

Manufacturing / Procedure

FNHA-4-C-001.00

ADHESIVE APPLICATION**1. SCOPE**

1.1 This specification shall describe the procedure which is required for the application of specific adhesive 86050025 (FNHA-2-E-001.00) and primer 86509008 (FNHA-2-E-001.50).

1.2 This specification may involve hazardous materials, procedures, and apparatus. This specification does not address the health and safety problems associated with its application or use. It is the specifications user's responsibility to follow appropriate health or safety practices and to determine the application or regulatory limitation before use.

2. RELATED SPECIFICATIONS

86050025(FNHA-2-E-001.00) - ADHESIVE -
WINDSHIELD GLASS

86509008(FNHA-2-E-001.50) - ADHESIVE-
WINDSHIELD PRIMER

3. SAFETY

The MSDS's for both primer (N000169) and adhesive (N000150) should be reviewed prior to the establishment of any procedure for the application of the subject products to assure that all safety precautions may be taken.

THE FLOOR AREA WHERE BOTH PRIMER AND ADHESIVE ARE APPLIED SHOULD BE WELL VENTILATED.

Avoid contact with skin, eyes, and clothing. Wear suitable protective clothing. Avoid breathing vapors.

3.2 Primer 86509008 (FNHA-2-E-001.50)

3.2.1 SUBSTRATE

3.2.1.1 The substrate surface to be coated with the primer shall be clean, dry, and free of oil and grease or any foreign material. A solvent may be used to remove the oil or grease. Care should be taken if alcohol or alcohol based solvents are used. Time should be allowed to let the surface dry completely prior to applying the primer because alcohol should not come in contact with the primer.

3.2.1.2 If the joint contains old sealant, it must be removed. The substrate should be cleaned by mechanical means.

3.2.2 APPLICATION**3.2.2.1 TEMPERATURE**

The temperature of application shall be between 4°C (40°F) and 38°C (100°F).

3.2.2.2 MIXING

Prior to opening the primer container, it shall be agitated well by shaking to assure the mixing of the primer.

3.2.2.3 APPLICATION

The primer shall be applied with either a rag, dauber, brush, or spray. A thin uniform coat shall be applied to the surface where the primer is required. When opening a container all the compound shall be used within an eight (8) hour period. If the compound appears to be gelling, do not use. do not reseal an open container because it will gel due to the exposure to atmospheric moisture.

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3.2.2.4 DRYING TIME

The typical drying time before installing sealant at 23°C (74°F) and at 50 % R.H. is between 1 hour to a maximum of 8 hours. If the primer has not been covered with an adhesive within the 8 hour period a new layer of the primer is required.

3.2.2.5 COVERAGE

The coverage for a 473 ml container is approximately 2.4 to 4.8 m² (26 to 52 ft²).

3.2.2.6 LIMITATIONS

The compound should not be applied on a frozen surface or through standing water. Compounds should not be applied over surfaces which have silicones or in the presence of curing silicones. The compound should not come in contact with alcohol or with alcohol containing solvents during curing.

3.3 Adhesive 86050025 (FNHA-2-E-001.00)

3.3.1 APPLICATION

3.3.1.1 TEMPERATURE

Apply the adhesive in the temperature range of +20°C (68°F) to +45°C (113°F).

3.3.1.2 APPLICATION

Apply the adhesive to the pretreated surface in a suitable bead. Make sure that the pretreat process had occurred long enough ago (at least 1 hour) to assure it's cure.

3.3.1.3 MATTING

Mate the two surfaces with the adhesive together and apply a gentle load.

3.3.1.4 CURE TIME

The cure time to develop a tack-free film is about 20 minutes at 23°C (74°F) and 50 % relative humidity. A 4mm (0.16in) bead will completely cure within 24 hours.

3.3.1.5 CLEAN UP

Immediately after the two surfaces have been fitted together the adhesive should be tooled to assure full contact without gaps. If required another bead of adhesive may be placed around the edge and tooled into a full seal. Excess adhesive may be removed by immediately mechanically wiping or wiping with mineral spirits. Cured adhesive material can only be removed mechanically.

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