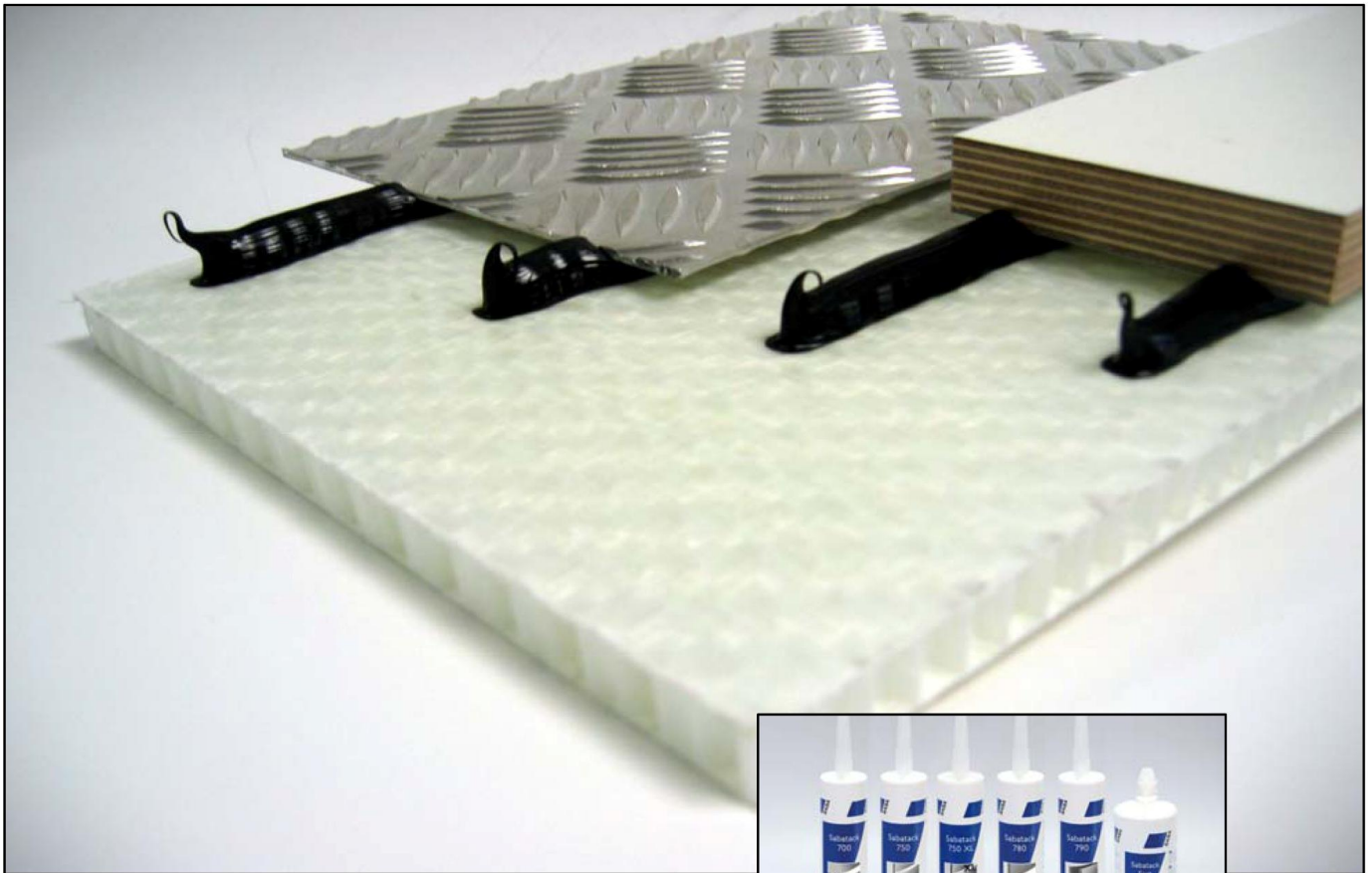




**Info sheet 253**

# Bonding of Monopan®

with Sabatack 700, 750 (XL), 780, 790 and Sabatack Fast





## 1. Preparation

### 1.1 MonoPan<sup>®</sup> (polypropylene), untreated

- Clean (with clean, lint-free cloth/rag) with SABA Cleaner 48. Observe drying time: minimum 5 minutes.
- Apply SABA Primer 4518 (with clean, lint-free cloth / rag or clean paintbrush). Observe drying time: minimum 15 minutes and maximum 30 minutes.
- If the second bonding surface is not MonoPan<sup>®</sup>, please refer to the SABA Transport Pre-treatment table.

#### Bonding/sealing with Sabatack

- Apply Sabatack to one of the two bonding surfaces.
- Press both bonding surfaces lightly together.
- Adhesive layer should be at least 2 mm thick.
- Affix until cured.

### 1.2 MonoPan<sup>®</sup> (polypropylene), painted

- Clean (with clean, lint-free cloth/rag) with SABA Cleaner 48. Observe drying time: minimum 5 minutes.
- Prime with SABA Primer 9002. Observe drying time: minimum 15 minutes.
- If the second bonding surface is not MonoPan<sup>®</sup>, please refer to the SABA Transport Pre-treatment table

#### Bonding/sealing with Sabatack

- Apply Sabatack to one of the two bonding surfaces.
- Press both bonding surfaces lightly together.
- Adhesive layer should be at least 2 mm thick.
- Affix until cured.



## Bonding an aluminium rail to untreated MonoPan®



Clean MonoPan® with  
SABA Cleaner 48



Pre-treat MonoPan® with SABA Primer  
4518



Activate rail with  
SABA Activator 9400



Apply Sabatack



Join parts



Done

## 2. References

- Safety Data Sheet Sabatack 700, 750 (XL), 780, 790 and Sabatack Fast
- Product Data Sheet Sabatack 700, 750 (XL), 780, 790 and Sabatack Fast
- SABA Transport Pre-treatment



## Appendix 1: SABA Research Report

### SABA Research Report

Testing summary of the bond strength of profiles on WIHAG MonoPan® material

#### Background

The aim of the tests was to determine whether it is possible to bond specific profiles on MonoPan® without the use of any mechanical mounting materials, like screws, bolts or nuts. Test pieces were made and tested independently to answer that question.

#### Tests

The materials were cleaned with SABA Cleaner 48 and the MonoPan® material was primed with SABA Primer 4518. The aluminium pieces were either pre-treated with SABA Activator 9400 or SABA Primer 9002 (depending on the type of MonoPan®). Then they were bonded with Sabatack 780.

The materials were then stored for several weeks to completely cure. After curing was complete, they were placed in the tension test machine. In testing, a cohesion fracture of the adhesive can occur. The pressure resistance value of the adhesive and the MonoPan® material are close together so that a material fracture of the MonoPan® is also conceivable. Please contact SABA directly for more information about the tests.

#### Test 01/1

