



HIGH TEMPERATURE ADHESIVE LIMITED

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APPLICATION GUIDE HTA120 TO STEEL

The following application guide is to be used for the fixing of pins to steel with perforated bases.

1. The steel substrate should be clean, dry and free from oil and grease or any other condition that may impair good adhesion.
2. The application cartridge should be cut to allow a bead of adhesive to be applied evenly over the base of the pin.
3. Once the adhesive has been applied the pin should be firmly pressed into place. A firm, even pressure should be applied to ensure good contact is made. The adhesive should ooze through the perforations in the base plate of the pins. **Under no circumstances should the excess adhesive be removed.** It should be simply left in place. The filling of the holes with adhesive ensures a sound contact has been made and an all over even distribution of adhesive has also formed between the adhesive and the substrate.
4. Once fixed in place leave to cure. The curing time is dependent on prevailing ambient temperatures.
5. The spacing of the pins is as per the material supplier's application manual.

Note: The above is to provide guidance as to the general application of the HTA120 Adhesive. We advise that you contact HTA Ltd for a project specific application specification. HTA120 has been developed so as to adhere to a vast and wide range of steel primer systems including, but not limited to TWO PACK EPOXY and ALKYD based systems. In addition the HTA120 can be fixed to bare, unprimed steel having been previously shot blasted to SA2.5

