

BONDING INSTRUCTIONS FOR SINGLE- AND DOUBLE-SIDED ALUMINIUM OVERLAY DOOR PANELS USING AN ACRYLIC TAPE BONDING KIT.

The VEYNA acrylic tape bonding kit includes:

1. SOUDAL SOUDASEAL 650 HT adhesive cartridge, 290 ml
2. Acrylic tape, 12 mm x 0.6 mm – 11 m
3. SOUDAL SURFACE ACTIVATOR adhesive primer bottle, 30 ml
4. Acrylic tape activator bottle, 30 ml
5. SIKA PCA primer and activator applicator sponge – 2 pcs.
6. Polyester matting fleece – 2 pcs.
7. STAUBFIX ULTRA electrostatic fleece
8. QR code for the digital instruction manual

INSTRUCTIONAL VIDEO



Recommendations:

- 1) Always use protective packaging 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 acrylic tape activator

- Divide both applicator sponges (included in the kit) into four pieces each. Then, soak one of the divided sponge pieces with the activator 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, strictly along the outer edge of the door leaf. The application width must not exceed 15 mm (the width of the 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.

c. Application of the acrylic tape.

- Apply the acrylic tape wearing disposable gloves.
- Apply along the outer edge around the door leaf on all bonding surfaces.

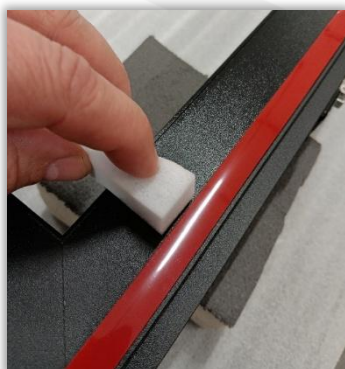
Note. Do not leave gaps in the corners; the tape sections must butt together tightly.



- In the event of an error, do not reapply tape that has been peeled off. It is very important to repeat the entire procedure, starting from abrading the surface (Step 1).
- Do not touch the adhesive side of the tape during application.

d. Application of the adhesive primer.

- Use another fresh 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 surface next to the applied acrylic tape strips 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. Do not allow the adhesive primer to come into contact with the applied acrylic tape.

- Leave the panel 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.

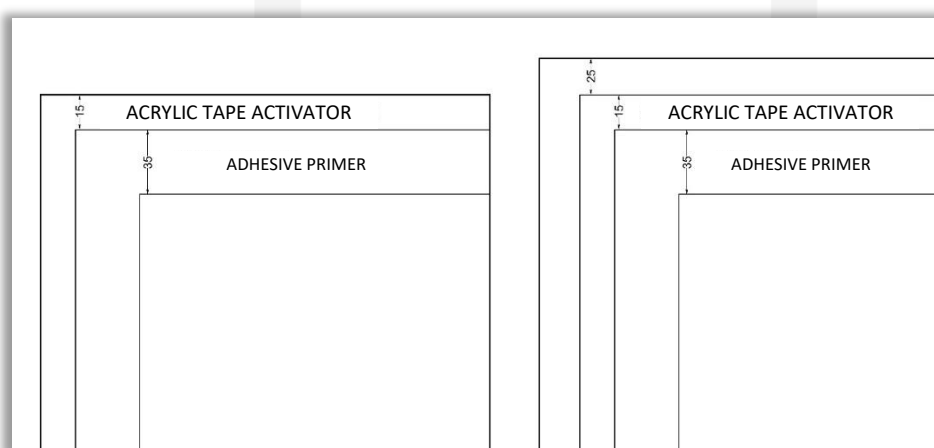
- Using the matting fleece (included in the kit), abrade the surface of the panel at the bonding area. The treated surface must be rough.
- Clean off the resulting dust with a damp cloth.
- Using the electrostatic fleece (included in the kit), remove electrostatic charges from the surface of the panel.

b. Application of the adhesive primer and acrylic tape activator.

- Mark the contact areas for the acrylic tape and the adhesive on the sheet.

Tip. On the smaller panel sheet, the contact area for the acrylic tape is located directly at the very edge. Therefore, apply the activator to the surface of the sheet up to a maximum of 15 mm from the edges. The adhesive primer is applied behind the tape activator, meaning its zone starts at 15 mm from the sheet edge and ends at 50 mm.

In the case of the larger sheet, leave approximately 25 mm of free surface from the very edge for the rebate. Start applying the activator 25 mm away from the edge of the sheet.



- Use another fresh piece of the divided applicator sponges (included in the kit). Soak it with the acrylic tape activator 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 within the designated areas.
- Apply the adhesive primer in a similar manner to the tape activator, within its respective designated zone.
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 within the free space next to the applied acrylic tape. When using the acrylic tape bonding method, the risk of adhesive squeeze-out to the exterior of the structure is very low.

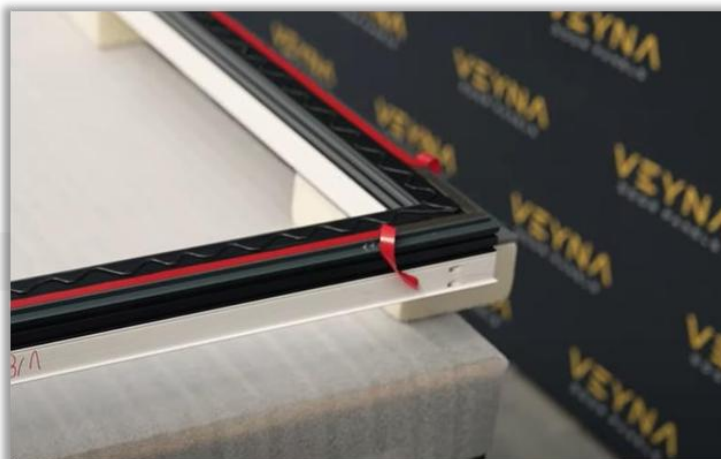


- Apply the adhesive to all contact points between the profiles and the panel.
- Reduce the amount of adhesive applied around hardware openings/cutouts.
- Once the adhesive is applied, the entire bonding process for the respective side of the overlay panel must be completed within a maximum of 5 minutes.

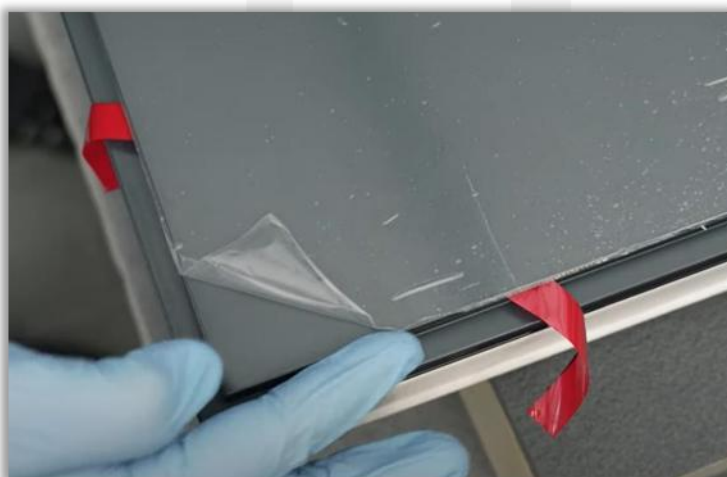
4) Bonding of the outer side.

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

- Peel back approximately 5 cm of the red protective liner from the acrylic tape and fold it outwards.



- Place the panel onto the door leaf and align it correctly.



- Once the components are properly positioned relative to each other, remove the protective liner by pulling it out. 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 may 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.