

BOND+SEAL

Surface finish optimisation



BOND+SEAL Activating Cleaner

For cleaning and activation of non-porous surfaces such as metals, plastics, glazed ceramics and painted surfaces.
Drying time: min. 10 min. (23°C/50% rel. humidity).
Not suitable for smoothing or removing of adhesives or sealing compounds.

Contents ml	Art. No.	P. Qty.
400	0890 100 60	1/12



BOND+SEAL Remover

For removal of PU or hybrid adhesives and sealing compounds from tools and non-porous surfaces, before they are fully cured.

Contents ml	Art. No.	P. Qty.
400	0890 100 63	1/12



BOND+SEAL Primer for Metal

For pre-treatment of metallic substrates (iron, steel, stainless steel, galvanized steel, aluminum, anodized aluminum, copper, brass, zinc).
Drying time: min. 30 min. (23°C/50% rel. humidity).
Not suitable for corrosion protection.

Contents ml	Art. No.	P. Qty.
250	0890 100 61	1/6



BOND+SEAL Primer for Plastic/Wood/Stone

For pre-treatment of plastics (PVC, ABS, GFK), wood and other porous substrates, such as stone and concrete.
Drying time: min. 30 min. (23°C/50% rel. humidity).
Not suitable for PE, PP, PTFE, PMMA and PC.

Contents ml	Art. No.	P. Qty.
250	0890 100 62	1/6

Application Table

Surface/material	Optimisation steps	Remarks
Aluminium (AlMg3, AlMgSi1)	B+S Activating Cleaner and, if necessary, B+S Primer for Metal	If necessary, first sand lightly with sanding fleece.
Aluminium anodized	B+S Activating Cleaner and, if necessary, B+S Primer for Metal	-
Steel (St 37, etc.)	B+S Activating Cleaner and, if necessary, B+S Primer for Metal	If necessary, first sand lightly with sanding fleece. In case of steel components in danger of corrosion: 2-comp. PU or epoxy corrosion protection required.
Stainless steel	B+S Activating Cleaner and, if necessary, B+S Primer for Metal	-
Steel, galvanized or hot galvanized	B+S Activating Cleaner and, if necessary, B+S Primer for Metal	If necessary, first sand lightly with sanding fleece.
2-comp. top coats (PU, epoxy), 2-comp. water based primers and enamels, KTL, primers (EP/2-comp.)	B+S Activating Cleaner	Due to the wide variety of enamels, this information is for reference only, preliminary testing required.
Powder coated surfaces	B+S Activating Cleaner	Preliminary testing recommended for applications with high forces or in moist ambient conditions.
GFK (unsaturated polyester), gelcoat side or SMC	B+S Activating Cleaner	If necessary, first sand lightly with sanding fleece.
GFK (unsaturated polyester), layup side	1. Sand with 0674 000 80 emery cloth 2. B+S Activating Cleaner 3. B+S Primer for P/W/S	-
ABS	1. Sand with sanding fleece 2. B+S Activating Cleaner 3. B+S Primer for P/W/S	Sanding may be omitted in case of components subject to light loads.
Rigid PVC	1. Sand with sanding fleece 2. B+S Activating Cleaner 3. B+S Primer for P/W/S	Sanding may be omitted in case of components subject to light loads.
Glass (mineral)	B+S Activating Cleaner	Joining surface must be protected against UV radiation (opaque covering).
Glass ceramics	B+S Activating Cleaner	-
Wood and wood products (particle boards) untreated	1. Remove dust 2. B+S Primer for P/W/S	-
Natural stone	1. Remove dust 2. B+S Primer for P/W/S	Possible discoloration in case of natural stone (marble).
Concrete, mineral mortar and plaster	1. Remove dust 2. B+S Primer for P/W/S	-
Textiles, fleece	B+S Primer for P/W/S	Preliminary testing required. In some cases, meshing of adhesive with the textile is sufficient.

Note:

The above information always relates to the surface of the component (e.g. steel coated with 2-component epoxy enamel: see 2-comp. top coats). Prior to starting optimisation procedures, all components must be clean, dry and free of dust, grease and oil. Unstable or loose layers must be removed first.

After that, spray the surface with a thin coat of B+S Activating Cleaner and wipe off with a clean cloth or absorbent paper, or spray B+S Activating Cleaner onto a cloth and wipe the surfaces to be joined. Always wipe in the same direction. Afterwards, apply a thin coat of B+S Primer for Metal or Primer for Plastic/Wood/Stone evenly with a brush.

Important:

Prior to the next step, the previously applied layer must have set and dried completely. Observe aeration times!