



GLUKON<sup>®</sup>pebble sea is a sprayable contact adhesive that has been specially developed for use in ship interiors, yacht building, boat building, etc. GLUKON<sup>®</sup>pebble sea is suitable for bonding HPL with materials used in ship interiors such as Cape Marine Boards, SUPALUX, promat: Cape Marine Boards, SUPALUX, promat MASTER BOARD, expanded glass panels, ALU honeycomb (sand with 80 grit here). It is also possible to bond these materials together. For further material recommendations, please refer to our technical data sheet. GLUKON<sup>®</sup>pebble sea is used wherever the highest demands are placed on the surface quality of the bond.

- + The spray adhesive satisfies the requirements of the French VOC regulation for class A+
- + The spray adhesive is MED-certified and fulfils the requirements for low flammability according to IMO Resolution MSC 307 (88) - (FTP Code) Annex 1, Part 5



## MATERIALS

GLUKON<sup>®</sup>pebble sea bonds a range of materials including: High-gloss HPL, furniture linoleum, plywood, multiplex, chipboard, décor chipboard, MDF, glass, cork, wood, almost all types of plastics, rubber, wall coverings, concrete, metal sheets, textiles, painted steel, etc.

## FEATURES

- + Adhesive is applied quickly and easily
- + Mobile, ready for immediate use without power or compressor
- + Spraying method: Pebble-Spray
- + Flash-off time: min. 5 minutes depending on ambient temperature/humidity
- + Open time: approx. 4 hours
- + The cured adhesive is not flammable
- + **Dichloromethane-free**

## TECHNICAL DETAILS

- + Description: Solvent-based sprayable contact adhesive
- + Colour: Transparent, whitish
- + Solid content: approx. 30 %
- + Resistance to temperature: approx. 100°C (brief period)
- + Shear strength: >150 psi
- + Coverage per 13.9 kg in the pressure container: approximately 90 - 110 m<sup>2</sup> (application on both sides)

## INSTRUCTIONS FOR USE

Before every job, it is necessary to check whether the selected adhesive is suited to the requirements profile of the materials used and the intended site of use!

The materials must be conditioned with each other before bonding or have a material moisture/temperature adapted to the final installation location (24/48 h). The materials to be bonded must be dry, clean and without dust, grease and cracks. Use only acetone for de-greasing or isopropanol in the case of sensitive surfaces (e.g. plastic or Plexiglas). The suitability of the selected cleaner should be checked for compatibility beforehand on a non-visible surface. For optimum bonding, metals and smooth surfaces must be cleaned and degreased with a lint-free cloth. Then roughen the materials by cross-grinding with sandpaper (recommendation: aluminium oxide, 100 grade). After that, degrease the materials once again.

To ensure optimum results, the adhesive should be used at temperatures of 15 - 25° C (ideally 20° C). This also applies to the materials to be bonded.

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.

Hold the spray gun approximately 20 cm above the surface to be treated. Apply the adhesive evenly in slightly overlapping lines. Always avoid puddles of adhesive (solvent accumulations)! Always apply the adhesive evenly, crosswise to both sides to be bonded (surface 1 vertically, surface 2 horizontally). Application quantity approx. 23g/m<sup>2</sup>/dry. Double application is recommended around edges or on very absorbent substrates, e.g. block board or plywood. This is **essential** with moulded bonding. Material joints that will be exposed to moisture or water after bonding, must be protected by the construction or by using a suitable adhesive or sealant (MS polymer or PU adhesive). Allow the adhesive to dry for min. 5 minutes until the solvents have flashed off completely (finger test). Compliance with the flash-off time is extremely important and must be **precisely** observed! The open time is approx. 4 hours. In order to

align large format surfaces better, spacers (e.g. dowel rods or spacer strips) can be used on the carrier material. Now the materials can be placed. They must be free of bubbles as it will not be possible to shift the materials afterwards! This is best done by carefully rubbing from the centre outwards. Then press/roll the materials together firmly (contact pressure approx. 2.5 - 3 kg/cm<sup>2</sup>). **High contact pressure is essential for optimum bonding!** The materials can be further processed immediately. It takes about 24/48 hours until the adhesive is completely cured. Therefore, bonds that will be under stress should remain braced during this time. 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 construction site. Please use Glukon Citrus Cleaning Spray for removing adhesive residues from surfaces. Please use the **GLUKON<sup>®</sup> pebble nozzle** exclusively. The **GLUKON<sup>®</sup> standard nozzle** is **NOT** suitable for the Pebble-Spray! 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: Solvent-based coatings, such as oils, waxes, NC lacquers, etc., could attack the adhesive and are therefore not suitable for coating with bonded materials! Depending on the raw material base, some cleaning agents may also attack the adhesive and for this reason avoid directly spraying onto the adhesive joints when cleaning soiled surfaces. Recommendation: Do not apply the cleaning agent directly to the workpiece, but rather apply it to a lint-free cloth and clean the surfaces with this. GLUKON<sup>®</sup>pebble sea is not suitable for bonding: PE, PP, polystyrene and plasticised materials such as PVC and CV coatings, vinyl and artificial leather!**

#### APPLICATION CHECK LIST

- + Does the selected adhesive match the requirements profile and the intended site of use?
- + Are the materials to be bonded correctly acclimatised (at least 48 hours) or adjusted to the prevailing climatic conditions at the place of installation?
- + Are the materials to be bonded dry, clean and free of dust and grease? Degrease only with acetone or isopropanol. Metals and smooth surfaces should be additionally roughened and then degreased again.
- + 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 workpiece, 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? Pistol and nozzle should spray without problem.
- + Is the correct nozzle being used? For GLUKON<sup>®</sup> pebble sea please use the GLUKON<sup>®</sup> pebble nozzle exclusively.
- + Are all tools (e.g. dowel rods) ready for laying the materials without bubbles?
- + Are pressure rollers ready or is the press available and set to the required pressure (2.5 to 3 kg/cm<sup>2</sup>)?
- + 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!
- Avoid directly inhaling, swallowing or absorbing through the skin as this is a health hazard!
- 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 data sheet (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> pebble sea** 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.

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