

Adhesive Bonding Guide

15th June 2021

To Whom It May Concern:

1. Cut the profile to the desired length using a sharp knife in a meter block or similar.
2. Clean the ends of the extrusion with acetone or alcohol and allow to dry thoroughly (10-15 minutes). Do not clean with white spirit or a similar chemical this will leave an oily residue, which will not bond.
3. Apply a small amount of a good quality Silicone adhesive such as Wacker E41 or E43 to one end of the extrusion and spread the adhesive onto both ends of the cord/profile. Do not use a low-cost silicone adhesive from a DIY merchant as these tend to be highly filled sealants rather than pure adhesives.
4. Place into a jig that is slightly smaller than the extrusion in order for it to have some grip to hold the profile and push the ends together in such a way that there remains some pressure on the joined ends.
5. Allow the bond to cure for at least 24 hours, longer if the section is above 20mm. The bond strength continues to improve over a seven-day period.
6. Remove the cord/profile from the jig and carefully trim any surplus adhesive with small scissors or a scalpel blade. If you have the facility to grind off the surplus adhesive with a powered sanding disc or belt this will usually leave a better finish.
7. The finished bond using RTV silicone adhesive leaves a reasonable bond, remains flexible and the jointing material typically withstands the same temperature and compression forces as the extruded cord/profile itself.