

## CLARIFYING THE DIFFERENCE BETWEEN USING A CLEANER OR A PRIMER

*Using TWEHA's bonding systems you don't need a primer, cleaning the surfaces is sufficient! This reduces the risk of application errors and saves on labor costs and procurement.*

### *Cleaner, washer or cleaner*

The necessity of using a cleaner depends about application. A cleaner is a cleanser to treat the backside of the panel and / or the front of the aluminum subframe. It removes oil, grease, residual dirt and other impurities and prepares the surfaces for the bonding process.

On the rear side of cladding panels (the side to be bonded), a residue (dust) derived from the production of release agents or films that protect the facade panel can remain.

- Release Agents. For example, HPL panels are manufactured by squeezing several plates - sometimes forty or eighty pieces at once - under high pressure. In order to be able to retrieve them from each other after pressing the plates, a release agent is applied between the plates in advance. That's mostly fat or a product based on silicone.
- Films. In some brands of HPL plates a protective film is applied on the front and / or rear side in order to protect the plate from damage and warping. Upon removing the foil a thin layer (residue) can be left behind the plate. The facade panel must first be lightly sanded and cleaned before it can be glued. The glue joint should for this reason always be applied after the specified time after the application of the primer!

### *Primer*

An adhesive primer is applied to the surface and generally improves the bond ability of the substrate and acts as a "chemical bridge" between the substrate and the adhesive.

These primers generally consist of a reactive chemical agent which is dosed in a solvent. This solvent evaporates after application, leaving behind the active agent.

This often-aggressive agent 'etches' the surface to be bonded, so that the adhesive can penetrate. This leads to a change of the surface of the substrate. A crater-like structure is formed to accommodate the mechanical "cross-linking" of the adhesive.

*The glue joint should for this reason always be applied within the specified time after the application of the primer!*

Aggressive primers are harmful to humans and the environment!