

WOLFINATOR

Assembly Adhesive

Universal assembly adhesive for absorbent and non-absorbent substrates. Special polymer for use without primer.

PROPERTIES

- High initial tack
- No primer required
- For indoor and outdoor use
- Good gap-bridging properties
- Weather- and age-resistant
- Paintable and sandable
- Very high final strength
- Solvent-free
- Can be used as a sealant
- Good adhesion e.g. to wood, metal, ceramics, stone, concrete, glass, polystyrene and painted surfaces

SCOPE OF USE

For the economical and efficient bonding of building materials indoors and outdoors on wood, metal and mineral substrates. Also for sealing connection joints. Universal use for roofing, plumbing and sheet metal works.

Can be easily used for producing concealed fastenings:

- bonding of masonry cappings
- bonding of metal sheets in the area of roof-to-wall, roof-to-skylight or eaves flashing connections
- bonding of WOLFIN metal sheets with each other (metal-to-metal)
- used as an assembly aid on steep roofs
- installation of flashing strips
- bonding WOLFIN metal sheets on the WOLFIN IB membrane (floor-to-wall connection) when waterproofing floors / wet rooms

WOLFINATOR Assembly Adhesive is an injectable, 1-component adhesive that cures in the presence of atmospheric moisture. Cross-linking and skin formation can be accelerated by increasing the temperature and air humidity.

SUBSTRATE PREPARATION

Suitable substrates include all absorbent and non-absorbent materials. WOLFINATOR Assembly Adhesive adheres, even without primer, to substrates such as wood, metal, ceramics, stone, concrete, glass, polystyrene and painted surfaces.

The substrate must be clean, sound and free of dust, grease and release agents. In the case of powdering, friable or dust-covered surfaces we recommend using our Terotech Primer V.

WOLFINATOR Assembly Adhesive is usually compatible with bitumen. However, due to the great variety of bitumen products available in the market, it is recommended that the user carries out preliminary tests. WOLFINATOR Assembly Adhesive is not suitable for bonding PE, PP, PTFE and acrylic glass.

The building materials can also be fixed on slightly damp substrates, but not on surfaces with standing water. In order for the adhesive to cure, small amounts of moisture must be absorbed (from the atmosphere or from the material to be bonded). The user should carry out suitability tests when using other materials and substrates than those mentioned here.

APPLICATION

Apply the adhesive with a hand gun. Cut the cartridge open above the thread and screw on the plastic nozzle. Cut the nozzle open to a width that matches the amount of adhesive to be applied. When working with the screwed-on nozzle, the bonding work can be interrupted without causing the premature curing of the adhesive.

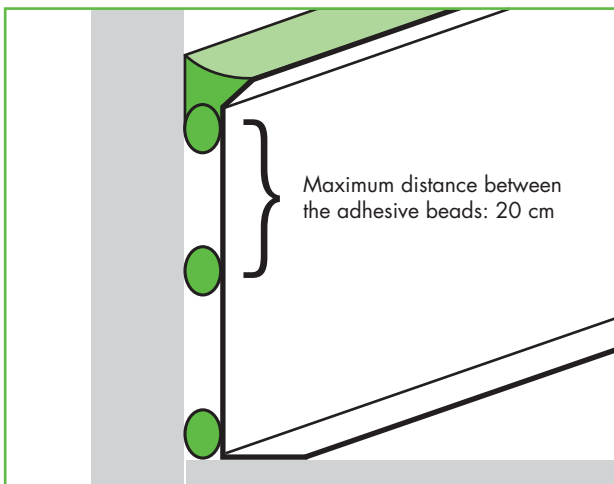
Apply the adhesive in beads on the material to be bonded or on the substrate. The bead diameter must be at least 8 mm, with a minimum distance of 10 cm between the beads. When applying the adhesive on vapour-tight surfaces such as glass, metal or GRP (= glass-fibre reinforced plastic), the application must be interrupted by 10 cm every 50 cm to avoid the trapping of condensate.

Afterwards, press the workpieces together and make sure, especially with non-absorbent materials, that the beads do not coalesce. **Ensure proper ventilation between the beads.** After pressing, the adhesive layer must have a minimum thickness of 3 mm. If necessary, use spacers. Application temperature: +5 °C to +40 °C.

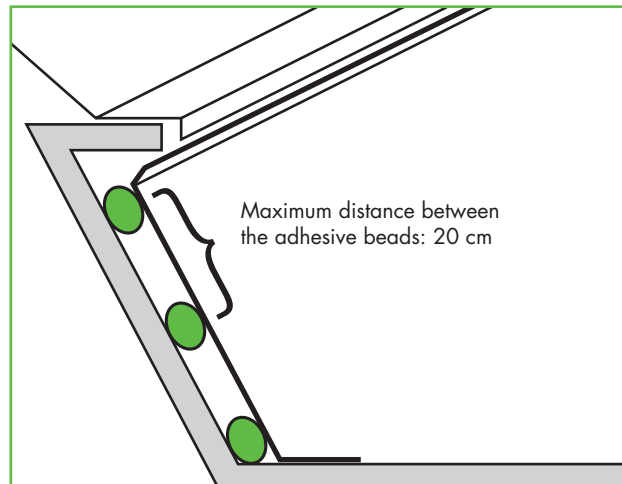
When installing heavy components or parts under high stress, it may be necessary to support them or to fix them by mechanical means. However, this is not normally required for WOLFEN metal sheets (see under "Scope of use" for the WOLFEN IB membrane). After bonding the metal sheet, wait for a minimum of 24 hours before connecting the WOLFEN roofing membrane (M or GWSK). This time can be longer in the case of very dry substrates. Carry out preliminary tests to ensure that bonding strength and curing time are sufficient.

Connecting WOLFEN metal sheets on flat roofs and balconies:

At least two beads of adhesive are applied on the underside of the metal sheet. The first bead is always applied in the area of force application. The upper bead provides the top edge seal and needs to be reworked if necessary. If the metal sheet is more than 20 cm wide, a third adhesive bead must be applied in the middle.



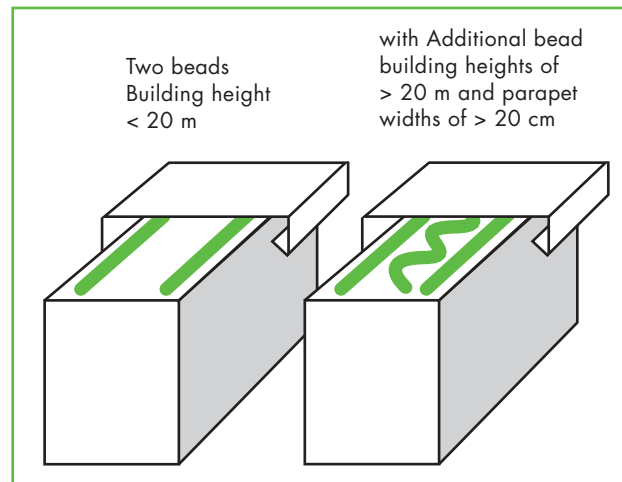
Connection between metal sheet and skylight:



Masonry and parapet flashings:

WOLFENATOR Assembly Adhesive can be used for fixing masonry and parapet flashings up to a building height of 12 m and parapets up to 50 cm width. In the case of parapets up to 20 cm width, 2 adhesive beads are applied along the parapet edge. In the case of larger widths, an additional bead must be applied. The adhesive layer must have a minimum thickness of 3 mm. If necessary, suitable spacers can be used.

If the flashings are made of titanium zinc, the beads must be interrupted after every meter by approx. 10 cm in order to avoid corrosion of the metal sheet underside.



Additional application:
Installation of windowsills

PLEASE NOTE

Materials fixed with WOLFATOR Assembly Adhesive can be repositioned for a few minutes. The part to be bonded is fixed immediately after applying the adhesive bead. The maximum open time is 20 minutes.

Post-treatment of the joint: After curing, WOLFATOR Assembly Adhesive can be painted over, especially with a water-based acrylic paint. Preliminary tests are recommended.

Immediately remove excess adhesive with a cloth. After curing, the adhesive can only be removed mechanically. The tools can be cleaned with commercial paint thinners or cleaner's naphtha (solvent).

WOLFATOR Assembly Adhesive is not suitable for bonding or sealing the seams of WOLFATOR roofing and waterproofing membranes.

WOLFATOR Assembly Adhesive is solvent-free and odourless. Special precautions are not normally required.

STORAGE

Store in a frost-free, cool and dry place.
Shelf life (in the original packaging): 12 months.
Use up opened cartridges as soon as possible.

DISPOSAL

Recycle according to the local regulations.

PACKAGING

300 ml nozzle cartridge

TECHNICAL DATA

Material base:	silane cross-linking polymer
Consistency:	paste-like
Odour:	odourless
Colour:	grey
Density acc. to DIN 53 217, part 2:	approx. 1.4 g/cm ²
Shore-A hardness acc. to DIN 53 505:	approx. 60
Permissible total deformation:	approx. 15 %
Extensibility/tension value at 100 % acc. to DIN 53504:	1.0 Npa
Gap bridging:	up to 20 mm width
Initial tack:	approx. 8 g/cm ²
Tensile shear strength acc. to DIN 53504:	approx. 2.0 Mpa
Elongation at rupture acc. to DIN 53504:	approx. 200 %
Temperature resistance:	-30 °C to +80 °C, temporarily up to 100°C
Open time at +20 °C:	approx. 20 minutes
Skin formation in standard climate acc. to DIN 50014:	20 minutes
Application temperature air and substrate:	+5 °C to +40 °C
Curing time in standard climate:	2 mm/24 h, longer curing time with higher adhesive layer thickness
Volume change acc. to DIN 52451:	< 4 %
Yield:	6 m / cartridge

In case of questions, please consult our advisory service.

Hotline Facade	Hotline Roof
Phone 0211/ 73 79 -288/289	Phone 0 60 53 / 708-141
Fax 0211/ 73 79 -227	Fax 0 60 53 / 708-113

Concerning the resistance to horizontal forces, it is necessary to observe the Flat Roof Guideline and follow the WOLFIN Installation Instructions. When using the adhesive for roof areas subject to foot or other traffic and for indoor sealing work, it may not be necessary to take additional measures that provide resistance to horizontal forces.

Apart from this information, it is also important to observe the relevant guidelines and regulations of various organizations and trade associations as well as the applicable standards of the German Standards Institute (DIN). The aforementioned properties are based on our practical experience and application tests.

As site- and application-specific conditions may vary from those described here, the correct and successful use of our products is therefore beyond our influence. If in doubt, the user should first carry out sufficient tests to ensure the product is suitable for the intended application. Legal liability cannot be accepted based on the contents of this technical data sheet or any verbal advice given.

This Technical Data Sheet supersedes all previous editions.

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