



Rockpanel Tack-S Adhesive system



Product

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

Application

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

Rockpanel Tack-S features

- Solvent and isocyanate-free.
- Durable, highly elastic, with optimum stress distribution.
- Good moisture and weather resistance.
- Quick and easy mounting.

Certification and fire classification

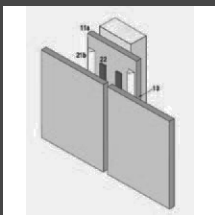
- Listed in the European Technical Approval, ETA 07/0141, for Rockpanel® panels
- Listed in IKOB-BKB CERTIFICATE NL-associated document to ETA-07/0141, no. IKB1718
- Glued Rockpanel boards, of Rockclad or AG type, 8mm thick, fall in the European fire class B-s2, d0



Rockpanel adhesive system

The bonding system consists of:

- Rockpanel Tack-S highly elastic adhesive.
- Primer MSP primer for backside of Rockpanel boards
- Liquid 1 for pretreatment of the front side of the Rockpanel strips in case timber battens are used.
- Prep M for pretreatment of aluminium support profiles.
- FoamTape for the initial bonding of the panels and a spacer to obtain a sufficient thick adhesive layer.



Rockpanel Tack-S Adhesive system

Information for the construction 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 definitive criterion for failure.

Wind load

Characteristic value of stress (wind load): 4,290 N/m¹ adhesive head.
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 $\gamma_m \cdot \gamma_f$ of 3.

Support distances

For the maximum support distances please consult Rockpanel.

NOTE: horizontal applications (soffit, canopy, awnings, ceilings)

For horizontal 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. For horizontal applications preferably apply the battens perpendicular to the façade.



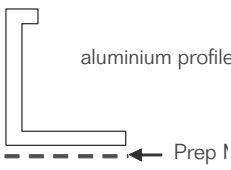
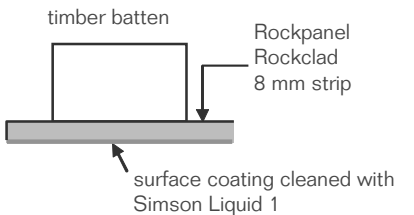


Rockpanel Tack-S Adhesive system

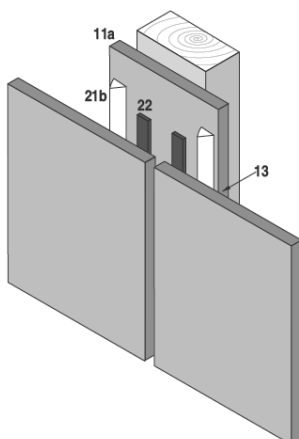
Indication of consumption per 100 m²

Surface of Rockpanel panel	number	standard packaging
Simson FoamTape	12 rolls	25 metres
Simson Rockpanel Tack-S	50 cartridges	290 ml
Simson Primer MSP (back side of Rockpanel)	6 cans	500 ml
Simson Liquid 1 (Rockpanel strip)	1 can	1000 ml
Simson Prep M (metal)	2 cans	500 ml

Detailed drawings of Rockpanel Tack-s Adhesive system

Figure 1 shows drawings of the basic principle for adhesion to aluminium profiles and mechanically fixed Rockpanel strips on wooden battens. Drawing 1-204b shows the vertical joint with Rockpanel strip on timber battens.

		Aluminium profile	Timber batten with Rockpanel strip
Types of ventilated underlying structures			
Materials same for both supporting structures	adhesive/ tape		
	primer and panel		



- 11a. 8 mm Rockpanel Rockclad strip; strip mechanically attached with Rockpanel nails or screws
- 13. Reverse side treated with MSP Primer (transparent)
- 21b. Triangular Tack-S adhesive bead with height of 9 mm
- 22. 2-sided adhesive FoamTape, 3*12 mm

Detail 1-204B.

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

Information 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 100-150 mm 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 gently 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 Adhesive system

Technical data

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 & Article code	290 ml cartridges	131441
	600 ml sausage	131411
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.	

Special nozzle

For gunning 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.

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 & Article code	500 ml	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.

Further information

Consult information on www.rockpanel.com

The following publications are available on request:

- Material Safety Data Sheets (MSDS)
- European Technical Approval, ETA 07/0141

Bostik B.V.

Postbus 303
5201 AH 's-Hertogenbosch
Tel: +31 (0)73 6 244 244
Fax: +31 (0)73 6 244 344
E-mail: infonl@bostik.com
Internet: www.bostik.nl

Bostik Belux SA-NV

Meulestedekaai 86
B-9000 Gent
Tel: +32 (0)9 255 17 00
Fax: +32 (0)9 255 17 01
E-mail: info@bostik.be
Internet: www.bostik.be

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

Technical characteristics	for Rockclad strips surface	
Dry matter content	0 %	
Colour	transparent	
Minimum drying time	5 minutes	
at 20°C/50% RH		
Maximum processing time	n/a minutes	
Packaging & Article code	container 1000 ml	25380
Processing temperature	+5 / +30°C	
Shelf life	Can be stored 12 months (after production) in unopened packaging	

Prep M

Technical characteristics	for aluminium	
Dry matter content	17 %	
Colour	transparent	
Minimum drying time	10 minutes	
at 20°C/50% RH		
Maximum processing time	n/a minutes	
Packaging & Article code	container 500 ml	22110
Processing temperature	+5 / +30°C	
Shelf life	Can be stored 12 months (after production) in unopened packaging	

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

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/m ³
Packaging	25 meters/roll
Working temperature	+5 / +35 °C
Shelf life	Can be stored for 12 months
Packaging & Article code	25 metre rol 182771

For more information consult the product safety sheets at www.bostik.nl.