

# Technical Brief

## Bonding Korogard® to Wood

For bonding Korogard to wood, there are various adhesives that are recommended. They are Formulated Solutions XT-2000+™ Mastic, 3M Fastbond™ 30-NF, and Dap Weldwood Nonflammable. When using any of these adhesives, the substrates must be free from dirt, grease, and dust. To clean the Korogard surface, wipe with a solvent such as isopropyl alcohol before you apply the adhesive. Although it isn't always practical, keep in mind that for all of these adhesives, best results will occur when the bonding process is done in a temperature-controlled environment of approximately 65°F (18°C) to 75°F (24°C).

If you choose to use 3M Fastbond 30-NF, Formulated Solutions XT-2000+ Mastic, or Dap Weldwood Nonflammable, we suggest applying a latex primer to the wood before applying the adhesive. Although the primer is not mandatory, it will decrease the amount of adhesive that absorbs into the wood when the first coat is applied.

For installation with contact adhesives, apply two coats to the wood. Allow the first coat to dry thoroughly before applying the second coat. Apply one coat to the Korogard. Adhesive should be dry and not feel tacky when you're joining the substrates together. Koroseal Wall Protection Systems recommends a minimum of 45 minutes be allowed before adhering the substrates. After adhesive dries, three hours remain to complete the job. THE LONGER YOU WAIT (up to four hours total), THE STRONGER THE INITIAL BOND WILL BE. Apply pressure to ensure that good contact is made. For hand lay-up, the Crain #333 high-pressure roller is recommended. Note that contact adhesives bond immediately upon contact. Utilization of slip sheets is highly recommended to prevent accidental bonding.

Installation with mastic adhesive requires that the adhesive is only applied to one of the substrates—specifically the wood surface. Be sure to cover 100% of the wood surface area, maintaining uniform coverage with a notched trowel. Insufficient adhesive is the cause of most problems. Allow adhesive to set up according to the instructions on the adhesive container label. After joining the substrates, apply pressure to ensure good contact (the Crain #333 high-pressure roller is recommended).

For More Information on These Adhesives:	Call
3M Fastbond 30-NF	800-362-3550
Dap Weldwood Nonflammable	888-327-8477
Formulated Solutions XT-2000+ Mastic	Your local Korogard distributor

## Bonding Korogard® to Metal

For bonding Korogard to metal, including aluminum, cold rolled steel or other grades of steel, and stainless steel, Dap Weldwood Nonflammable can be used with good results.

When using this adhesive, the substrates MUST be free from dirt, grease, and dust. To clean the surfaces, wipe with a solvent such as isopropyl alcohol before you apply the adhesive. Best results will occur when the bonding process is done in a temperature-controlled environment of approximately 65°F (18°C) to 75°F (24°C).

Dap Weldwood Nonflammable is a contact adhesive. One coat of the adhesive should be applied to the metal and one coat to the Korogard. Wait until the adhesive is tack-free and then join the substrates. Apply pressure with a pressure roller (Crain #333) to ensure good contact.

For More Information on This Adhesive:	Call
Dap Weldwood Nonflammable	888-327-8477

The suggestions and data in this document are based on information we believe to be reliable. They are offered in good faith, but without guarantee, as conditions and methods of use of our products are beyond our control. We recommend that the prospective user determine the suitability of our materials and suggestions before adopting them on a commercial scale.



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