

## **General Adhesive Sealant Application Guide**

### **1. Scope and Purpose**

This Technical Data Sheet provides standardised procedures for the proper application, preparation, and finishing of Saba adhesive sealant products.

### **2. Surface Preparation**

#### **2.1 Non-Porous Substrate Preparation**

Follow the sequential procedure below for all non-porous substrate applications:

**Step 1:** Initial Cleaning; clean all substrate surfaces using either Isopropyl alcohol or Methylated Spirits to remove surface contaminants.

**Step 2:** Surface Protection (optional). Apply masking tape to substrate areas requiring protection from adhesive sealant contact.

**Step 3:** Mechanical Abrasion. Abrade all bonding and sealing surfaces using minimum 120g sandpaper or a suitable Scotchbrite pad. This process creates a mechanical key increasing the surface wettability necessary for proper adhesion.

**Step 4:** Final Cleaning. Clean abraded surfaces thoroughly with Methylated Spirits or Isopropyl alcohol and a clean rag; rotate the rag regularly to ensure a clean surface. Ensure complete removal of dust, dirt, oils, and all other contaminants. Allow sufficient evaporation time for cleaning solvents before proceeding.

**Step 5:** Primer Application (conditional). Apply appropriate primer if specified in the product Technical Data Sheet (TDS).

### **3. Adhesive Sealant Application Procedure**

#### **3.1 Product Application**

Apply adhesive sealant to the prepared substrate surface following the product-specific guidelines outlined in the corresponding TDS.

#### **3.2 Tooling Procedure**

Primary Tooling (Dry Method): Perform initial dry tooling to verify that:

- Adhesive sealant is correctly applied to the bond area
- The bond zones are sufficiently covered and sealed
- Joint is aligned and within recommended specification

Optional Secondary Tooling (Wet Method): If further tooling is required, prepare a diluted solution of pH-neutral soap and clean water. Apply this solution to the adhesive sealant surface via spray application. Perform tooling operations before surface skin formation occurs.

#### **3.3 Masking Tape Removal**

Remove masking tape immediately following tooling operations. Pull tape away and slightly off parallel to the applied bead, moving away from the joint. **CRITICAL:** Do not pull tape perpendicular to the sealant surface, as this may cause lifting or delamination if the sealant was not terminated at the tape edge.

#### **3.4 Clean-Up Operations**

Remove excess adhesive sealant from substrate surfaces using Methylated Spirits or Isopropyl Alcohol and a clean rag. Cured adhesive sealant can only be removed by mechanical means.

### **4. Critical Restrictions**

#### **4.1 Solvent Tooling Prohibition**

**WARNING: Do not use solvents for tooling operations.**

Tooling with solvents or other unsuitable chemicals will result in:

- Product discoloration
- Structural breakdown
- Reduced performance

Prohibited Tooling Agents: Methylated Spirits, Acetone, Turpentine, Isopropyl alcohol, Wax and Grease Remover and/or similar solvents are not suitable for tooling operations.

#### **4.2 Application Over Newly Applied Coatings or Adhesives**

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**CAUTION:** Do not apply adhesive sealant over newly applied, still curing 2-part coatings or solvent based adhesives.

Such applications may result in:

- Failure to, or exaggerated cure times
- Failure or degraded bond strength
- Bubbles forming internally in the adhesive sealant
- Structural breakdown
- Reduced performance

## **5. SUBSTRATE-SPECIFIC REQUIREMENTS**

### **5.1 General Substrate Conditions**

All substrates must be: Clean, Dry, Free from dust, and free from grease, oils, and any other contaminates

### **5.2 Porous Surfaces**

Porous substrates require priming with a suitable primer prior to adhesive sealant application. Consult the relevant Technical Data Sheet for more information or contact your nearest BluSky office.

### **5.3 Plastic Substrates**

Polypropylene (PP) and Polyethylene (PE) plastics require application of a suitable primer before adhesive sealant installation. Consult the relevant Technical Data Sheet for more information or contact your nearest BluSky office.

**IMPORTANT:** Do not use paint preparation solvent cleaners, as these products may contain oils that leave residual films. Such films will interfere with bonding performance.

## **6. Operating Temperature Range**

Application Temperature (min./max.): +5°C to +35°C

Substrate Temperature (min./max.): +5°C to +35°C, must be +3°C above the dew point

## **7. PAINTING AND OVERCOATING**

### **7.1 Paint Compatibility**

Saba adhesive sealants may be painted, including wet-on-wet application. The technology of paint formulations and systems evolves constantly. We recommend compatibility testing the adhesive sealant with the chosen paint system prior to application.

### **7.2 Paint System Considerations:**

The drying time of some paint systems may increase when applied MS Polymer adhesive sealants, for example Alkyd Resin Paints & dispersion based. Traditional single component oil-based paints and varnishes do not cure properly when applied over MS Polymer adhesive sealants. This is due the paint being unable to penetrate the adhesive sealant surface. We recommend compatibility testing the adhesive sealant with the chosen paint system prior to application.

## **8. Compatibility Testing**

Substrate materials (particularly plastics) and formulations can differ from manufacturer to manufacturer, preliminary compatibility testing is recommended before all applications. Contact your nearest BluSky office for testing protocols and technical support.

## **9. Technical Support**

### **9.1 For product-specific information, consult:**

- Individual Product Technical Data Sheets (TDS)
- Safety Data Sheets

### **9.2 Technical Assistance**

For technical questions or application support, contact:

BluSky Products

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Email: [sales@bluskyproducts.com.au](mailto:sales@bluskyproducts.com.au)