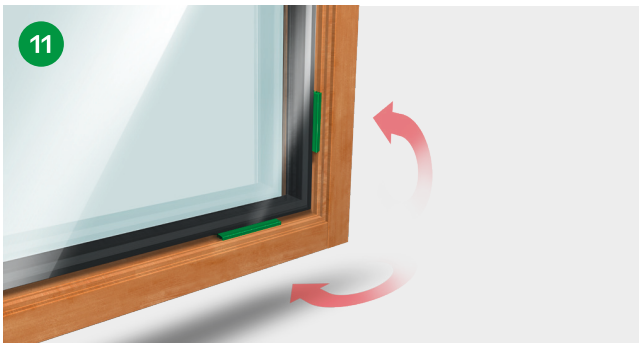
Processing of Wooden Profiles



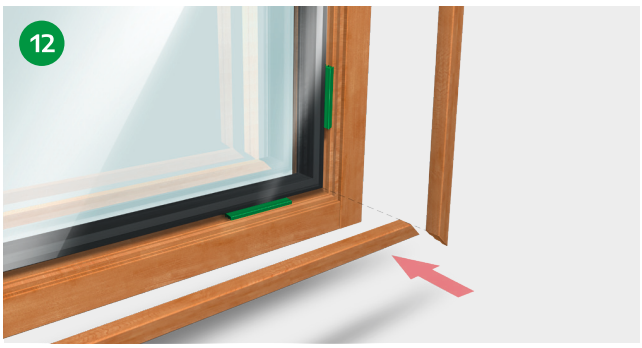
Position the glazing blocks correctly.



Insert pane.



Insert and engage glazing blocks.



Attach glazing strips.

Product range	Unit
DuploTEC Cleaner U	1 litre
DuploTEC TAT 404xx (Applicator)	1 Pc.
DuploCOLL 56056.1 – adhesive tape 2mm thickness – width 12/ 15mm	Roll à 50m
DuploCOLL 56057.1 – adhesive tape 3,2mm thickness – width 12/ 15mm	Roll à 25m

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