Ref.	Description
ROCKPANEL TACK-S	Rockpanel Adhesive - 290ml
PRIMER MSP	Primer for the back side of Rockpanel Board - 500ml
LIQUID 1	Cleaner for the surface of Rockpanel Strips - 1000ml
PREP M	Primer for the surface of the aluminium supporting structure - 500ml
FOAMTAPE	Assembly tape for fixing. Also serves as a spacer - 25m coils
PL/AD/AS/RS	Roller Frame, 10 rollers & tray application set
PL/AD/FS/SR	Set of 10 spare rollers
SKELETON/GUN	290ml - 310ml applicator gun

DETAILED DRAWINGS OF ROCKPANEL TACK-S ADHESIVE SYSTEM

Figure 1 shows drawings of the basic principle for adhesion to aluminium profiles and mechanically fixed Rocpanel strips on wodden battens. Figure 2 shows the vertical joint with Rockpanel strip on timber battens.

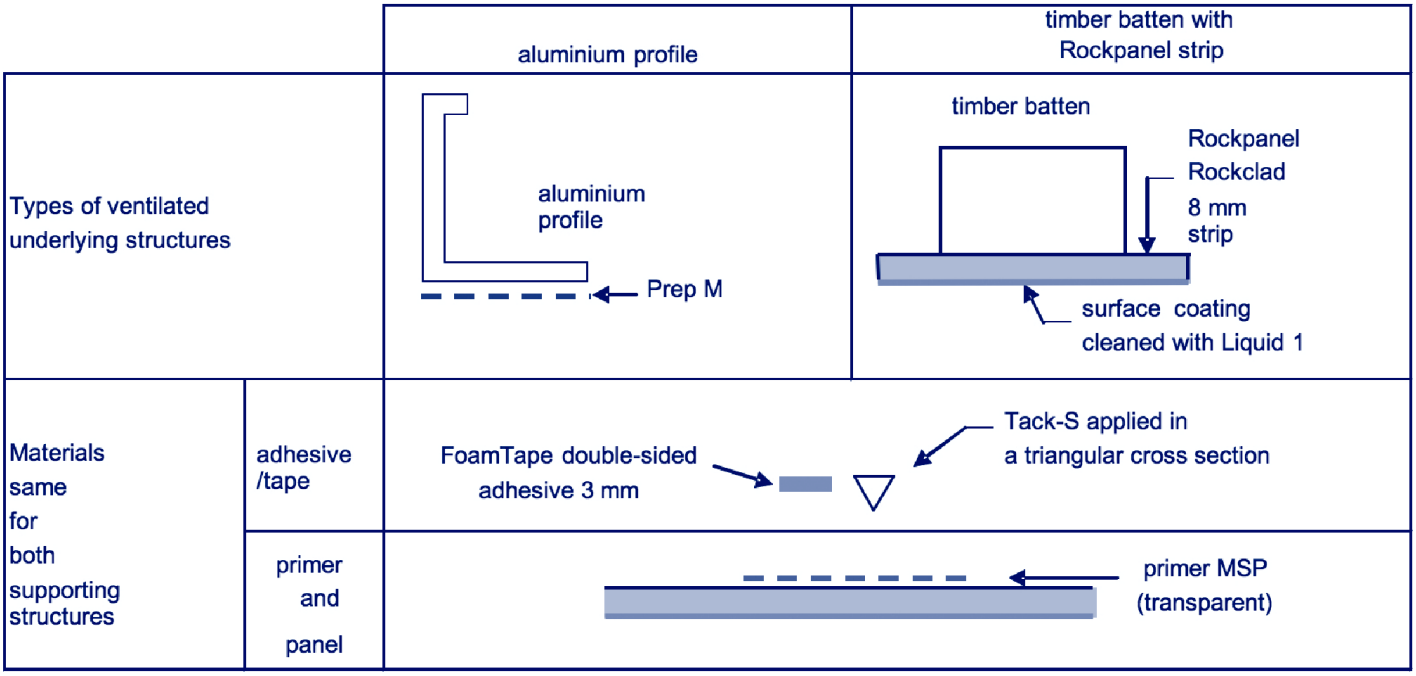
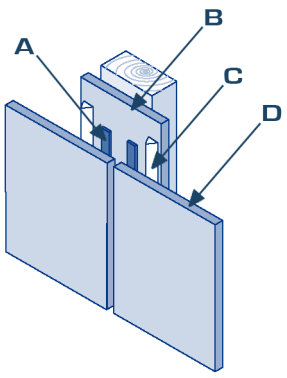


Figure 1. Supporting structures and Rockpanel with pretreatment and materials needed.



A	2-sided adhesive FoamTape, 3 x 12mm
B	8mm Rockpanel Rockclad strip; strip mechanically attached with Rockpanel nails or screws
C	Triangular Tack-S adhesive bead with height of 9mm
D	Reverse side treated with MSP Primer (transparent)

Figure 2
Rockpanel Tack-S adhesive system with Rockpanel panels glued to mechanically attached Rockpanel Rockclad strips on ventilated vertical timber battens.

ROCKPANEL TACK-S ADHESIVE SYSTEM

Product
Rockpanel Tack-S is an elastic adhesive system, specially developed for adhering Rockpanel boards.

The system consists of the following components.

1. Rockpanel Tack-S : adhesive
2. Primer MSP : primer for the back side of the Rockpanel board
3. a. Liquid 1 : cleaner for the surface of Rockpanel strips (Rockclad type)
   b. Prep M : primer for the surface of the aluminium supporting structure
4. FoamTape : Assembly tape for fixing. Also serves as spacer.

Application
Adhesion of Rockpanel panels (exclusively) for: façade cladding, fascias, eaves, soffits and canopies.

Properties
- Solvent and isocyanate-free.
- Durable, highly elastic, with optimum stress distribution.
- Good moisture and weather resistance.
- Easily sprayed.

Certification
- Listed in the European Technical Approval, ETA 07/0141, for Rockpanel® panels
- Listed in IKOB-BKB CERTIFICATE NL- associated document to ETA-07/0141, no. IKB1718
- Glued Rockpanel boards, of Rockclad or AG type, 8mm thick, fall in the European fire class B-s2, d0

SYSTEM COMPONENTS

1 Rockpanel Tack-S

Type	: 1-component, elastic
Shore A	: 40
Density	: 1,3 gram/ml
Skin formation (start)	: 15 minutes (at 20°C/RH 50%)
Hardening rate	: approx. 3 mm/24 hours (at 20°C/ RH 50%)
Elongation at break	: 200 % (DIN 53504/ISO 37)
Temperature resistance	: -40/+ 100 °C
Processing temperature	: + 5/+ 35 °C
Packaging	: 290 ml cartridges, 600 ml sausage
Colour	: white
Shelf life	: Store in a cool (between +5 and +35°C) and dry place. Can be stored at least 12 months in unopened packaging.
Article code	: 290 ml cartridge, 131414

Special nozzle
For spraying Rockpanel Tack-S, a special nozzle is provided with each cartridge. This applies a triangular bead 9 mm wide and 9 mm in height. The nozzle prevents air inclusion and unnecessary loss of adhesive.

2 Primer MSP
Special water-resistant primer Simson MSP, suitable for pretreatment of the adhesive side of Rockpanel panel.

Dry substance content	: 40 %
Minimum drying time	: 60 minutes
Maximum processing time	: 30 minutes
Processing temperature	: + 5/+ 30 °C
Shelf life	: Can be stored for 12 months (after production) in unopened packaging
Packaging	: 500 ml
Article code	: 22080

Simson Primer MSP is to be used with a special application set: velvet brush rollers with handle and basin. The roller ensures minimum consumption for an optimal pretreatment.

3 Liquid 1 and Prep M
For adhesion to supporting structures, two pretreatment preparations are available: Liquid 1 for Rockpanel Rockclad strips (mechanically fixed on wooden battens) and Prep M for aluminium profiles.

	Liquid 1	Prep M
Technical Characteristics:	For Rockclad strips surface	For aluminium
Dry matter content:	0%	17%
Colour:	Transparent	Transparent
Minimum drying time (20°C / 50% RH):	5 Minutes	10 Minutes
Maximum processing time:	n/a	n/a
Packaging in container:	1000ml	500ml
Processing temperature:	+ 5°C / + 30°C	+ 5°C / + 30°C
Shelf life:	Can be stored for 12 months (after production) in unopened packaging.	Can be stored for 12 months (after production) in unopened packaging.
Article code	25380	22110

Liquid 1 is also suitable for the direct removal of adhesive and primer residue.

4 FoamTape
Double-sided adhesive HDPE FoamTape with a 3 mm thickness of 3 mm and 12 mm width. It provides the initial bonding of the Rockpanel panels and guarantees adequate thickness and shape of the adhesive beading. FoamTape has a protective film of silicone paper on one side. FoamTape has a dense structure and is very resistance to moisture and dirt.

Colour	: Grey
Density	: 50 kg/m³
Packaging	: 25 meters/roll
Working temperature	: + 5/+ 35 °C
Shelf life	: Can be stored for 12 months
Article code	: 182771

FOR THE DESIGNER

CONDITIONS ON THE UNDERLYING STRUCTURE

Air space and ventilation
The underlying supporting structure for façade applications should be vertical and ventilated. The gap between the back side of the panels and the underlying structure should be at least 40 mm. The maximum span of the panels is listed in the tables. The gap can be reduced from 40 to 20 mm minimum.

Choice of materials
Quadrilateral smoothly-planed wood types with a durability class and moisture content corresponding to the conditions listed in the Certificates are suitable. Aluminium alloy and material thickness corresponding to the Certificates.

Dimensions of wooden battens
Rockpanel Rockclad 8 mm strips are mechanically attached to the battens. The minimum width dimensions of the battens depend on the function of the supporting strut. See also the paragraph on details of the Rockpanel adhesive system (on page 4).

1. Batten for joint connection	: 70 mm
2. Remaining battens	: 45 mm
Minimum supporting strut thickness	: 28 mm

The Rockpanel Rockclad strip should be allowed to extend out on both sides by at least 15 mm.

STRUCTURAL SAFETY

Self Weight of Panels
Average value of shear strength (self weight of panel)
:5.250 N/m1 adhesive bead.
The self weight load of the panel is not a criterion for failure.

Wind load
Characteristic value of stress (wind load)
:4.290 N/m1 adhesive bead.
Calculation of wind suction corresponding to NEN 6700/6702. The ETA gives a characteristic tensile strength for the adhesive bonding of 0.33 N/mm2. For an adhesive bead breadth of 13 mm this corresponds to 4290 N/m1. The tensile strength of panel bonding is not definitive in the wind calculation for a total safety γm.γf of 3.

Support distances
For the maximum support distances please consult Rockpanel.

NOTE: Soffit or canopy applications
For soffit or canopy constructions different fixing distances are advised. For this application Rockpanel advises approx. 70% of the distances for façade bonding, so that for batten distances > 300 mm, support may be needed until the adhesive has hardened. In horizontal application (canopy) the truss is to be assembled at right angles to the façade.

Indication of consumption

Surface of Rockpanel panel	100 m2	Standard packaging
Simson FoamTape	: 12	rolls (25 metres)
Simson Rockpanel Tack-S	: 50	cartridges (290 ml)
Simson Primer MSP (back side of Rockpanel)	: 4	cans (500 ml)
Simson Liquid 1 (Rockpanel strip)	: 1	cans (1000 ml)
Simson Prep M (metal)	: 2	cans (500 ml)

FOR THE INSTALLER

GUIDELINES FOR PRETREATMENT AND POSITIONING

1. Pretreatment of aluminium profiles
For aluminium supporting structures Simson Prep M must be applied with a clean, fluff- and dust-free colourless cloth or tissue. Start applying adhesive after a drying time of 10 minutes.

2. Pretreatment of surface of Rockpanel strips
Clean the surfaces of the 8 mm Rockpanel Rockclad strips with a clean, fluff- and dust-free colourless cloth or tissue moistened with Liquid 1.

3. Priming Rockpanel panels
Use Simson Primer MSP to pretreat the adhesive side of the panel with the special application set with rollers (not directly from the package). One layer of primer is sufficient. Multiple layers are not permitted. For Rockpanel Rockclad (vapour-permeable) remove the protective film from the front of the panel before priming. Prime the panels vertically (standing upright), not horizontally (lying down), to prevent the solvent in the primer from penetrating too deeply into the panels and weakening the coating on the front. Pretreat the panel over its entire length and in strips of 100 -150mm with this primer. Allow a minimum drying time of 60 minutes for Primer MSP.

4. Applying assembly tape
After the primers and cleaners have dried, apply the Simson FoamTape vertically and continuously only onto the supporting structure. Press on the FoamTape and cut with a sharp knife. For the correct positioning and length of the tape, also keep in mind the dimensions and function of the supporting strut, the dimensions of the Rockpanel panel and the required gap for the Rockpanel Tack-S. After applying the tape, do not remove the protective layer immediately.

5. Applying Rockpanel Tack-S with special nozzle
Apply Rockpanel Tack-S vertically and continuously only, after the FoamTape has been applied. Use manual or air guns for this. Use the special nozzle so that a triangular adhesive bead with a height of approximately 9 mm can be applied. If necessary cut the nozzle across the factory-provided V-incision for a clean working angle.

6. Positioning Rockpanel panel
Remove the protective layer from the FoamTape. The Rockpanel panel must be positioned within a maximum of 10 minutes after application of the adhesive. Position the panel by pressing it gently and adjusting if necessary. This is still possible before the Rockpanel panel touches the FoamTape. If necessary, use spacers, support blocks or a horizontal batten for good positioning of the panel. Use a glass clamp if necessary to improve the grip. Once the panel is well positioned, it should be pressed, for example with a straight rule so that the FoamTape is completely contacted across the back of the panel. Pressing with a rule prevents “bulging”. Correction is now no longer possible.

7. Cleaning
Remove fresh primer or adhesive residues on the Rockpanel panel with Simson Cleaner Liquid 1. Use a clean, fluff and dust free cloth or tissue.

Rockpanel Tack-S is a product of Bostik B.V.
email: infonl@bostik.com
www.bostik.nl and www.simson.nl

Bostik
The Adhesive Company

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