

GLUKON<sup>®</sup>farm was specially developed for bonding PE, PP and PA films with a wide range of materials.

GLUKON<sup>®</sup>farm is applied to both sides of the overlapping film (approx. 50 cm). After roughly 60 seconds the films can be bonded together, or minor film repairs can also be performed.

GLUKON<sup>®</sup>farm can be applied on one side and also used for fixation, e.g. as an assembly aid when applying the side wall film.

Your advantages when bonding silage film with GLUKON<sup>®</sup>farm:

- 1. TIME SAVINGS**  
Additional weighing down with foil overlapping is superfluous
- 2. FILM SAVINGS**  
Due to narrow film overlaps
- 3. IMPROVED SUBSTRATE PROTECTION**  
Due to reliable and airtight film bonding

## MATERIALS

GLUKON<sup>®</sup>farm has been specially developed for the bonding of PE, PP and PA film and is used in the field of silage film bonding and repair bonding. GLUKON<sup>®</sup>farm bonds a range of materials including: PE, PP and PA film, rubber, glass, concrete, painted steel, wood, polystyrene, etc.

## FEATURES

- + Adhesive is applied quickly and easily
- + Pressure-sensitive contact adhesive
- + Flexible adhesive joint
- + Offers good film bonding with a low contact pressure
- + Mobile, ready for immediate use without power or compressor
- + Spraying method: Web spray
- + Flash-off time: approximately 60 seconds depending on ambient temperature/humidity
- + Open time: approx. 4 hours

## TECHNICAL DETAILS

- + Description:  
Solvent-based sprayable pressure-sensitive contact adhesive
- + Colour: Transparent-yellowish
- + Solid content: approx. 27 %
- + Temperature resistance: from approx. -20°C to approx. 65°C
- + Shear strength: >80psi
- + Coverage per 13 kg pressurised container:  
approx. 100 m<sup>2</sup> (applied on both sides),  
tin 500 ml: approx. 3 m<sup>2</sup>
- + The cured adhesive is not flammable

## INSTRUCTIONS FOR USE

The substrate must be dry and free of dust and grease. Remove dirt such as concrete, cement or paint residues. Cover adjoining surfaces. Application temperature 5 - 25 °C (container/can temperature). GLUKON<sup>®</sup>farm should not be applied at temperatures below -10°C (ambient/material temperature)! With first use connect the hose and gun to the container. Then slowly open the container valve and check the system is leak-tight. The system is now ready for operation. To apply the adhesive, hold the gun approx. 10 cm (hand width) above the application surface. The rule of thumb for correct application here is: Spray jet width = distance between the spray gun and materials. Apply the adhesive evenly. Avoid puddles of adhesive (solvent build-ups).

### Application of permanent contact adhesive

With the permanent bonding of two films, the adhesive is applied to both bonding surfaces (application quantity approx. 35 - 70 g/m<sup>2</sup>/wet), leave to dry for approx. 1 minute until the solvents have completely flashed off! The open time is approx. 4 hours. Once the adhesive has flashed off, connect both surfaces together and rub with a soft brush to ensure a good and long-lasting bond. Loads can be applied to bonded materials immediately. It takes about 24 hours until the adhesive is completely cured.

### Use for fixation

If the adhesive is used as a pressure-sensitive adhesive it must be applied to the least absorbent material on one side only, and after it has flashed off it can be used as an assembly aid when applying side wall film for example. **Important: Not final bonding strength!**

Lock the spray gun after use. The valve on the adhesive container must **NEVER** be closed unless the container is being replaced with a new one or it is closed for transport to the site of use. Please use Glukon Citrus Cleaning Spray for removing adhesive residues from surfaces. Before use, please read our Glukon instructions for use (enclosed with the container), which are also available to download from: [www.glukon.de](http://www.glukon.de)

### Important information:

**Do not use GLUKON<sup>®</sup>farm for bonding plasticising materials such as PVC, CV coatings, vinyl and artificial leather!**

**Please note: In order to avoid spraying the adhesive onto the silage, make sure the film is arranged without gaps or with a slight overlap.**

#### APPLICATION CHECKLIST

- + Does the selected adhesive match the requirements profile and the intended site of use?
- + Are the materials to be bonded dry, clean and free of dust and grease?
- + Do the application temperatures of the adhesive, the materials and the environment fall inside the permissible parameters (15 - 25 °C)?
- + Are you sufficiently familiar with how to apply the adhesive? Distance between the spray gun and the film, spray jet width and spraying speed?  
Please visit our website: [www.glukon.de/anwendung](http://www.glukon.de/anwendung) and watch our application video for further information.
- + Do you know the respective flash-off times and open times for the adhesive to be used? These must be adhered to!
- + Are the materials free of tears or similar damage?
- + Has the work process been thought through? Can dirt be ruled out when applying the adhesive?
- + Is the system ready to use? Is the product well shaken? Gun with lance and nozzle should spray without problem.
- + Is the correct nozzle being used? Please only use our Glukon standard nozzle with our web spray adhesives.
- + Are pressure-application tools to hand, e.g. brush?
- + Is health and safety ensured?

#### HEALTH & SAFETY / SAFETY INSTRUCTIONS

- Processing must only be performed by competent individuals.
- Personal protective equipment should be worn when working with the Glukon spray adhesive system.  
Please also be sure to observe our safety data sheets in this regard!
- Good ventilation of the workplace/site must be guaranteed or ensured by means of suitable technical measures (e.g. explosion-protected extraction unit or stationary extraction)
- With insufficient ventilation or incorrect use there is a risk of an explosive gas/air mixture forming! This results in a danger to life! The formation of naked flames and excessive heat (+50 °C) must be avoided in general!
- The vessel is pressurised and must be protected against damage (e.g. valve being struck off, being dropped, the effects of heat, etc.).
- Never forcibly open full containers or containers that have not been completely emptied! Risk of explosion!
- The safety data sheets are available to download at: [www.glukon.de](http://www.glukon.de)

#### STORING AND HANDLING THE GLUKON<sup>®</sup>CONTAINER

Must be stored at a temperature between +10 °C and +50 °C. The container is under pressure. Protect containers from direct sunlight and heat sources. Do not store on a cold concrete floor. Avoid damage to the container or penetration by foreign objects. The containers may not be refilled! Transport containers in an upright position and secure against shifting/toppling. Close container valve when transporting. Protect containers from rain. Handle containers carefully. Do not throw or drop. Only store in well-ventilated rooms. Containers showing damage from the outside, such as dents or

valve damage, are to be disposed of professionally. Do not stick objects in the spray head! Please also refer to the safety datasheet (Point 7 and Point 14) for our GLUKON<sup>®</sup>containers! GLUKON<sup>®</sup> can be stored under the recommended conditions for at least 18 months.

**ATTENTION! SHAKE/ROLL THE CONTAINER WELL FOR AT LEAST 1 MINUTE BEFORE FIRST USE AND IF NOT USED FOR EXTENDED PERIODS. PROTECT FROM FREEZING. ENSURE THE CORRECT TEMPERATURE WHEN WORKING! (min. +15°C).**

#### DISCLAIMER

We always recommend trying the adhesive on your materials first. Please refer to our technical leaflets and the adhesive recommendations of the respective material manufacturer. It is important to test all materials to be bonded before production. The person using the product is responsible for checking whether **GLUKON<sup>®</sup>farm** is suitable for the respective application. **Industrial adhesive. Exclusively for commercial applications.**

The above details are based on results in practice and tests undertaken by us. As we have no influence on the choice of materials or the conditions of use, all details are non-binding information and, as such, no guarantee of characteristics. This also applies to instructions from our technical advice service. Publication of this technical leaflet renders all previous ones invalid.

The contents of this datasheet may only be reproduced, copied or used for other purposes as extracts with the consent of Bölker Sprühklebersysteme GmbH. Breaches will be prosecuted under criminal law.