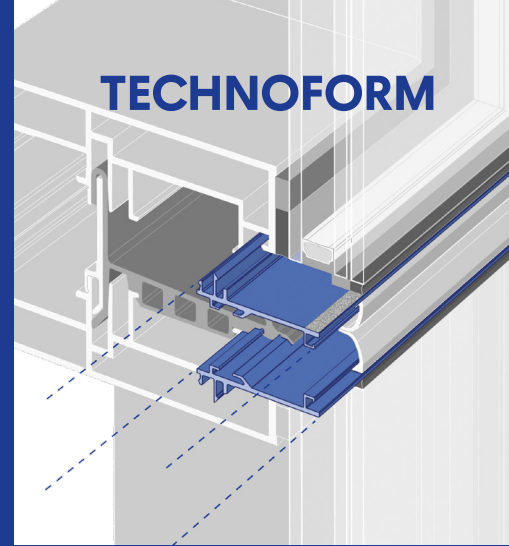


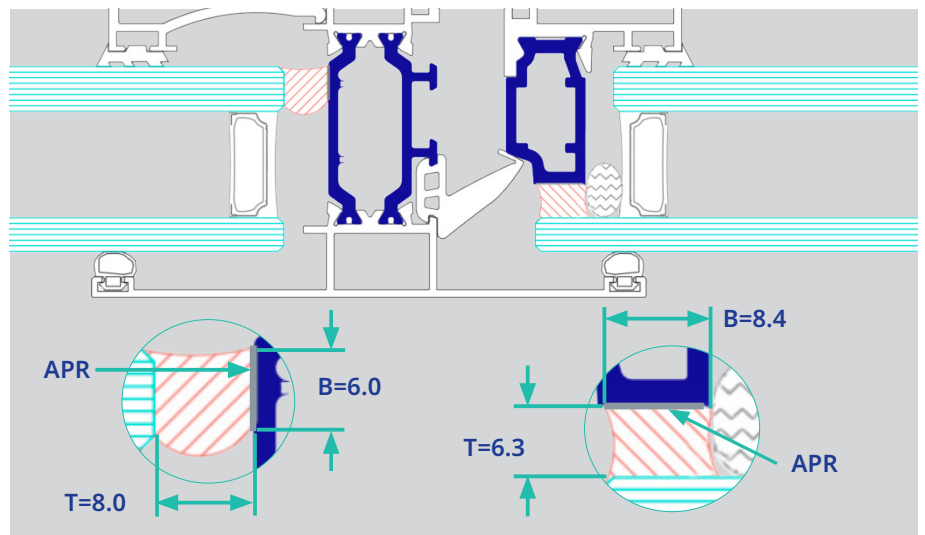
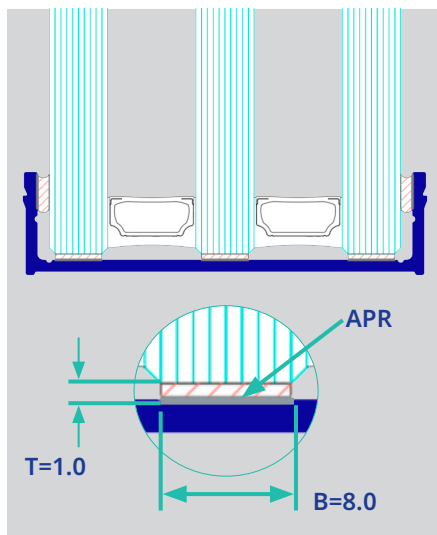
Adhesion Prime design manual

Technoform Adhesion Prime is a dispersion of alumina particles designed to improve the adhesion characteristics of the surface of the strip to achieve an optimal connection between the adhesive and polyamide.



TECHNOFORM

Adhesion Prime (APR) is intended to be used in designs for windows, doors, and facades that require adhesion between the thermal break and the frame, panel or glazing. It is subject to follow ETAG, EN16759/13022-2, ASTM C1401/C1193.



General use

General applications, bite and/or thickness out of Ratio.

Surface for Adhesion Prime must be flat and wider than 6mm.

Thickness (T):
distance between the bonded surfaces.

Bite (B): length of the contact between the surface and the silicone.

Weather-proof end use

Weather-proof applications, behaving as elastic bonding, bite must be smaller than thickness.

Ratio: $6 \leq B \leq 15$; $B \leq T$; $T \leq B \leq 3T$; $6 \leq T \leq 45$

Surface for Adhesion Prime must be flat and wider than 6mm.

Standards:

ASTM C1193, point 16.4.12.4
 $6\text{mm} \leq T$

Certifications: ASTM C1184, PA66 GF25.

Structural end use

Structural applications, behaving as stiff bonding, bite must be larger than thickness.

This application is only allowed for glazing supported systems and withstanding wind loads.

Ratio: $6 \leq T \leq 12$; $T \leq B$; $B \leq T \leq 3B$; $6 \leq B \leq 36$

Surface for Adhesion Prime must be flat and wider than 6mm.

Standards:

ASTM C1401, point 28.3: $6\text{mm} \leq T$

Certifications: ASTM C1184, PA66 GF25.

Insulating solutions for windows, doors, and facades

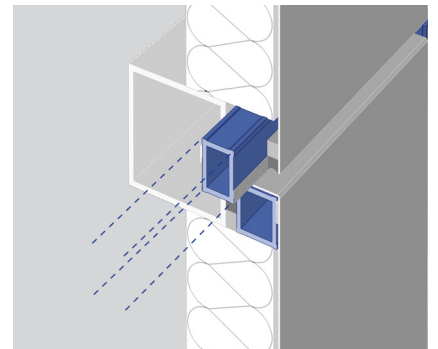
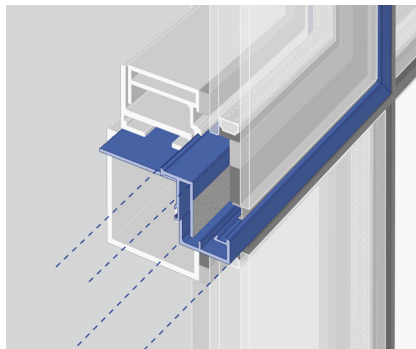
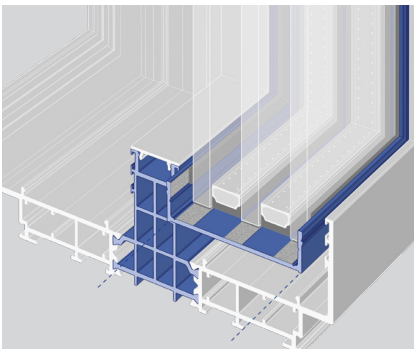
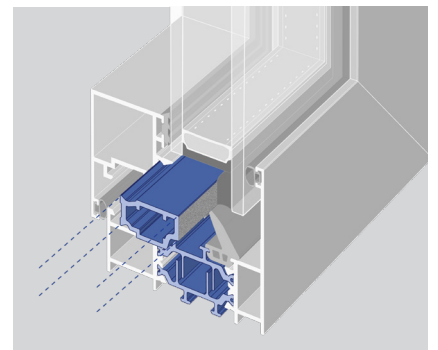
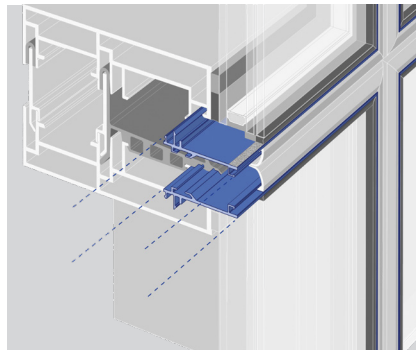
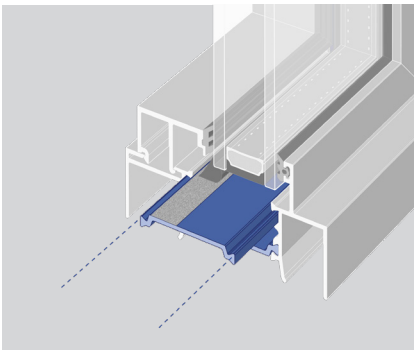
Technoform polyamide strips greatly improve thermal conductivity for windows, doors, and facades.

However, adhesion to polyamide profiles has historically been challenging due to the low surface energy of plastics in general and the very smooth surface of Technoform polyamide profiles in particular. The adhesion of the glues on polyamide is often weaker than the one observed on aluminum.

For this reason Technoform in the past never recommended using PA profiles in glue connections and does not guarantee the results.

Technoform Adhesion Prime opens a huge range of new design possibilities, both for sealant and structural adhesion solutions.

New design possibilities



Application boundaries

The use of Adhesion Prime is limited and dependent on the shape of the polyamide. It can be applied along the external cross-section of the strip, excluding the inner site of the fins, gasket channels and open cavities.

Adhesion Prime has been proven effective for surface widths greater than 5 mm.

It is important to verify the effectiveness of Adhesion Prime in each specific applications.

