General instructions for use

Correct use, treatment and processing of Holonite products will result in a strong adhesion with the surface.
The instructions set out below apply for all products and must always be observed together with the product-specific instructions.

Holonite adhesive/sealant
A special Holonite adhesive/sealant (Holonite B/S) has been developed to enable optimal use of Holonite products. Used in accordance with the instructions for use and in combination with Holonite primer, this adhesive/sealant guarantees optimal adhesion and sealing of expansion joints. The Holonite adhesive/sealant is intended for joints that allow for expansion of the parts joined without distorting. The surface on which the adhesive/sealant is to be used must also be taken into account. Holonite adhesive/sealant has been developed for gluing stone-like materials. Holonite products must never be applied directly onto bitumen, EPDM or other foils. Neither is it always possible to apply Holonite products to wood or plywood. We would be happy to advise you on how best to apply Holonite products to other materials/surfaces.

Processing of Holonite products

Pre-treatment
Both the Holonite products and the surface they are to be applied to must be clean, dry and free of dust or grease. The ambient temperature should be at least 5°C. Thoroughly degrease the product surfaces to be glued and sealed using Holonite cleaner. Make sure that the products are at an angle so that any excess fluid can drain off, and use a block brush or similar brush and a processing tray (to avoid risk of pollution, never use cleaner directly from the can).

Priming
Allow the cleaner to dry (minimum of 15 minutes and maximum of 4 hours) and then treat the surfaces of the Holonite products to be glued and sealed with Holonite primer. The Holonite primer table shows which primer should be used for certain surfaces. Once again, use a block brush or similar brush and a processing tray.

Bonding
Apply a spacer (e.g. foam tape) to the surface to ensure a consistent minimum layer of 3 mm adhesive between the surface and the Holonite product. Apply the Holonite adhesive/sealant (B/S) to the surface in continuous grooves using the V-shaped nozzles. Always apply the adhesive vertically. Position the Holonite products within the time it takes for the glue to form a skin (maximum of 5 minutes) and press firmly into the adhesive to ensure the adhesive spreads evenly.
The adhesive/sealant has elastic properties to absorb tension due to expansion and shrinkage. When installing the products, allow sufficient clearance between the various elements, determining the clearance according to the length of the element concerned.

Sealing expansion joints
During installation of Holonite products, it is important to take the expansion coefficient of 35 x 10-6 [1/°C] (= approx. 2.5 mm/m1) of Holonite into consideration.
When positioning the Holonite products, maintain the appropriate mutual expansion joint widths between the various elements

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and between the elements and any structural ends. For outdoor applications this should be at least 1% of the length of the element with a minimum of 6 mm on either side. So a product of 2000 mm, for example, would require a total of 20 mm expansion joint, 10 mm on either side.
For indoor applications this should be at least 0.5% of the length of the element with a minimum of 4 mm on either side.

Tightly fill the expansion joint with open-cell PU back-filling. Note: sealant joints between Holonite products must not be too deep. The depth of sealant joints less than 10 mm wide must not exceed the width of the joint. The depth of sealant joints of at least 10 mm wide must not exceed 2/3 of the width of the joint. Evenly fill and seal the joint with Holonite adhesive/sealant, avoiding any air bubbles. Finish the joint sealant within the time it takes to form a skin (maximum of 5 minutes) using a spatula wet in a neutral soap solution.

Expansion joints should preferably not be created if the ambient temperature is high or likely to rise rapidly due to direct or continuous sunlight.