

I. Shelf Life & Adhesive Quality Checks

Verify that the product is within specified shelf life on the product label. All bulk and Cartridge products have guaranteed 9-month shelf life. Shelf life begins from date of shipment from MASTIKOL's manufacturing plants.

How to read shelf life:

- I.1.1. Locate the product label on the cartridge.
- I.1.2. Record the **Lot #** located at right below the MASTIKOL logo.



If the product is within the 9 month shelf life then proceed with the next quality checks.

- I.1.3. Remove the protective cap and visually examine the two apertures for any obstructions.

If there are obstructions, blockage should be removed.



bonding procedure

I.1.1.1. Load cartridge into dispensing gun, making sure the pistons are lined up with the push rod correctly (A). Then close the black locking cover (B).



(A)



(B)

I.1.1.2. Extrude (purge) a small amount material out of the cartridge until both materials have been dispensed and are level at the apertures. This is to ensure that the pistons are level in the cartridge to prevent inconsistent mix.



I.1.1.3. Insert the static mixer (provided with the cartridge) and twist to lock.



I.1.1.4. Well mixed adhesive should be black in color. The mixture should be smooth and uniform.



I.1.1.5. If a uniform color is obtained then the adhesive is ready for use. If not, repeat the cleaning and purging steps.



II. Bonding procedure laboratory & worksite

II.1. Remove any type of primer and paint through aggressive abrasion, then make the surface dry and perfectly clean. Use only tools (brushes/discs etc.) that do not participate in the pollution of construction materials by releasing residues, consumables must be made of stainless steel or inert material.



bonding procedure



II.2. The abraded area should be cleaned with MK-WIPES. The wipes motion should be horizontal and in one direction only to remove the abrasion residue.

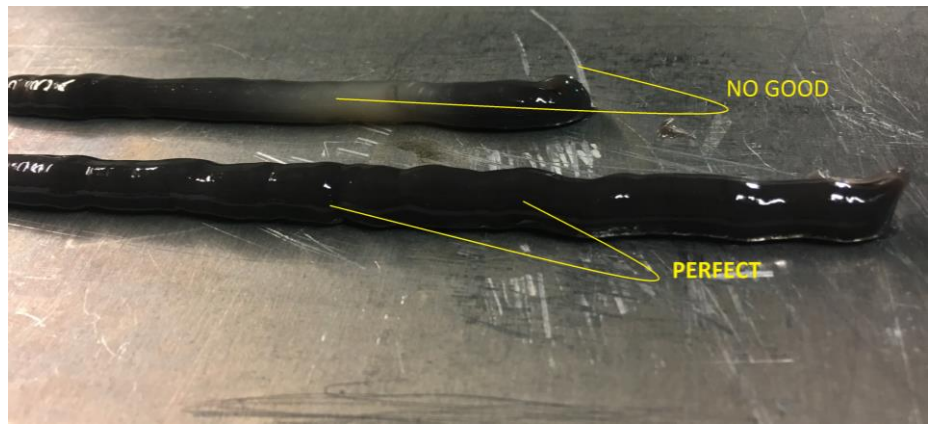


bonding procedure

II.3. Clean through MK-WIPES the Masterplate (metal component Harpoon)



II.4. Purge adhesive through the mixer nozzle to ensure a uniform black colour before application.



II.5. WARNING: ALWAYS CHECK THE HOMOGENEOUS COLOR BEFORE EACH APPLICATION.

II.6. Apply the adhesive in one mass to the center of the fastener plate ensuring enough adhesive is applied for it to be visible all around the edge of the fastener once it is pressed onto the surface



bonding procedure

II.7. In case of surfaces that can interact with the magnets:

Place the ring magnet along the tip until it comes into contact with the base of the harpoon without adhesive



In case of surfaces that CANNOT interact with the magnets:

Remove the protective film of the red Tape already prepared on the base of the component without adhesive



II.8. Push the fastener into its desired location. It is possible to slide the fastener slightly to reposition if needed, but the fastener should never be lifted from the surface and re-applied. Don't excess to disturb the adhesive to avoid reaction stop.



bonding procedure

ALLOW THE MAGNET TO ATTRACT THE BASE TO THE METAL WALL OR PRESS THE TAPE ON THE METAL WALL WITH FORCE RELEASE THE HARPOON



II.9. If the fastener must be removed and re-applied, then the adhesive should be cleaned off both the steelwork and fastener either using MK-WIPES if still wet or ground off if cured. In the case of already polymerized adhesive, remove it by means of a mechanical action with a tool that can separate it from the surface.

Steps 3-5 should then be repeated

II.10. Adhesive should be visible as "squeeze out" all around the Masterplate. This is to ensure good coverage.



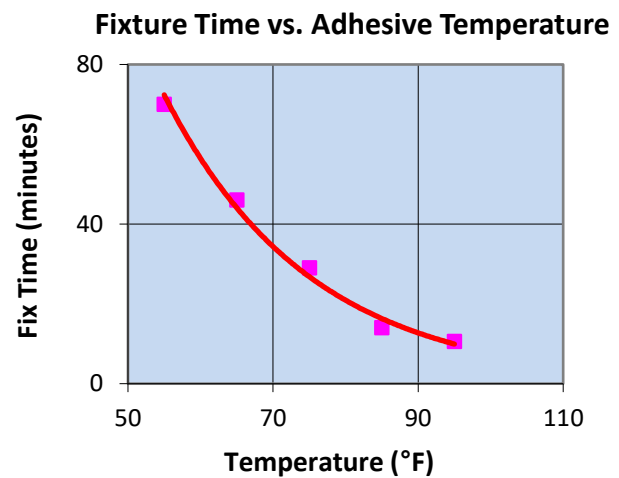
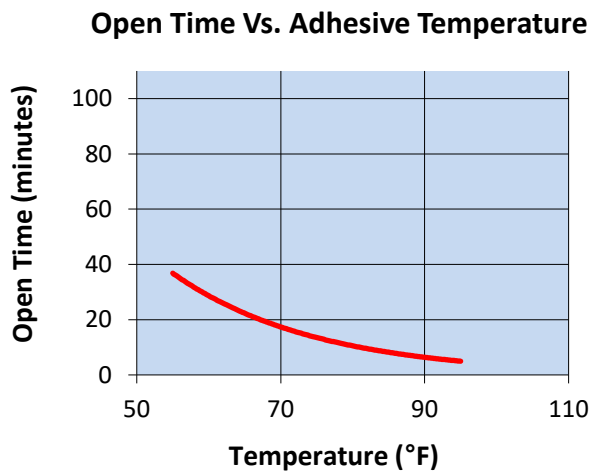
II.11. If the excess adhesive needs to be cleaned after joining for aesthetic reasons, this should be done while the adhesive is still liquid and while the fixing component is held in place so as not to disturb the bond.



II.12. The component must not be touched until the fixing time is reached. Please see the table below for the influence of temperature on the fixing time.

III. Cure profile as a function of Temperature

Temp (°F)	Temp (°C)	Open time (min)	Fixture time (min)
55	13	35	70
65	18	24	46
75	24	15	29
85	29	7	14
95	35	2	11



Condizioni di pericolo saldatura evitate e tempistiche di refitting ridotte





CONCLUDE THE SET-UP OPERATIONS ACCORDING TO THE PROCEDURES ONCE THE FIRST HARDENING OF THE ADHESIVE IS REACHED

RECOMMENDATIONS AND PRECAUTIONS ON THE USE OF PERSONAL PROTECTIVE EQUIPMENT

Technical measures: Make sure there is sufficient ventilation in the room. The floor of the storage room must be waterproof to prevent spillage of liquids.

Personal protective equipment must bear the CE mark which certifies their compliance with current regulations.

Respiratory protection: In case of exceeding the threshold value (e.g. TLV-TWA) of the substance or of one or more of the substances present in the product, it is recommended to wear a mask with a type B filter whose class (1,2, or 3) must be chosen in relation of use. (ref. standard EN 14387). If there are gases or vapors of a different nature and/or gases or vapors with particles (aerosols, fumes, mists, etc.), combined filters must be provided. The use of respiratory protection means is necessary in case the technical measures adopted are not sufficient to limit the exposure of the worker to the threshold values taken into consideration. The protection offered by the masks is however limited.

In the event that the substance in question is odorless or its olfactory threshold is higher than the relative TLV-TWA and in the event of an emergency, wear an open-circuit compressed air breathing apparatus (ref. Standard EN 137) or a self-contained breathing apparatus outdoor air (ref. EN 138 standard). For the correct choice of the respiratory protection device, refer to the EN 529 standard.

Hand protection: Always use waterproof category III work gloves (ref. Standard EN 374). For the final choice of the material of the work gloves it is necessary to consider: compatibility, degradation, breakage time and permeation.

Eye protection: Safety glasses. Make sure an eye wash is on hand. It is recommended to wear airtight protective goggles (ref. Standard EN 166).

Skin protection: Wear category I professional long-sleeved work clothes and safety footwear (ref. Directive 89/686/EEC and standard EN ISO 20344). Wash with soap and water after removing protective clothing.

(ALWAYS REFER TO THE RELEVANT SAFETY DATA SHEETS OF INDIVIDUAL PRODUCTS DISTRIBUTED AND/OR AVAILABLE ON REQUEST)

