

## **CLEANING SURFACE WHICH HAS TO BE BONDED**

In addition to the required high surface tension, satisfactory wetting of surfaces to be bonded can only be achieved if they are made, dry, clean and free of grease prior to bonding.

- The presence of any grease or oil, including sebum from contact with fingers, is detrimental to the formation of a strong bond.
- In the presence of dirt, dust or rust, the adhesive will attach itself to it and not to the surface of the part to be bonded.
- Moisture, as a thin film between the substrate and the adhesive bead, will frustrate the adhesion completely.

### **Cleaner**

Using TWEHA Cleaner+ is the most appropriate method to achieve a satisfactory level of surface cleaning independent on the type of surface contamination to achieve the quality of the bond desired.

### **Mechanical**

The surface is ground with sandpaper or with other abrasives (sand blasting). The dust formed must be thoroughly removed, ideally with TWEHA Cleaner+. Abrasion will increase the surface available to bonding.

### **Surface improvement**

For some surfaces which are highly porous and surface with less structure such as fiber cement board, a surface improver TWEHA Prefix X-tra is useful. Application of the surface improver also requires careful cleaning.

### **Primer**

TWEHA's Bonding Systems do not require the use of a primer. This means one operation less so less risk, less costs and the absence of a dangerous aggressive product due to toxicity concerns.

For some bonding systems primers are an important piece for most applications. They help prepare the substrate by cleaning and softening the surface to maximize final bonding integrity by the use of some kind of organic solvent.

For most cases, a cleaner should be used, followed by a primer and then the adhesive. Additionally, after application of the primer, the adhesive should be applied immediately before the primer dries.

Note that TWEHA Prefix X-tra does NOT have this limitation in time.