BONDING KOROGARD

KOROSEAL
WALL PROTECTION

Bonding Korogard to Wood

For bonding Korogard to wood, there are various adhesives that are recommended. They are Formulated Solutions XT2000+™ Mastic, 3M™ Fastbond™ 30NF, and Dap® Weldwood® Nonflammable. When using any of these adhesives, the substrates must be free from dirt, grease, and dust. Use a mild detergent solution to degrease the back side of the sheet. Rinse with clean water and microfiber cloth, changing water frequently. Dry completely before installation. Although it isn't always practical, keep in mind that for 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™ 30NF, Formulated Solutions XT2000+™ Mastic, or Dap® Weldwood® Nonflammable, apply a high-quality acrylic primer to the wood before applying the adhesive. It is best to cover all six sides of the wood to prevent warping or other deformations in the installed sheets.

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 sheet. Adhesive should be dry and not feel tacky when you're joining the substrates together. Koroseal recommends a minimum of 45 minutes be allowed before adhering to 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™ 30NF	800.362.3550
Dap® Weldwood® Nonflammable	888.327.8477
Formulated Solutions XT2000+™ Mastic	Your local Koroseal® sales representative

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 These Adhesives:	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 determines the suitability of our materials and suggestions before adopting them on a commercial scale.