

Knowhow

Processing instructions for dry glazing of wood and wood-aluminum windows



Please note:

- Work surface**
 - The workplace should be as clean and dust-free as possible
 - Materials (incl. adhesive tape) should correspond to the ambient temperature (not <15°C)
- Surfaces**
 - We recommend testing the suitability of the tape on painted or primed surfaces before hand
- Workplace**
 - The bonding of the wood/wood-aluminum window can be installed both horizontally and upright

1. Clean the frame



- Cleaning of the wood frame to be bonded
- tesa® 60040 industrial cleaner or isopropanol, lint-free clean cloth
- Clean until there is no visible residue on the cloth.
 - Change the cloth at regular intervals.
 - Clean in one direction only and avoid back and forth movements.

2. Roughen / clean the frame



- Roughen the frame to be bonded*
- Abrasive fleece (e.g. Mirlon abrasive fleece with at least 150 grit)
- When roughening the surfaces, the coating must not be removed completely.
 - Clean up the dust from sanding.
- After roughening, the surface has to be cleaned again (see point 1)

* No roughening of the raw wood surfaces

3. Prime the frame



- Pre-treatment of the frame to be bonded
- tesa® 60153 Adhesion Promoter Fast Cure (bonding agent)*
Application aid: melamine resin sponge
- Avoid direct skin contact with bonding agent and use gloves
 - Flash-off time of 30 sec – 5 min. before bonding.
 - UV light can be used to check application.
 - After the flash-off time, the adhesive tape should be applied as soon as possible.
 - Observe the safety instructions on the on the packaging.

* We recommend testing the suitability of the bonding agent on the surface beforehand

4. Apply adhesive tape



- Defined and bubble-free bonding application of the adhesive tape to the window frame:
To optimize the tightness the corners should be tape dover and then cut to joint
- tesa® ACXplus 707x High Resistance
Application aid:
tesa® 6040 PV21 Lamination Tool
- Wrinkle-free and bubble-free bonding of the surface.

5. Clean the glass



- Cleaning of the glass to be bonded
- tesa® 60040 industrial cleaner or isopropanol, lint-free clean cloth
- Clean until there is no visible residue on the cloth.
 - Change the cloth at regular intervals.
 - Clean in one direction only and avoid back and forth movements.



Application video available at:
www.tesa.com/en/industry/building-industry/windows



Activity



Materials, auxiliary materials



Important check

tesa.com


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6. Prime the glass



 Priming the glass surface to be bonded


 tesa® 60151 Adhesion Promoter Glass
Application aid: 2x lint-free clean cloth

-  • Avoid direct skin contact with Adhesion promoter use gloves.
- Apply primer with one lint-free cloth and wipe off the primer with a second lint-free cloth, immediately after application.*
- Bonding must be completed within the next 5 minutes after priming.
- Observe the safety instructions on the packaging.

* watch application video


7. Positioning




 Remove the liner

- With upright application the liner is to take off completely over the entire length.
- Alternatively (e.g. for horizontal application method), the liner can be bended of at the corners to a length of approx. 10cm. Removing the liner at the corners after the final positioning of the glass pane.




 Insert the glass blocks at the corners and on the lower profile of the window frame



 Positioning the glass surface:


- Initial alignment on the bottom edge of the frame profile.
- Carefully slide in.*


-  • Careful positioning of the glass surface at the lower window edge. Avoid delamination of the adhesive tape.


* Alternatively: for horizontal application the positioning and blocking should be carried out. The liner should then be removed at the corners

8. Applying pressure




 Pressing the glass panel on to the window frame profile

 Manual or pneumatic pressure tools, e.g.: tesa® 6003 Pressure Roller

-  Full-surface wetting (bonding of adhesive tape and surface) is achieved with a contact pressure of 10 N/cm² to the tape area.

9. Storing / Transportation



 After pressing on, the glazing beads or the cladding should be attached

The window can be transported or stored now