

Instruction for gluing single- and double-sided aluminium overlay panels manufactured by VEYNA

Recommendations

1. During the transport, the panels must be protected against damage using "special protective packaging".
2. Before starting gluing, clear the table thoroughly of residues of glue, sand particles, filings, etc. The door leaf must be cleaned with compressed air and degreased.
3. The package must always be opened by cutting along its side, never longitudinally or transversely.

The VEYNA overlay panel gluing kit contains;

1. Sikaflex 221/ 300 mL
2. Sika Primer 206G+P/ 30 mL
3. Sika Aktivator Pro/ 30 mL
4. Sika Power Clean Aid/ 2 pieces
5. Polyester matting nonwoven / 2 pieces
6. Specialist electrostatic nonwoven
7. Gloves
8. Gluing instruction
9. Primer pen for glass
10. Acrylic tape*



*Concerns the kit for gluing by the customer including the tape.

See the tutorial



NOTE: The Veyna overlay panel gluing kit should be used for gluing overlay panels only on substrates specified in the leaflet. Procedures in the instructions and the bonding and drying times should be strictly adhered to. Recommended conditions for bonding and drying are 23°C and 50% air humidity. The optimum bonding time is 24 hours. The processing temperature should be no lower than 18°C and no higher than 25°C.

A training at Veyna facilities can be arranged. The first training is free of charge. Subsequent trainings, if necessary, are paid for according to individual arrangements.

1. Initial activities

Prepare all components to be glued and kits for gluing VEYNA aluminium overlay panels. The place where gluing is performed should be stable and of dimensions suitable for the leaf structure (it should not be a glazing table). Thoroughly remove all contamination from the structure and the table. All contaminations should be initially removed using compressed air and suitable tools and agents. The cleaning should be performed before polishing surfaces that are to be glued together.

2. Preparation of glued surface

The surface of the leaf section and of the panel should be matted using polyester matting nonwoven until the entire surface is rough.



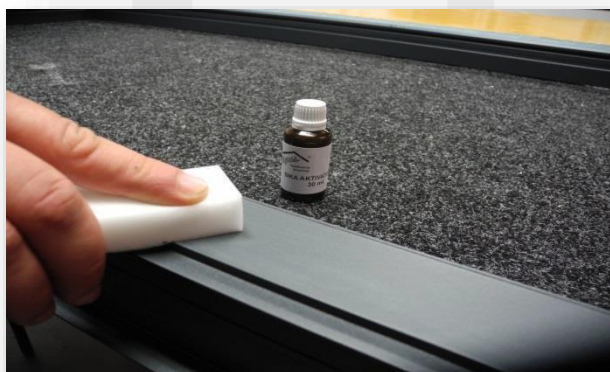
After matting, clean the surface thoroughly of the dust with a wet cloth,



and then repeat the action using electrostatic nonwoven.



Then, using the SIKa POWER CLEAN AID sponge and the SIKa AKTIVATOR PRO agent, wipe the surface of the leaf and the metal sheet at the gluing location.



After activation of the aluminium, apply SIKa PRIMER 206G+P on the glued components, carefully, so other components of the panel or the leaf are not contaminated.



Then wait about 20 minutes, until PRIMER is completely dry.

2.1 For the kit with the tape:

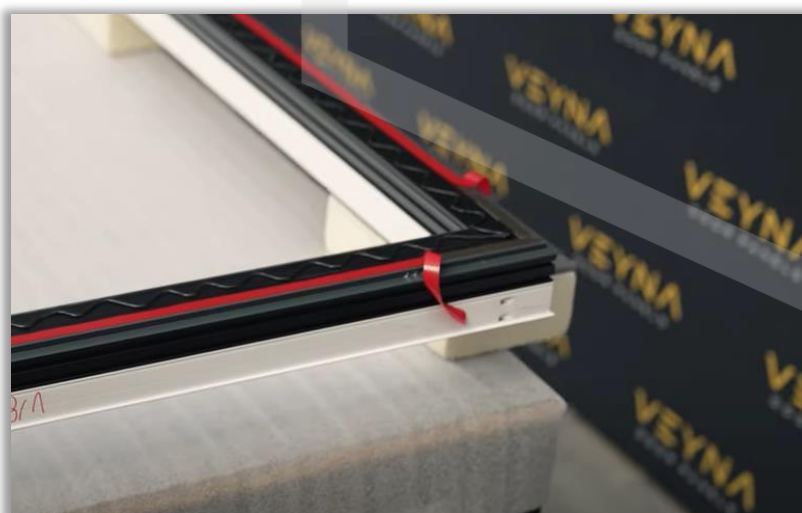
1. Apply the Veyna tape for fast assembling on a door leaf.



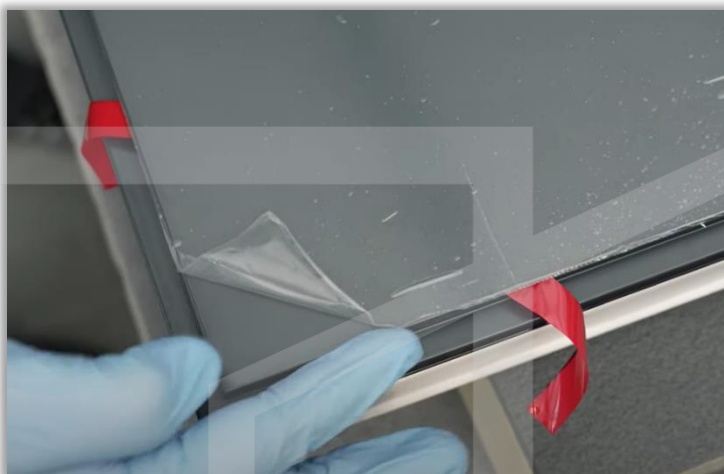
2. Apply the SikaFlex 221 glue (according to the recommendations in the instruction, **section 3 “Gluing”**).



3. Fold the red release paper of the tape out.



4. Place the metal panel in the required position in relation to the door leaf.



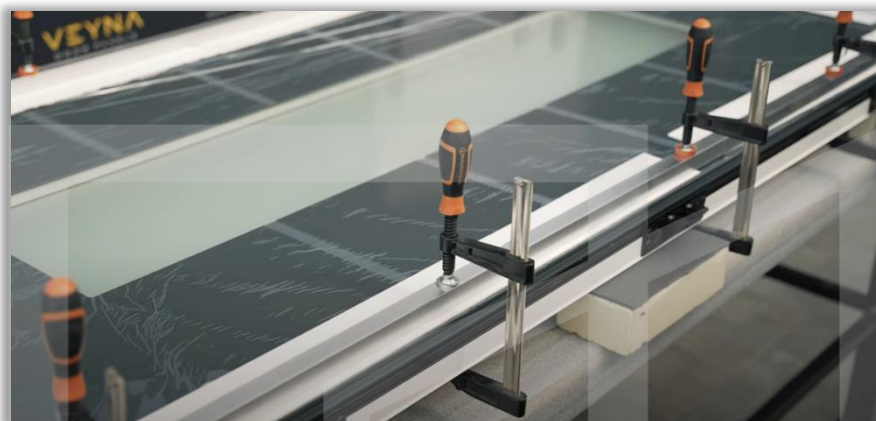
5. Remove the red release paper by pulling the sections previously folded out.



6. Set and press the panel onto the door leaf, and the metal sheet panels are immobilised by the tape. The use of a roller is recommended.

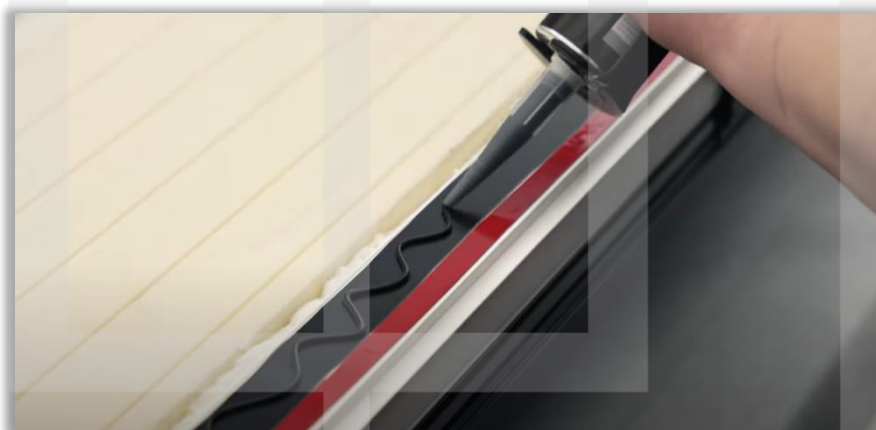


7. Use clamps to maintain the coplanarity of glued surfaces.



3. Gluing of the internal side of the panel (for a double-sided overlay panel).

Apply the SIKAFLEX 221 glue as zigzags onto vertical and horizontal sections, leaving about 20 mm of free space from the external edge of the leaf, to prevent the glue getting outside the structure.



Load the glued surface using carpenter clamps or weights. Using a cloth and non-corrosive solvent, e.g. benzine, remove excess glue that could leak out after clamping. You should also remember to evenly secure the surface under clamps or weights, e.g. with a board or sections (of the width and length matching the glued part). **Do not move the structure for at least 12 hours, and the complete bonding requires 24 hours.**

When the tape is used, the assembling time is shortened to 6 hours, because two panels can be glued at the same time. When the bonding time elapses, make openings for fittings and perform all necessary additional sawing and drilling. Drilling should be performed with surfaces secured with paper or protective film. If single-sided overlay panels are glued, glazing beads can be installed.

Note:

The thickness of the glue layer after the panel is glued to the leaf frame should not exceed 1 mm. The glue should be applied within 20 minutes of the moment of starting that activity. Place the overlay panel on the door leaf and level it in relation to other. This action should be performed within 10 minutes of ending application of glue. Pay attention for the panel not to slide on the wet glue.

If double-sided overlay panels are glued:

4. Gluing together the internal metal sheet and the XPS core

Apply drops of SIKAFLEX 221 glue of about 1 cm around the pane at intervals of 10 cm, 5 cm from the pane edge. Fill the remaining part of the XPS styrofoam with such drops of glue every 20 cm.



Gluing and sealing of the glazed part, if present:

For models with glazing with double-sided overlay panels, during gluing of the inner side, the gluing of the PANE + METAL SHEET surface also requires appropriate preparation. Each time, specialist layered acrylic tape of the appropriate thickness is prepared on the internal metal sheet supplied individually.



First, clean and degrease the pane thoroughly, preferably with an agent with a high alcohol content (denatured alcohol, industrial spirit). Then apply PRIMER included in the kit at about 1 cm from the pane edge, where the said tape is placed. The form of a pen enables the formulation to be precisely applied. Perform the action around the entire pane and on each of them (if there is more than one pane in a given model). The primer leaves a characteristic matt trace, so it is possible to verify whether it was applied precisely.



After the entire preparation process for gluing the overlay panels (the process described in paragraphs above), remove the protective layer from the tape just before gluing the internal part.

ATTENTION!!! Do not touch the tape and be careful not to contaminate it.



After the internal metal sheet is glued together with other components of the structure, press the glued surface evenly and strongly.



For this task, we recommend purchasing:

SMALL PRESSURE ROLLER

LARGE PRESSURE ROLLER



Use of clamps to maintain coplanarity.

