Instructions for RC pane bonding on PVC windows

blaugelb RC Adhesive can be used to bond transparent and non-transparent infill panels of burglary-resistant windows and doors in accordance with RC2.

Observe the relevant standards and guidelines as well as the state of the art. This applies to extracts from the following standards and guidelines:

- DIN EN 1627, EN 1628, EN 1629 and EN 1630
- DIN 18545 Sealing of glazing with sealants
- Technical Guideline No. 3 from the Glaserhandwerk (Glazing Trade)
- ift guideline DI-01/1 The usability of sealants
- ift guideline DI-02/1 The usability of sealants Part 2
- ift guideline VE-05/01 Proof of the compatibility of glazing blocks

Test reports are available in the download area of the blaugelb RC Adhesive at:
www.blaugelb.de

No liability for printing errors accepted.

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Please read these installation instructions carefully before commencing installation.

01 Clean the glazing rebate as well as the pane edge seal using blaugelb Cleaner IPA 10.

Cleaning of the glazing rebate

Cleaning of the edge seal

02 Protruding secondary seal of the edge seal must be removed mechanically.

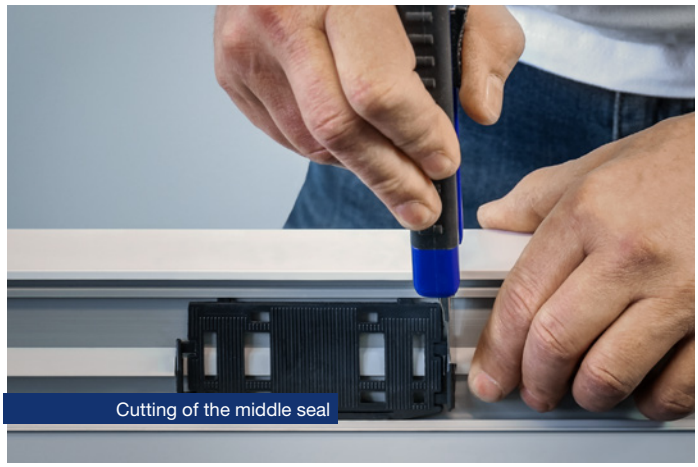
Removal of the protrusion

03 All stickers that can affect the bond must also be removed.

Removal of stickers

04 Position the glazing bridges around the edges and insert the bottom load-transferring glazing blocks. With middle seal systems, cut the middle seal at the glazing bridges so that this can be lined up with the pane edge seal. The middle seal performs the function of the backfill cord in this case.

Insertion of the glazing bridge



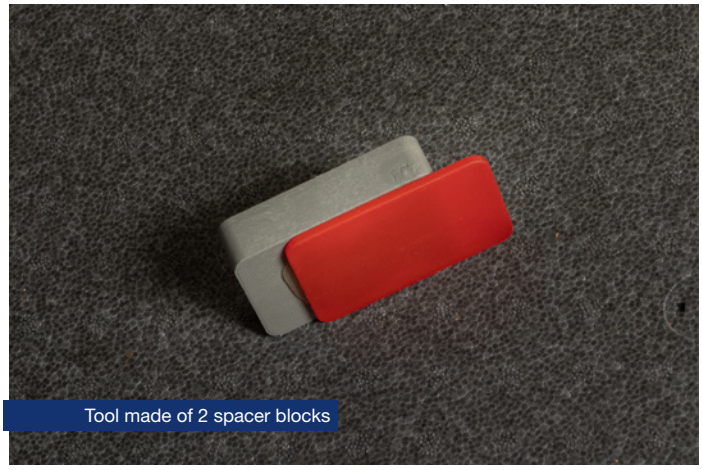
Cutting of the middle seal

05 Insertion of the pane according to glazing guidelines, including blocks as per the system specifications. The safety glass (at least P4A) can be installed on both the room side and the weather side. Deviations resulting from independent tests must be observed.

Insertion of the pane

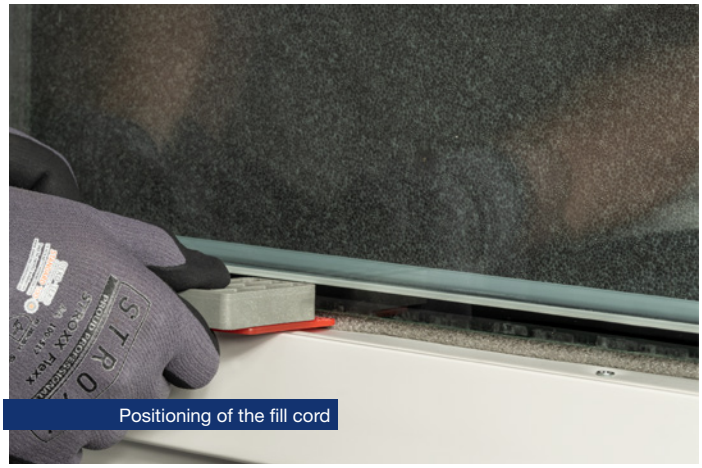
Bottom load transfer

06 If the safety glass is positioned on the room side, a backfill cord is required to limit the amount of blaugelb RC Adhesive applied. A tool is required to position the backfill cord as the safety glass must be bonded along the entire pane thickness.



Tool made of 2 spacer blocks

Application of the fill cord



Positioning of the fill cord

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07 Adjust the nozzle to the size of the rebate area by flattening it with pliers to insert the blaugelb RC Adhesive across the entire pane thickness. The following must be observed: Edge clearance ≥ 5 mm.

Adjustment of the spray nozzle

08 Moisten the rebate area with water.

Initial moistening of the joint

09 Fill the adhesive in the rebate area using a battery-powered or compressed-air gun. To speed up the curing process, we recommend applying several layers of the blaugelb RC Adhesive while adding water (moistening in between with a spray bottle).

Applying the first adhesive layer

Filled joint

Interim moistening of the bond

Applying the final adhesive layer

Curing speed without moistening = 3 mm/24 h. Cavity-free (bubble-free) filling of the rebate area must be ensured to eliminate any risk of moisture accumulation.

10 After applying all of the blaugelb RC Adhesive, it must be moistened again with water. The rebate area must not be filled completely. There is a risk of moisture accumulation which affects the secondary edge seal.

Final moistening of the bond

There is no need to smooth the blaugelb RC Adhesive, but any protruding, disrupting adhesive (glazing bead) must be removed immediately. Adhesive residues on visible surfaces can be easily removed with blaugelb Cleaning Wipes (item no. 241602) when fresh.

11 Insert the glazing beads.

Application of the glazing beads

Note: The window should be placed in a resting support directly after completion. This results in a homogeneous full cure of the adhesive without hairline cracks. The time to be spent in the resting support is a direct factor of: pane thickness, rebate area clearance, ambient temperature and ambient humidity.

Please also note the technical data sheet.

Technical data:

Material base:	1C hybrid polymer
Colour:	Black
Curing system:	Polymerisation by atmospheric humidity
Building material class: **DIN 4102-1**	B2
Curing speed: at 23 °C and 50 % RH	Approx. 3 mm / 24 hrs.
Skin formation: At 23 °C and 50 % RH	Approx. 6 minutes
Density: **DIN 53479**	1.50 g/ml
Shore A hardness: **DIN 53505**	55 +/- 5
Max. permissible deformation:	20 %
Change in volume: **DIN EN ISO 10563**	Approx. -4 vol. %
Tensile stress value at 100 % elongation: **DIN EN ISO 8339**	2.3 N/mm²
Tensile strength: **DIN 53504**	3.6 N/mm²
Tensile shear strength: **DIN 53504**	1.5 N/mm²
Modulus of elasticity 100 %: **DIN EN ISO 8339**	2.4 N/mm²
Elongation at break: **DIN 53504**	400 %
Elastic recovery: **ISO 7389-B**	> 75 %
Solvent content:	Free
Isocyanate content:	Free
Processing temperature:	Ambient: 0 °C to +40 °C Substrate: 0 °C to +35 °C
Temperature resistance:	From –40 °C to +90 °C
Moisture resistance:	Waterproof
Ecological report:	EMICODE EC1 Plus
Overpainting:	Very good coatability according to DIN 52452-A1, can be painted over wet-in-wet
Storage life:	12 months in unopened pack at +5 °C to +25 °C
Delivery form:	600 ml tubular bag

Expert. Honest. Reliable.

For more information, visit
www.blaugelb.de

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