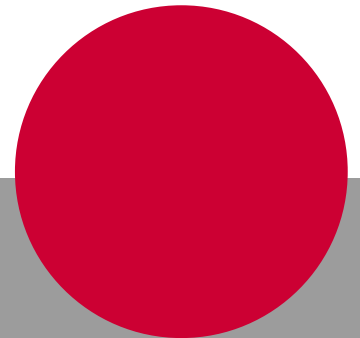


Bonding of Board Materials



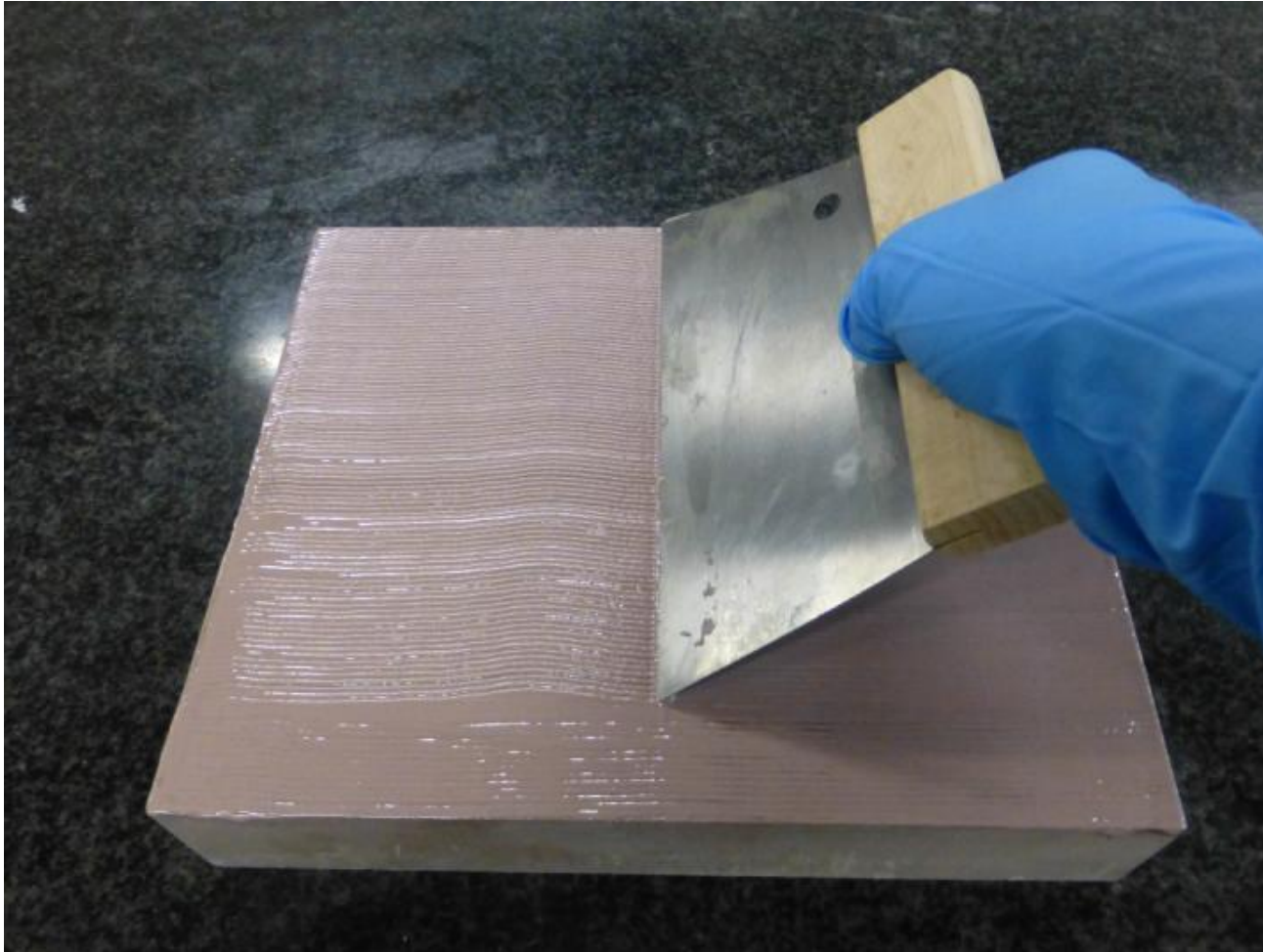
Preparation for Bonding and Repair



Bonding surfaces must be free of grease and dust. If necessary, grind and degrease.

To achieve a defined coating thickness in the bonding joint, spatulas should be used that are suitable for the particular joint thickness.

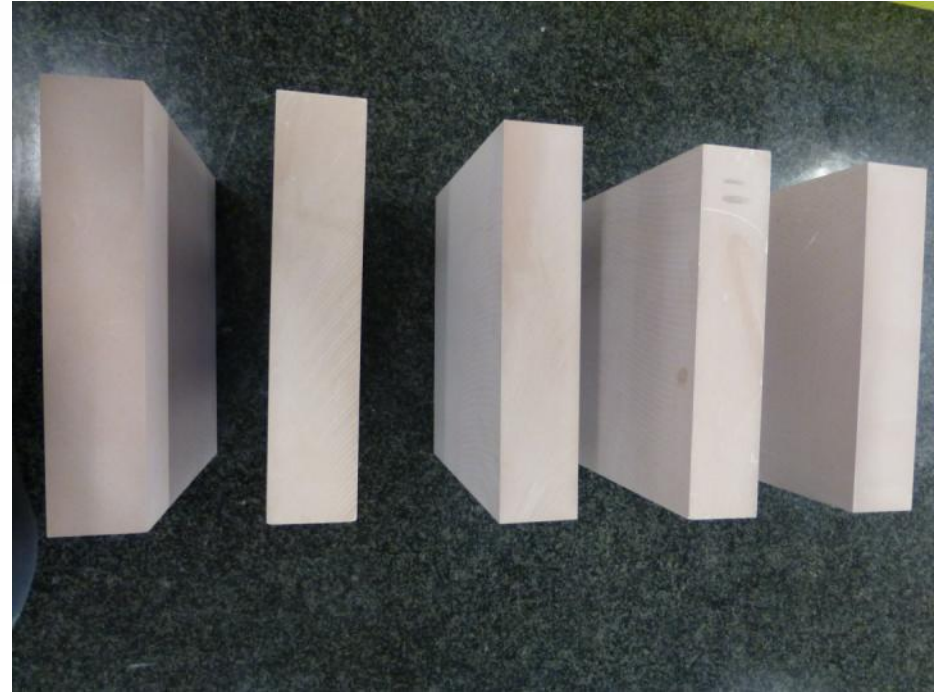
Application



The adhesive needs to be applied evenly to both sides of the joint to allow for better cross-linking and to avoid air entrapment.

Liquid adhesive

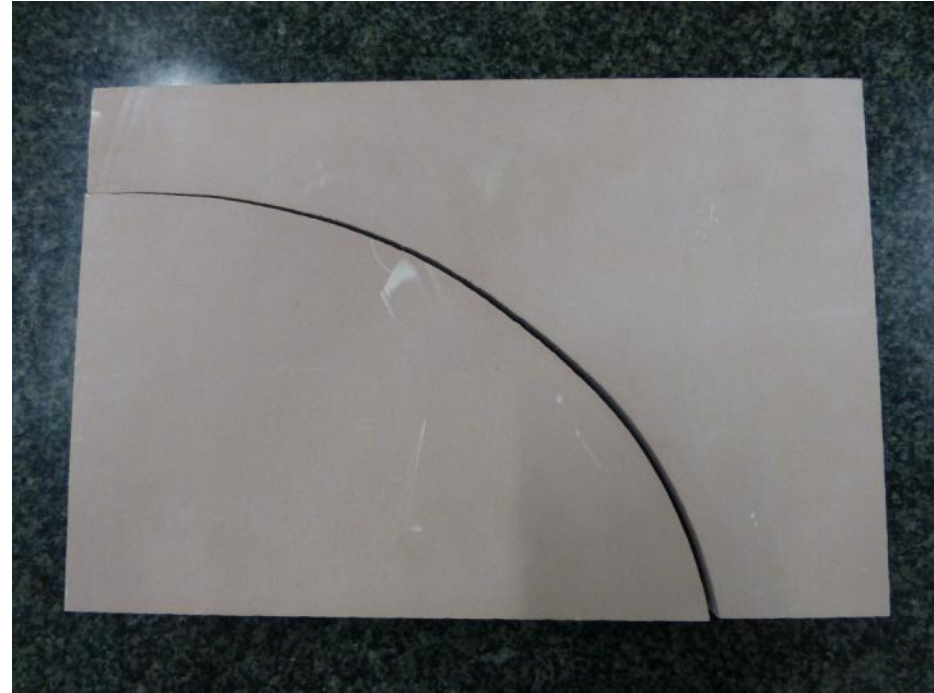
RAKU-TOOL® EP-2306 / EH-2904-1



Liquid adhesive is used when a thin and equal bonding line needs to be achieved.

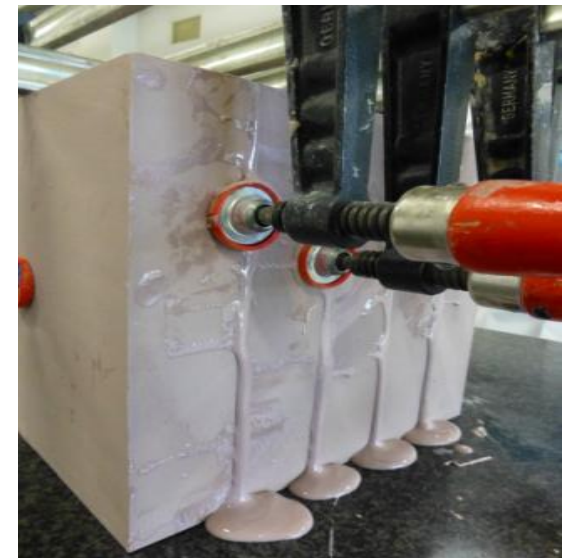
Slightly thixotropic adhesives

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Use slightly thixotropic adhesives for vertical and rough cut bonding joints to prevent the adhesive from escaping from the joint.

Clamping



Apply clamping pressure (e.g. vise) to the parts/casting to be bonded until the excess adhesive is pushed out, then reduce pressure and leave to cure.

This minimizes stress that might be triggered in the casting during machining.