

Guideline on Application of Rigibond 5

RATIO:

- Ensure that the specified ratio for the system is adhered to. The pre described ratio for Rigibond 5 is 5:1, that is, 5 parts Rigibond5 to 1 part Resinate 200
- Too little “B” or Isocyanate can lead to uncured adhesive.
- Too much “B” or Isocyanate component can lead to brittle glue line.

Mixing:

The two components can either be mixed with a mixer attached to a drill, or with a suitable handheld mixing instrument. In both cases the isocyanate should be thoroughly mixed through the resin. Obviously a drill would ensure quicker mixing.

Application:

The mixed system can then be applied onto the relevant surface. The easiest way to do this is to pour a suitable amount onto the substrate – if at all possible onto the smoother harder surface rather than onto the foam. The glue can then be spread out using a fine toothed trowel. The spread rate is normally about 500g to 800g per m². Depending on the grade of Rigibond5 used, the open time to pour and spread the adhesive is anywhere from 10 minutes onwards. This also depends on the size of the mix you are doing as the reaction is exothermic and speeds up the reaction. For longer open times, the adhesive can be poured on to the surface immediately after mixing. Once the glue has been evenly spread out, the relevant layer can then be bonded. For best results weights or pressure can be put on the glued assembly. The article can then be handled after a minimum of 4 hours of bonding; this depends greatly on the ambient temperature as well as the temperatures of the substrates.

Ensure that all substrates are free of water and are clean of any residue.

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