



## Adhesive fixing for pre-finished plywood panels to ceilings without mechanical fastenings

Plymasters

### Scenario – Ceilings

#### Purpose

For the bonding of “**Plymaster Pre-finished**” Linings for an interior ceiling application. This specification is designed for the securing of the Plymaster product without the need for mechanical fastenings. The following specification relates to residential applications only.

#### Products Required

- [Fix All High Tack](#) 290ml Cartridges #20303,
- [Holdfast Double Sided Foam Tape](#) 12mm x **2mm** x 30m #56665
- [Soudal Surface Activator](#) #19389 (adhesion promoter for prefinished surface & steel battens)
- [Soudal Primer 150](#) #20057 (adhesion promoter to timber battens)
- Clean Cloths for application of cleaner
- [Soudal Trade Tough Wipes](#) #46012
- [Soudal Sealant Remover](#) #175692

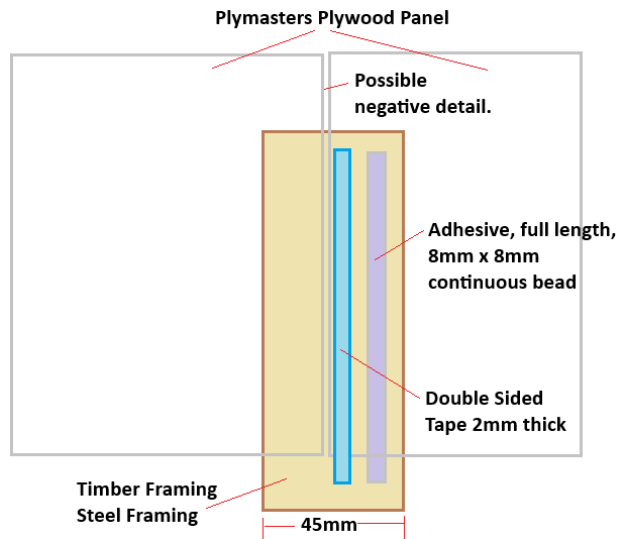
### Procedure

**Step 1** Ensure you read the Product Technical Documents before you begin. If at this point you have any questions, please contact your local Soudal Territory Manager.

**Step 2** Ensure that the walls that you are working with are straight and flat, use a straight edge for this. Where this is not so, there may be additional stresses on the bonded joints once applied.

Batten placement for walls:

1. All Frame/Battens - No greater than 600mm apart, 45mm wide
2. Negative detail 5mm or less – Follow line drawing  
 Timber & Steel Battens/Framing:  
 - if creating a “negative detail greater than 5mm”, you need to double batten along all edges that will have the “negative detail” (as you will not have sufficient space for both the adhesive or tape.



**Step 3** Ensure that the “coated non-visual side” of the “**Plymasters Plywood Prefinished**” has had the Soudal Surface Activator applied in the corresponding locations to the positioning of the ceiling battens where the Fix All high Tack will be placed in continuous beads.

All timber battens are to have Soudal Primer 150 applied to them to improve the adhesion of the adhesive.

- Leave to dry for a period of not less than 60-minutes before applying the sealant (longer in colder conditions) and not longer than 4 Hours.
- You should only forward “prime” the “Timber Battens” what you are intending to install within the next 4 hours. Failure to not follow this has the potential to reduce the adhesive bond strength to the panel.

All steel battens are to be wiped down with the Soudal Surface Activator to improve the adhesion of the adhesive and remove any contaminants. Leave to dry for a period of 5-10 minutes (longer in colder conditions).

**Step 4** Position the tape, full length onto the battens down one side. This allows room for the application of the adhesive (Fix All High Tack) so that when compressed the adhesive does not flow over the tape, and therefore reducing the initial hold of the tape, (Holdfast Double Sided Tape 2.00mm).

**Step 5** Position 7-8mm continuous beads of adhesive the full length approx. 20-25mm from the applied tape. When the 7-8mm bead of adhesive is compressed to 2mm thick, it is now approx. 15mm wide.

**Step 6** Press back into position and press to the ceiling. Support the panel while pressing to the ceiling for a period of not less than 72hours under ideal conditions.

- The Double-Sided Tape provides the initial bond while the adhesive provides the secondary bond. As the adhesive cures the primary bond is taken by adhesive.

**Note:** As environmental conditions cool, curing times extend for adhesives & sealants. Soudal cannot determine what the impact that colder conditions will have on the curing rate as this is a local consideration.

**Step 7** Soudal recommends where possible to use either hidden mechanical fixings at the other edge of the panels, or a limited number of appropriate length (approx. 40mm) panel pins to provide greater initial strength and support during the curing process.

- By using the panel pins, this will reduce the “propping” time required.
- Placement of the “panel pins” is as directed by the panel supplier.

**Step 8** If you get the Fix All High Tack Adhesive on the pre-finished visual surface, before it is cured, this can be wiped off with the Soudal Trade Tough Wipes.

Once the adhesive has cured onto the pre-finished surface, it can be removed with the Soudal Sealant Remover.

**The following points should be noted:**

- Lower temperatures will dramatically increase the time required for the adhesive to fully cure.
- Preparation is critical to success

If you have any further questions do not hesitate to contact [Soudal NZ Ph:0800701080](tel:0800701080)

**Step 7** If you are choosing to use mechanical fasteners, then these should be fixed now.

**Step 8** You need to avoid getting the adhesive on to the un-coated surface. If you do get adhesive onto the surface, clean off using the Soudal Trade Wipes before it cures.

**The following points should be noted:**

- Lower temperatures will dramatically increase the time for the adhesive to fully cure.
- Preparation is critical to success.

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