

BONDING INSTRUCTIONS FOR SINGLE- AND DOUBLE-SIDED ALUMINIUM OVERLAY DOOR PANELS USING A BASIC BONDING KIT.

The VEYNA basic bonding kit includes:

1. SOUDAL SOUDASEAL 650 HT adhesive cartridge, 290 ml
2. SOUDAL SURFACE ACTIVATOR adhesive primer bottle, 30 ml
3. SIKA PCA activator applicator sponge
4. Polyester matting fleece
5. STAUBFIX ULTRA electrostatic fleece
6. QR code for the digital instruction manual



Recommendations:

- 1) Protective packaging must strictly be used for transport.
- 2) The ambient room temperature where the entire process takes place must be within the range of 19–25°C. Relative air humidity must not exceed 50%.
- 3) The workstation must be properly prepared before unpacking. Clean the table of any adhesive residues, sand particles, filings, shavings, etc.
- 4) The bonding station must be stable and sized to match the dimensions of the door leaf. Glazing tables and trestles are not recommended.
- 5) The door leaf must be cleaned with compressed air and degreased. All machining/processing operations must be completed prior to the panel bonding process.
- 6) The protective packaging must be opened with caution. Cut the foil only on the sides, never from the front or bottom.
- 7) Pay special attention to additional accessories located on the packaging.
- 8) Retain the foam packaging corners for internal transport or potential reuse during subsequent shipping.

1) Preparation of the door leaf.

a. Preparation of the bonding surfaces on the outer side.

- Using the matting fleece (included in the kit), abrade the surface of the door leaf at the bonding area. The treated surface must be rough.
- Clean off the resulting dust with a damp cloth.
- Using the electrostatic fleece (included in the kit), remove electrostatic charges from the surface of the door leaf.

b. Application of the primer.

- Divide the applicator sponge (included in the kit) into four pieces. Then, soak one of the divided sponge pieces with the adhesive primer from the 30 ml bottle (included in the kit). Do not allow the product to drip from the sponge.
- Wipe the previously abraded surface of the door leaf with the soaked sponge.
NOTE: The product must be applied in a single pass and in the same direction. Do not rub or smear the product. The layer must be as thin as possible.
- Leave the door leaf to dry. Flash-off time is approximately 1–5 minutes from the completion of the application process.

2) Preparation of the overlay panel (outer side).

a. Preparation of the bonding surfaces.

- Using the matting fleece (included in the kit), abrade the surface of the panel at the bonding area. The treated surface must be rough.
- Clean off the resulting dust with a damp cloth.

- Using the electrostatic fleece (included in the kit), remove electrostatic charges from the surface of the panel.

b. Application of the primer.

- Use another piece of the divided applicator sponges (included in the kit). Soak it with the adhesive primer from the 30 ml bottle (included in the kit). Do not allow the product to drip from the sponge.
- Wipe the previously abraded bonding surface of the panel with the soaked sponge.

NOTE: The product must be applied in a single pass and in the same direction. Do not rub or smear the product. The layer must be as thin as possible.

- Leave the panel to dry. Flash-off time is approximately 1–5 minutes from the completion of the application process.

3) Application of the adhesive to the outer side of the door leaf.

- Before commencing the bonding process, purge approximately 5 cm of adhesive away from the door leaf.
- Apply SOUDAL SOUDASEAL 650 HT adhesive (included in the kit) in a zigzag bead, leaving a free clearance of approximately 2 cm. This provides adequate space for the adhesive to spread when pressed by the sheet and prevents any adhesive squeeze-out to the exterior of the structure.



- Apply the adhesive to all contact points between the profiles and the panel.
- Reduce the amount of adhesive applied around hardware openings/cutouts.
- Once the adhesive is applied, the entire bonding process for the respective side of the overlay panel must be completed within a maximum of 5 minutes.

4) Bonding of the outer side.

- Before starting the bonding process, check to ensure that hands have not been soiled during the adhesive application process.

- Place the panel onto the door leaf.
- Once the components are properly positioned relative to each other, gradually press the components together, starting from the top side of the door. Progressively transfer the pressure towards the bottom of the door. It is essential that the pressure is applied tightly, point-by-point, and in one direction only.
- To distribute the adhesive evenly, use a pressure roller. (Roller available for purchase. Details are available from the Veyna sales representative.)
- Apply screw clamps along the perimeter. It is imperative to use spacers covered with a soft material. Alternatively, weights can be used.

Note: During clamping, ensure that the components do not shift relative to each other on the wet adhesive.

- Clean any areas of adhesive squeeze-out using a soft cloth or a paper towel moistened with alcohol or extraction naphtha.
- The curing time of the adhesive is a minimum of 12 hours. If bonding is performed at a temperature lower than 19°C, the curing time may be extended.
- Handling the components, especially moving them, is strictly prohibited during the adhesive curing period.



In the case of bonding a single-sided overlay panel, the bonding procedure is complete.

5) Preparation of the door leaf with the bonded outer side.

- Proceed analogously to Step 1.
- If glazing is present: Degrease the glass surface with an alcohol-based agent (denatured alcohol, IPA alcohol).

6) Preparation of the overlay panel (inner sheet).

- Proceed analogously to Step 2.
- If glazing is present: Partially remove the red protective liner from the acrylic tape applied around the glazing cutout. Fold the ends into the cutout so that the remainder can be removed after positioning the sheet on the door leaf.

Note: Do not allow the tape adhesive to become contaminated. Touching the adhesive surface with fingers is strictly prohibited. Use disposable gloves.

7) Application of the adhesive to the inner side of the door leaf.

- Proceed analogously to Step 3.
- Apply Soudal Soudaseal 650 HT adhesive (included in the kit) in 2 cm dollops across the entire XPS surface
- at intervals of 15–20 cm.
- If glazing is present: Apply Soudal Soudaseal 650 HT adhesive (included in the kit) around the glass pane at a distance of approximately 5 cm from its edge, and in spots spaced approximately 10 cm apart.



- Leave the adhesive as dollops. Do not spread it over the surface.

8) Bonding of the inner side.

- Proceed analogously to Step 4.
- If glazing is present: The final stage of bonding the inner side is to remove the red protective liner located in the glazing cutout and to press the contact area together.

Important: The bonding process for any given side of the overlay panel must be completed within a single working day. Excessive breaks between operations may result in a weaker bond of the adhesive and the acrylic tape.