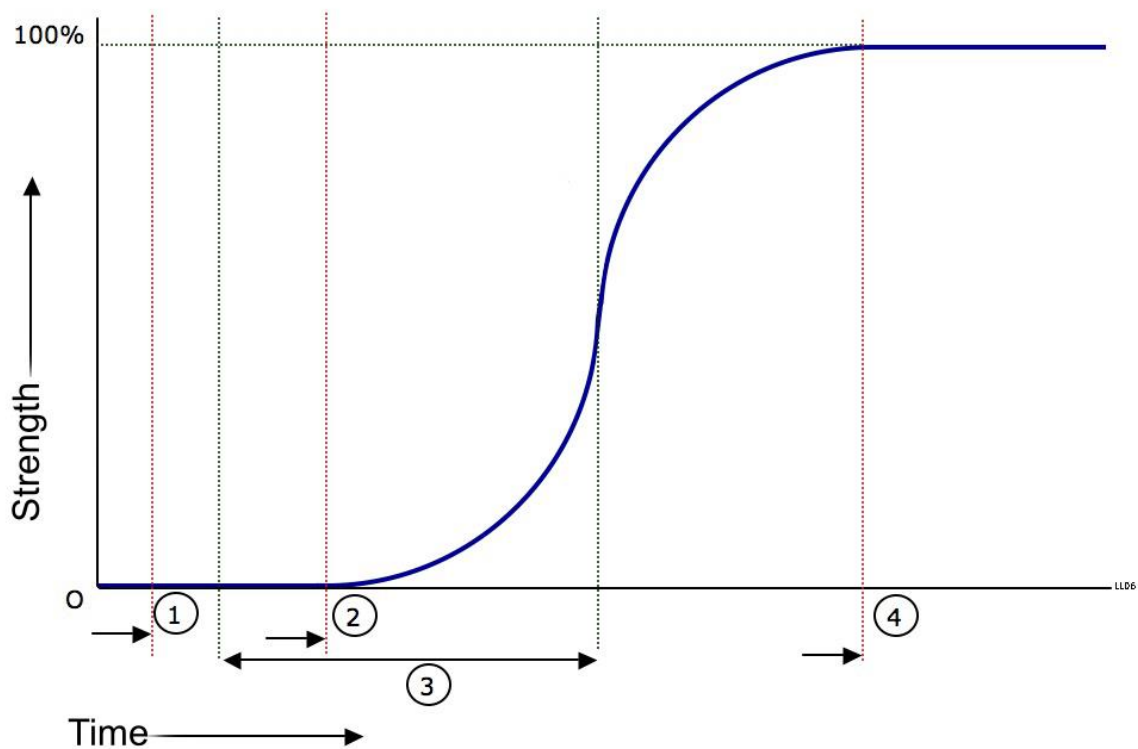


TERMS FROM THE ADHESIVE PROCESS

The TWEHA adhesive systems are single-component or 1K adhesives. These consist of only one component to be applied. The second component or activator, necessary for the reaction, is drawn from the environment (humidity).

The following terms are used in the adhesive process:



- 1- Application time: The time required to apply the adhesive to the surface.
- 2- Open time: The period during which the adhesive has not yet reacted. Within this time frame, the adhesive must be applied. If the adhesive is applied later, a complete strong bond will not form.
- 3- Working time: maximum amount of time during which adhesive on/between substrates cannot yet be stressed.
- 4- Curing time: The entire process time required to achieve a 100% strong adhesive bond. Typically, the strength build-up follows the "S" curve depicted in the figure.
- 5- Shelf life: how long a product will last just sitting on the shelf, unopened. The shelf life refers to the length of time from the date of manufacture that the product is under warranty based on a technical data sheet.