General Information:

Cellular and compact polyurethanes of the Sylomer®, Sylodyn® and Sylodamp® brands can be bonded in accordance with the information below. In order to obtain sufficient adhesion, it is recommended to use a suitable adhesive for each bonding operation and for the surfaces being bonded.

1.1 Bonding PU elastomers

1.1.1 Preparation

Preparation of the contact surfaces to be bonded is of vital importance for the strength of the adhesive bond. The substrates must suit one another and be available as bare material. In order to enable adhesion, the surfaces to be bonded must be free from adhesive residue, oil, grease, release agents (e.g. silicon) and, in particular, dirt, dust, scale, protective layers, sizing agents, coats of paint and any kind of moisture. These can be removed mechanically through stripping, brushing, scraping, grinding or sandblasting. Likewise, they can be removed chemically through degreasing, acid cleaning or priming, to name just a few methods.

In general, Sylomer®, Sylodyn® and Sylodamp® can be bonded to one another very successfully as flat products, even without pretreatment. In the case of moulded parts with or without distinct skin, the adhesive release agent must be removed. If necessary, the surface must be processed by grinding. If they are bonded to other materials, such as plastic, wood, metal or concrete, the surface to be bonded can be pre-treated with a primer prior to the bonding operation for cleaning and for improved adhesion. Application of the primer and preparation for bonding must be carried out in accordance with the manufacturer's recommendations. The manufacturer's instructions relating to horizontal/vertical bonding, curing time, etc. should be followed to the letter, so that the required adhesion is in fact achieved. The adhesive film must be applied carefully, according to these instructions, using appropriate equipment (brush, spatula, palette knife, spray pistol [airless], etc.).

Note that strips of the Sylomer®, Sylodyn® and Sylodamp® materials are supplied with two different surfaces. Due to the manufacturing process, two sides have a skin, and they exhibit an almost sealed surface as a result of the integral structure. Better adhesion can be achieved with the open-celled structure on the sides that have been cut (saw, water jet, etc. - see figure). However, these surfaces soak up adhesive due to the open structure. This must be taken into consideration and tested in advance with regard to the amount of adhesive to be applied.

1.1.2 Bonding

If bonding is carried out correctly in accordance with the instructions, it can be assumed that the bond is chemically stronger than the material structure. This means that the material will tear away from the bonded joint if subjected to tensile force. The tensile strength specified in the data sheet may be used as a parameter here.
We make a general distinction between two types of adhesive:

**Contact adhesives:**
Non-gap-filling adhesive film, which is applied as thinly as possible to both surfaces to be bonded. The adhesive should be pressed with a maximum pressure of 0.5N/mm². After the first contact between the bonding surfaces, it is no longer possible to correct the position (contact effect). Resulting creases, waves and bubbles cannot be corrected. Bonds that have been separated must be built up again from scratch. The flash-off time specified by the manufacturer must be observed. Particularly with systems that use conventional solvents such as water, the adhesive film must be dry enough such that the adhesive surface no longer forms threads when tested with a finger.

**Hardening adhesives:**
These are gap-filling 1 and 2 component reactive adhesives, which are applied evenly and, if necessary, can compensate for uneven areas with the layer thickness. The parts must be joined together immediately after applying the adhesive. It is possible to make adjustments for a limited amount of curing time once the adhesive parts have made contact. Depending on the bonding process, pressing the surfaces to be bonded together after the bonding operation may create better adhesion.

---

**Note:**
All information provided in this document is based on our current level of knowledge. The actual properties that can be achieved depend on the various conditions. Therefore, tests should be carried out at the place of use prior to using the product, so that the results can be checked with the aid of an adhesive expert. It is the responsibility of the user to check the results in regard to usability and suitability.

---

### 2 Recommended adhesives

Due to the variety of possible materials to be bonded and suitable adhesives, the following list can only provide information for certain combinations. This is based on the current level of knowledge of Getzner Werkstoffe. We accept no liability for these recommendations and any damage that may result. Each adhesive bond must be prepared in line with the manufacturer's recommendations and must be tested in advance.

#### 2.1 Bonding Sylomer®/Sylodyn®/Sylodamp® to one another and to wood

To increase the adhesion on the surfaces to be bonded, it is advisable to also clean and treat the surfaces with a primer.

<table>
<thead>
<tr>
<th>Primer</th>
<th>Manufacturer</th>
<th>Website</th>
</tr>
</thead>
<tbody>
<tr>
<td>Marine Primer 5400A</td>
<td>3M</td>
<td><a href="http://www.3m.com">www.3m.com</a></td>
</tr>
<tr>
<td>OTTO Primer 1225</td>
<td>Otto Chemie</td>
<td><a href="http://www.otto-chemie.de">www.otto-chemie.de</a></td>
</tr>
<tr>
<td>Primer 83 for adhesive tape</td>
<td>3M</td>
<td><a href="http://www.3m.com">www.3m.com</a></td>
</tr>
<tr>
<td>Primer Loctite 7239</td>
<td>Henkel</td>
<td><a href="http://www.henkel.com">www.henkel.com</a></td>
</tr>
<tr>
<td>Sika Primer 3N</td>
<td>Sika</td>
<td><a href="http://www.sika.at">www.sika.at</a></td>
</tr>
<tr>
<td>Adhesive</td>
<td>Type</td>
<td>Manufacturer</td>
</tr>
<tr>
<td>--------------------------------</td>
<td>--------------</td>
<td>--------------</td>
</tr>
<tr>
<td>3M Scotch Weld 7240 B/A FR</td>
<td>H 2-C</td>
<td>3M</td>
</tr>
<tr>
<td>3M Scotch Weld 78 HT</td>
<td>C</td>
<td>3M</td>
</tr>
<tr>
<td>3M Scotch Weld 90</td>
<td>C</td>
<td>3M</td>
</tr>
<tr>
<td>3M Scotch Weld 9372W/9375W</td>
<td>Tape</td>
<td>3M</td>
</tr>
<tr>
<td>3M Scotch Weld 9377</td>
<td>Tape</td>
<td>3M</td>
</tr>
<tr>
<td>3M Scotch Weld 94 CA</td>
<td>C</td>
<td>3M</td>
</tr>
<tr>
<td>3M Scotch Weld DP110</td>
<td>H 2-C</td>
<td>3M</td>
</tr>
<tr>
<td>3M Scotch Weld VHB 5958</td>
<td>Tape</td>
<td>3M</td>
</tr>
<tr>
<td>Araldite® 2014-1</td>
<td>H 2-C</td>
<td>Huntsman</td>
</tr>
<tr>
<td>ASTORbond 12361</td>
<td>Tape</td>
<td>ASTORplast</td>
</tr>
<tr>
<td>ASTORtack 11347</td>
<td>Tape</td>
<td>ASTORplast</td>
</tr>
<tr>
<td>ASTORtack 11356</td>
<td>Tape</td>
<td>ASTORplast</td>
</tr>
<tr>
<td>Elastan</td>
<td>H 1-C/H 2-C</td>
<td>BASF</td>
</tr>
<tr>
<td>Icema R 101 P</td>
<td>H 2-C</td>
<td>H.B. Fuller</td>
</tr>
<tr>
<td>Icema R 145/44</td>
<td>H 1-C</td>
<td>H.B. Fuller</td>
</tr>
<tr>
<td>Körapur 666 + Köracur</td>
<td>H 2-C</td>
<td>Kömmerling</td>
</tr>
<tr>
<td>Körapur 672 + Köracur</td>
<td>H 2-C</td>
<td>Kömmerling</td>
</tr>
<tr>
<td>Loctite (Macroplast) 406</td>
<td>H 1-C</td>
<td>Henkel</td>
</tr>
<tr>
<td>Loctite (Macroplast) 480</td>
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<td>Henkel</td>
</tr>
<tr>
<td>Loctite (Macroplast) UK 5400</td>
<td>H 1-C</td>
<td>Henkel</td>
</tr>
<tr>
<td>Loctite (Macroplast) UK 8101 B3</td>
<td>H 2-C</td>
<td>Henkel</td>
</tr>
<tr>
<td>Loctite (Macroplast) UK 8202</td>
<td>H 2-C</td>
<td>Henkel</td>
</tr>
<tr>
<td>Loctite (Macroplast) UK 8303 B60</td>
<td>H 2-C</td>
<td>Henkel</td>
</tr>
<tr>
<td>Loctite (Macroplast) UR 7225</td>
<td>H 1-C</td>
<td>Henkel</td>
</tr>
<tr>
<td>Monterings LIM 5100</td>
<td>C</td>
<td>Würth</td>
</tr>
<tr>
<td>Ottocoll P83</td>
<td>H 1-C</td>
<td>Otto Chemie</td>
</tr>
<tr>
<td>Sikaflex -254 Booster</td>
<td>H 1-C</td>
<td>Sika</td>
</tr>
<tr>
<td>Sikaflex -265 Booster</td>
<td>H 1-C</td>
<td>Sika</td>
</tr>
<tr>
<td>Technicoll 8044</td>
<td>C</td>
<td>Technicoll</td>
</tr>
<tr>
<td>Technicoll 8344</td>
<td>H 1-C</td>
<td>Technicoll</td>
</tr>
<tr>
<td>Teroson (Terokal) SB 2444</td>
<td>C</td>
<td>Henkel</td>
</tr>
<tr>
<td>Tesafix 4962</td>
<td>Tape</td>
<td>Tesa</td>
</tr>
<tr>
<td>Thixon 422</td>
<td>H 1-C</td>
<td>DOW</td>
</tr>
<tr>
<td>Ultraflex 56</td>
<td>C</td>
<td>H.B. Fuller</td>
</tr>
<tr>
<td>VaryBond VB92</td>
<td>H 1-C</td>
<td>ITW</td>
</tr>
</tbody>
</table>

C = Contact adhesive, H 1-C = One-component adhesive, H 2-C = Two-component adhesive; Tape = Self-adhesive tape
2.2 Bonding Sylomer®/Sylodyn®/Sylodamp® to metallic substrates

When bonding metallic surfaces, it is advisable to clean the metal surface to be bonded in advance with a primer.

<table>
<thead>
<tr>
<th>Primer</th>
<th>Metal</th>
<th>Manufacturer</th>
<th>Website</th>
</tr>
</thead>
<tbody>
<tr>
<td>3M Primer 83 for adhesive tape</td>
<td>Steel, aluminium</td>
<td>3M</td>
<td><a href="http://www.3m.com">www.3m.com</a></td>
</tr>
<tr>
<td>3M Scotch Brite 7447</td>
<td>Steel, aluminium, copper, brass</td>
<td>3M</td>
<td><a href="http://www.3m.com">www.3m.com</a></td>
</tr>
<tr>
<td>OTTO Primer 1225</td>
<td>Al, steel, Zn</td>
<td>Henkel</td>
<td><a href="http://www.otto-chemie.de">www.otto-chemie.de</a></td>
</tr>
<tr>
<td>Primer Loctite 7239</td>
<td>Steel, aluminium</td>
<td>Henkel</td>
<td><a href="http://www.henkel.com">www.henkel.com</a></td>
</tr>
<tr>
<td>Primer Loctite/Macroplast UK 5400</td>
<td>Steel, Zn, brass</td>
<td>Sika</td>
<td><a href="http://www.henkel.com">www.henkel.com</a></td>
</tr>
<tr>
<td>Sika Primer 3N</td>
<td>Steel, Al, Fe, amongst others</td>
<td>Sika</td>
<td><a href="http://www.sika.at">www.sika.at</a></td>
</tr>
<tr>
<td>Sikalastic Metal Primer</td>
<td>Al, Pb, Fe, Cu steel, brass</td>
<td>Otto Chemie</td>
<td><a href="http://www.sika.at">www.sika.at</a></td>
</tr>
</tbody>
</table>

The usual bare metals are steel, stainless steel, iron, aluminium, copper, brass and lead.

<table>
<thead>
<tr>
<th>Adhesive</th>
<th>Type</th>
<th>Manufacturer</th>
<th>Website</th>
</tr>
</thead>
<tbody>
<tr>
<td>3M Scotch Weld 7240 B/A FR</td>
<td>H 2-C</td>
<td>3M</td>
<td><a href="http://www.3m.com">www.3m.com</a></td>
</tr>
<tr>
<td>3M Scotch Weld 90</td>
<td>C</td>
<td>3M</td>
<td><a href="http://www.3m.com">www.3m.com</a></td>
</tr>
<tr>
<td>3M Scotch Weld 9372W/9375W</td>
<td>Tape</td>
<td>3M</td>
<td><a href="http://www.3m.com">www.3m.com</a></td>
</tr>
<tr>
<td>3M Scotch Weld 9377</td>
<td>Tape</td>
<td>3M</td>
<td><a href="http://www.3m.com">www.3m.com</a></td>
</tr>
<tr>
<td>3M Scotch Weld 94 CA</td>
<td>C</td>
<td>3M</td>
<td><a href="http://www.3m.com">www.3m.com</a></td>
</tr>
<tr>
<td>3M Scotch Weld DP110</td>
<td>H 2-C</td>
<td>3M</td>
<td><a href="http://www.3m.com">www.3m.com</a></td>
</tr>
<tr>
<td>3M Scotch Weld VHB 5958</td>
<td>Tape</td>
<td>3M</td>
<td><a href="http://www.3m.com">www.3m.com</a></td>
</tr>
<tr>
<td>Araldite® 2014-1</td>
<td>H 2-C</td>
<td>Huntsman</td>
<td><a href="http://www.huntsman.com">www.huntsman.com</a></td>
</tr>
<tr>
<td>ASTORbond 12361</td>
<td>Tape</td>
<td>ASTORplast</td>
<td><a href="http://www.astorplast.at">www.astorplast.at</a></td>
</tr>
<tr>
<td>ASTORtack 11347</td>
<td>Tape</td>
<td>ASTORplast</td>
<td><a href="http://www.astorplast.at">www.astorplast.at</a></td>
</tr>
<tr>
<td>ASTORtack 11356</td>
<td>Tape</td>
<td>ASTORplast</td>
<td><a href="http://www.astorplast.at">www.astorplast.at</a></td>
</tr>
<tr>
<td>Elastan</td>
<td>H 1-C/H 2-C</td>
<td>BASF</td>
<td><a href="http://www.basf.com">www.basf.com</a></td>
</tr>
<tr>
<td>Icema R 101 P</td>
<td>H 2-C</td>
<td>H.B. Fuller</td>
<td><a href="http://www.hbfuller.com">www.hbfuller.com</a></td>
</tr>
<tr>
<td>Icema R 145/44</td>
<td>H 1-C</td>
<td>H.B. Fuller</td>
<td><a href="http://www.hbfuller.com">www.hbfuller.com</a></td>
</tr>
<tr>
<td>Körapur 666 + Köracur</td>
<td>H 2-C</td>
<td>Kömmerling</td>
<td><a href="http://www.koe-chemie.de">www.koe-chemie.de</a></td>
</tr>
<tr>
<td>Körapur 672 + Köracur</td>
<td>H 2-C</td>
<td>Kömmerling</td>
<td><a href="http://www.koe-chemie.de">www.koe-chemie.de</a></td>
</tr>
<tr>
<td>Loctite (Macroplast) 480</td>
<td>H 1-C</td>
<td>Henkel</td>
<td><a href="http://www.henkel.com">www.henkel.com</a></td>
</tr>
<tr>
<td>Loctite (Macroplast) UK 8101 B3</td>
<td>H 2-C</td>
<td>Henkel</td>
<td><a href="http://www.henkel.com">www.henkel.com</a></td>
</tr>
<tr>
<td>Loctite (Macroplast) UK 8202</td>
<td>H 2-C</td>
<td>Henkel</td>
<td><a href="http://www.henkel.com">www.henkel.com</a></td>
</tr>
<tr>
<td>Loctite (Macroplast) UK 8303 B60</td>
<td>H 2-C</td>
<td>Henkel</td>
<td><a href="http://www.henkel.com">www.henkel.com</a></td>
</tr>
<tr>
<td>Loctite (Macroplast) UR 7225</td>
<td>H 1-C</td>
<td>Henkel</td>
<td><a href="http://www.henkel.com">www.henkel.com</a></td>
</tr>
</tbody>
</table>
### General adhesive information

**Sylomer®/Sylodyn®/Sylodamp®**

<table>
<thead>
<tr>
<th>Adhesive</th>
<th>Type</th>
<th>Manufacturer</th>
<th>Website</th>
</tr>
</thead>
<tbody>
<tr>
<td>Ottocoll P83</td>
<td>H 1-C</td>
<td>Otto Chemie</td>
<td><a href="http://www.otto-chemie.de">www.otto-chemie.de</a></td>
</tr>
<tr>
<td>Sikaflex -254 Booster</td>
<td>H 1-C</td>
<td>Sika</td>
<td><a href="http://www.sika.at">www.sika.at</a></td>
</tr>
<tr>
<td>Sikaflex -265 Booster</td>
<td>H 1-C</td>
<td>Sika</td>
<td><a href="http://www.sika.at">www.sika.at</a></td>
</tr>
<tr>
<td>Technicoll 8344</td>
<td>H 1-C</td>
<td>Technicoll</td>
<td><a href="http://www.technicoll.de">www.technicoll.de</a></td>
</tr>
<tr>
<td>Thixon 422</td>
<td>H 1-C</td>
<td>DOW</td>
<td><a href="http://www.dow.com">www.dow.com</a></td>
</tr>
<tr>
<td>Ultraflex 56</td>
<td>C</td>
<td>H.B. Fuller</td>
<td><a href="http://www.hbfuller.com">www.hbfuller.com</a></td>
</tr>
</tbody>
</table>

*C = Contact adhesive, H 1-C = One-component adhesive, H 2-C = Two-component adhesive; Tape = Self-adhesive tape*

#### 2.3 Bonding Sylomer®/Sylodyn®/Sylodamp® to carbon/glass-fibre reinforced plastic (CFRP/GFRP)

<table>
<thead>
<tr>
<th>Adhesive</th>
<th>Type</th>
<th>Manufacturer</th>
<th>Website</th>
</tr>
</thead>
<tbody>
<tr>
<td>3M Scotch Weld 7240 B/A FR</td>
<td>H 2-C</td>
<td>3M</td>
<td><a href="http://www.3m.com">www.3m.com</a></td>
</tr>
<tr>
<td>3M Scotch Weld 90</td>
<td>C</td>
<td>3M</td>
<td><a href="http://www.3m.com">www.3m.com</a></td>
</tr>
<tr>
<td>3M Scotch Weld 9372W/9375W</td>
<td>Tape</td>
<td>3M</td>
<td><a href="http://www.3m.com">www.3m.com</a></td>
</tr>
<tr>
<td>3M Scotch Weld 9377</td>
<td>Tape</td>
<td>3M</td>
<td><a href="http://www.3m.com">www.3m.com</a></td>
</tr>
<tr>
<td>3M Scotch Weld 94 CA</td>
<td>C</td>
<td>3M</td>
<td><a href="http://www.3m.com">www.3m.com</a></td>
</tr>
<tr>
<td>3M Scotch Weld DP110</td>
<td>H 2-C</td>
<td>3M</td>
<td><a href="http://www.3m.com">www.3m.com</a></td>
</tr>
<tr>
<td>3M Scotch Weld VHB 5958</td>
<td>Tape</td>
<td>3M</td>
<td><a href="http://www.3m.com">www.3m.com</a></td>
</tr>
<tr>
<td>Araldite® 2014-1</td>
<td>H 2-C</td>
<td>Huntsman</td>
<td><a href="http://www.huntsman.com">www.huntsman.com</a></td>
</tr>
<tr>
<td>ASTORbond 12361</td>
<td>Tape</td>
<td>ASTORplast</td>
<td><a href="http://www.astorplast.at">www.astorplast.at</a></td>
</tr>
<tr>
<td>ASTORtack 11347</td>
<td>Tape</td>
<td>ASTORplast</td>
<td><a href="http://www.astorplast.at">www.astorplast.at</a></td>
</tr>
<tr>
<td>ASTORtack 11356</td>
<td>Tape</td>
<td>ASTORplast</td>
<td><a href="http://www.astorplast.at">www.astorplast.at</a></td>
</tr>
<tr>
<td>Icema R 101 P</td>
<td>H 2-C</td>
<td>H.B. Fuller</td>
<td><a href="http://www.hbfuller.com">www.hbfuller.com</a></td>
</tr>
<tr>
<td>Icema R 145/44</td>
<td>H 1-C</td>
<td>H.B. Fuller</td>
<td><a href="http://www.hbfuller.com">www.hbfuller.com</a></td>
</tr>
<tr>
<td>Körapur 666 + Köracur</td>
<td>H 2-C</td>
<td>Kömmerling</td>
<td><a href="http://www.koe-chemie.de">www.koe-chemie.de</a></td>
</tr>
<tr>
<td>Körapur 672 + Köracur</td>
<td>H 2-C</td>
<td>Kömmerling</td>
<td><a href="http://www.koe-chemie.de">www.koe-chemie.de</a></td>
</tr>
<tr>
<td>Sikaflex -254 Booster</td>
<td>H 1-C</td>
<td>Sika</td>
<td><a href="http://www.sika.at">www.sika.at</a></td>
</tr>
<tr>
<td>Sikaflex -265 Booster</td>
<td>H 1-C</td>
<td>Sika</td>
<td><a href="http://www.sika.at">www.sika.at</a></td>
</tr>
<tr>
<td>Technicoll 8044</td>
<td>C</td>
<td>Technicoll</td>
<td><a href="http://www.technicoll.de">www.technicoll.de</a></td>
</tr>
<tr>
<td>Technicoll 8344</td>
<td>H 1-C</td>
<td>Technicoll</td>
<td><a href="http://www.technicoll.de">www.technicoll.de</a></td>
</tr>
</tbody>
</table>

*C = Contact adhesive, H 1-C = One-component adhesive, H 2-C = Two-component adhesive; Tape = Self-adhesive tape*
2.4 Bonding Sylomer®/Sylodyn®/Sylodamp® with plastics

Due to the wide range of plastics, it is not possible to provide a general adhesive recommendation. However, reactive adhesive systems (e.g. cyanoacrylate adhesives) have proved successful in many cases. When choosing an adhesive, ensure that it has a suitably high viscosity to prevent the normal damage, above all on split surfaces. Polyolefins (e.g. polyethylene) can also be bonded to Sylomer®, Sylodyn® and/or Sylodamp® if chemically pretreated with primers.

<table>
<thead>
<tr>
<th>Primer</th>
<th>Plastic</th>
<th>Manufacturer</th>
<th>Website</th>
</tr>
</thead>
<tbody>
<tr>
<td>Marine Primer 5400A</td>
<td>PU, PMMA, PE amongst others.</td>
<td>3M</td>
<td><a href="http://www.3m.com">www.3m.com</a></td>
</tr>
<tr>
<td>OTTO Primer 1225</td>
<td>Plastics</td>
<td>Otto Chemie</td>
<td><a href="http://www.otto-chemie.de">www.otto-chemie.de</a></td>
</tr>
<tr>
<td>Primer 83 for adhesive tape</td>
<td>PVC</td>
<td>3M</td>
<td><a href="http://www.3m.com">www.3m.com</a></td>
</tr>
<tr>
<td>Primer Loctite 7239</td>
<td>PP, PE, Teflon, PMMA, ABS, PC</td>
<td>Henkel</td>
<td><a href="http://www.henkel.com">www.henkel.com</a></td>
</tr>
<tr>
<td>Sika Primer 3N</td>
<td>PU, PVC, EP</td>
<td>Sika</td>
<td><a href="http://www.sika.at">www.sika.at</a></td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Adhesive</th>
<th>Type</th>
<th>Manufacturer</th>
<th>Website</th>
</tr>
</thead>
<tbody>
<tr>
<td>3M Scotch Weld 7240 B/A FR</td>
<td>H 2-C</td>
<td>3M</td>
<td><a href="http://www.3m.com">www.3m.com</a></td>
</tr>
<tr>
<td>3M Scotch Weld 78 HT</td>
<td>C</td>
<td>3M</td>
<td><a href="http://www.3m.com">www.3m.com</a></td>
</tr>
<tr>
<td>3M Scotch Weld 90</td>
<td>C</td>
<td>3M</td>
<td><a href="http://www.3m.com">www.3m.com</a></td>
</tr>
<tr>
<td>3M Scotch Weld 9372W/9375W</td>
<td>Tape</td>
<td>3M</td>
<td><a href="http://www.3m.com">www.3m.com</a></td>
</tr>
<tr>
<td>3M Scotch Weld 9377</td>
<td>Tape</td>
<td>3M</td>
<td><a href="http://www.3m.com">www.3m.com</a></td>
</tr>
<tr>
<td>3M Scotch Weld 94 CA</td>
<td>C</td>
<td>3M</td>
<td><a href="http://www.3m.com">www.3m.com</a></td>
</tr>
<tr>
<td>3M Scotch Weld DP110</td>
<td>H 2-C</td>
<td>3M</td>
<td><a href="http://www.3m.com">www.3m.com</a></td>
</tr>
<tr>
<td>3M Scotch Weld VHB 5958</td>
<td>Tape</td>
<td>3M</td>
<td><a href="http://www.3m.com">www.3m.com</a></td>
</tr>
<tr>
<td>Araldite® 2014-1</td>
<td>H 2-C</td>
<td>Huntsman</td>
<td><a href="http://www.huntsman.com">www.huntsman.com</a></td>
</tr>
<tr>
<td>ASTORbond 12361</td>
<td>Tape</td>
<td>ASTORplast</td>
<td><a href="http://www.astorplast.at">www.astorplast.at</a></td>
</tr>
<tr>
<td>ASTORtack 11347</td>
<td>Tape</td>
<td>ASTORplast</td>
<td><a href="http://www.astorplast.at">www.astorplast.at</a></td>
</tr>
<tr>
<td>ASTORtack 11356</td>
<td>Tape</td>
<td>ASTORplast</td>
<td><a href="http://www.astorplast.at">www.astorplast.at</a></td>
</tr>
<tr>
<td>Elastan</td>
<td>H 1-C/H 2-C</td>
<td>BASF</td>
<td><a href="http://www.basf.com">www.basf.com</a></td>
</tr>
<tr>
<td>Icema R 101 P</td>
<td>H 2-C</td>
<td>H.B. Fuller</td>
<td><a href="http://www.hbfuller.com">www.hbfuller.com</a></td>
</tr>
<tr>
<td>Icema R 145/44</td>
<td>H 1-C</td>
<td>H.B. Fuller</td>
<td><a href="http://www.hbfuller.com">www.hbfuller.com</a></td>
</tr>
<tr>
<td>Körapur 666 + Köracur</td>
<td>H 2-C</td>
<td>Kömmerling</td>
<td><a href="http://www.koe-chemie.de">www.koe-chemie.de</a></td>
</tr>
<tr>
<td>Körapur 672 + Köracur</td>
<td>H 2-C</td>
<td>Kömmerling</td>
<td><a href="http://www.koe-chemie.de">www.koe-chemie.de</a></td>
</tr>
<tr>
<td>Loctite (Macroplast) 406</td>
<td>H 1-C</td>
<td>Henkel</td>
<td><a href="http://www.henkel.com">www.henkel.com</a></td>
</tr>
<tr>
<td>Loctite (Macroplast) 480</td>
<td>H 1-C</td>
<td>Henkel</td>
<td><a href="http://www.henkel.com">www.henkel.com</a></td>
</tr>
<tr>
<td>Loctite (Macroplast) UK 8101 B3</td>
<td>H 2-C</td>
<td>Henkel</td>
<td><a href="http://www.henkel.com">www.henkel.com</a></td>
</tr>
<tr>
<td>Loctite (Macroplast) UK 8202</td>
<td>H 2-C</td>
<td>Henkel</td>
<td><a href="http://www.henkel.com">www.henkel.com</a></td>
</tr>
<tr>
<td>Loctite (Macroplast) UK 8303 B60</td>
<td>H 2-C</td>
<td>Henkel</td>
<td><a href="http://www.henkel.com">www.henkel.com</a></td>
</tr>
<tr>
<td>Loctite (Macroplast) UR 7225</td>
<td>H 1-C</td>
<td>Henkel</td>
<td><a href="http://www.henkel.com">www.henkel.com</a></td>
</tr>
</tbody>
</table>
General adhesive information
Sylomer®/Sylodyn®/Sylodamp®

<table>
<thead>
<tr>
<th>Adhesive</th>
<th>Type</th>
<th>Manufacturer</th>
<th>Website</th>
</tr>
</thead>
<tbody>
<tr>
<td>Sikaflex -254 Booster</td>
<td>H 1-C</td>
<td>Sika</td>
<td><a href="http://www.sika.at">www.sika.at</a></td>
</tr>
<tr>
<td>Sikaflex -265 Booster</td>
<td>H 1-C</td>
<td>Sika</td>
<td><a href="http://www.sika.at">www.sika.at</a></td>
</tr>
<tr>
<td>Technicoll 8044</td>
<td>C</td>
<td>Technicoll</td>
<td><a href="http://www.technicoll.de">www.technicoll.de</a></td>
</tr>
<tr>
<td>Technicoll 8344</td>
<td>H 1-C</td>
<td>Technicoll</td>
<td><a href="http://www.technicoll.de">www.technicoll.de</a></td>
</tr>
<tr>
<td>Thixon 422</td>
<td>H 1-C</td>
<td>DOW</td>
<td><a href="http://www.dow.com">www.dow.com</a></td>
</tr>
<tr>
<td>Ultraflex 56</td>
<td>C</td>
<td>H.B. Fuller</td>
<td><a href="http://www.hbfuller.com">www.hbfuller.com</a></td>
</tr>
</tbody>
</table>

C = Contact adhesive, H 1-C = One-component adhesive, H 2-C = Two-component adhesive; Tape = Self-adhesive tape

2.5 Bonding Sylomer®/Sylodyn®/Sylodamp® to concrete and other mineral substrates

<table>
<thead>
<tr>
<th>Primer</th>
<th>Suitable for</th>
<th>Manufacturer</th>
<th>Website</th>
</tr>
</thead>
<tbody>
<tr>
<td>3M Primer 83 for adhesive tape</td>
<td>Concrete, oil, etc.</td>
<td>3M</td>
<td><a href="http://www.3m.com">www.3m.com</a></td>
</tr>
<tr>
<td>OTTO Primer 1225</td>
<td>Concrete, oil, etc.</td>
<td>Otto Chemie</td>
<td><a href="http://www.otto-chemie.de">www.otto-chemie.de</a></td>
</tr>
<tr>
<td>Sika Primer 3N</td>
<td>Concrete, oil, etc.</td>
<td>Sika</td>
<td><a href="http://www.sika.at">www.sika.at</a></td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Adhesive</th>
<th>Suitable for</th>
<th>Type</th>
<th>Manufacturer</th>
<th>Website</th>
</tr>
</thead>
<tbody>
<tr>
<td>3M Scotch Weld 9372W/9375W</td>
<td>Concrete</td>
<td>Tape</td>
<td>3M</td>
<td><a href="http://www.3m.com">www.3m.com</a></td>
</tr>
<tr>
<td>3M Scotch Weld 9377</td>
<td>Concrete</td>
<td>Tape</td>
<td>3M</td>
<td><a href="http://www.3m.com">www.3m.com</a></td>
</tr>
<tr>
<td>3M Scotch Weld Spray 90</td>
<td>Concrete</td>
<td>C</td>
<td>3M</td>
<td><a href="http://www.3m.com">www.3m.com</a></td>
</tr>
<tr>
<td>3M Scotch Weld VHB 5958</td>
<td>Concrete</td>
<td>Tape</td>
<td>3M</td>
<td><a href="http://www.3m.com">www.3m.com</a></td>
</tr>
<tr>
<td>Icema R 101 P</td>
<td>Concrete</td>
<td>H 2-C</td>
<td>H.B. Fuller</td>
<td><a href="http://www.hbfuller.com">www.hbfuller.com</a></td>
</tr>
<tr>
<td>Icema R 145/44</td>
<td>Concrete</td>
<td>H 1-C</td>
<td>H.B. Fuller</td>
<td><a href="http://www.hbfuller.com">www.hbfuller.com</a></td>
</tr>
<tr>
<td>Loctite (Macroplast) UK 8101 B3</td>
<td>Concrete, asphalt</td>
<td>H 2-C</td>
<td>Henkel</td>
<td><a href="http://www.henkel.com">www.henkel.com</a></td>
</tr>
<tr>
<td>Loctite (Macroplast) UK 8303</td>
<td>Concrete, asphalt</td>
<td>H 2-C</td>
<td>Henkel</td>
<td><a href="http://www.henkel.com">www.henkel.com</a></td>
</tr>
<tr>
<td>Ottocoll P83</td>
<td>Concrete</td>
<td>H 1-C</td>
<td>Otto Chemie</td>
<td><a href="http://www.otto-chemie.de">www.otto-chemie.de</a></td>
</tr>
<tr>
<td>Technicoll 8344</td>
<td>Concrete, asphalt</td>
<td>H 1-C</td>
<td>Technicoll</td>
<td><a href="http://www.technicoll.de">www.technicoll.de</a></td>
</tr>
<tr>
<td>Teroson (Terokal) SB 2444</td>
<td>Concrete</td>
<td>C</td>
<td>Henkel</td>
<td><a href="http://www.henkel.com">www.henkel.com</a></td>
</tr>
<tr>
<td>Weber.tec 920 (Montaplast K1/2)</td>
<td>Concrete, asphalt</td>
<td>H 1-C</td>
<td>Saint Gobain</td>
<td><a href="http://www.sg-weber.de">www.sg-weber.de</a></td>
</tr>
<tr>
<td>Weber.tec 922 (Plastikol UDM 2S)</td>
<td>Concrete, asphalt</td>
<td>H 2-C</td>
<td>Saint Gobain</td>
<td><a href="http://www.sg-weber.de">www.sg-weber.de</a></td>
</tr>
</tbody>
</table>

C = Contact adhesive, H 1-C = One-component adhesive, H 2-C = Two-component adhesive; Tape = Self-adhesive tape
2.6 Flammability and fire-resistant adhesives

Please note that the adhesives listed above may affect the flammability of the materials to be bonded. These adhesives do not have any flame-retardant properties. When using self-adhesive tapes (single and double-sided), it should be noted that these self-adhesive items may have a negative impact on flammability. Special flame-retardant and/or fire-resistant adhesives and adhesive tapes are commercially available upon request. A selection is listed below:

<table>
<thead>
<tr>
<th>Adhesive</th>
<th>Suitable for</th>
<th>Type</th>
<th>Manufacturer</th>
<th>Website</th>
</tr>
</thead>
<tbody>
<tr>
<td>3M – 9372W/9375W</td>
<td>Metal, wood, plastics</td>
<td>Tape</td>
<td>3M</td>
<td><a href="http://www.3m.com">www.3m.com</a></td>
</tr>
<tr>
<td>3M – 9377</td>
<td>Metal, wood, plastics</td>
<td>Tape</td>
<td>3M</td>
<td><a href="http://www.3m.com">www.3m.com</a></td>
</tr>
<tr>
<td>Scotch Weld 7240 B/A</td>
<td>Metal, wood, plastics</td>
<td>H 2-C</td>
<td>3M</td>
<td><a href="http://www.3m.com">www.3m.com</a></td>
</tr>
<tr>
<td>VHB self-adhesive tape 5958</td>
<td>Metal, wood, plastics</td>
<td>Tape</td>
<td>3M</td>
<td><a href="http://www.3m.com">www.3m.com</a></td>
</tr>
</tbody>
</table>

C = Contact adhesive, H 1-C = One-component adhesive, H 2-C = Two-component adhesive; Tape = Self-adhesive tape

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