



## Adhesive fixing for un-coated plywood panels - Without mechanical fastenings

Plymasters

### Scenario – Wall Linings

#### Purpose

For the bonding of “**Plymaster Un-Coated**” Linings for an interior application. This specification is designed for the securing of the Plymaster product without the need for mechanical fastenings or support while curing is taking place. (*Note: “Mechanical Fasteners” can be used if required for an architectural finish and additional support*)

#### Products Required

- [Soudaseal 240FC](#) 600ml Sausage #20098 or
- [Fix All High Tack](#) 290ml Cartridges #20303
- [Holdfast Double Sided Foam Tape](#) 12mm x **2mm** x 30m #56665
- [Soudal Solvent Cleaner](#) (for reverse of prefinished panels & framing) #37013
- [Soudal Primer 150](#) for Porous surfaces on reverse of the plywood
- Clean Cloths for application of cleaner
- [Soudal Trade Tough Wipes](#) #46012

#### 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.

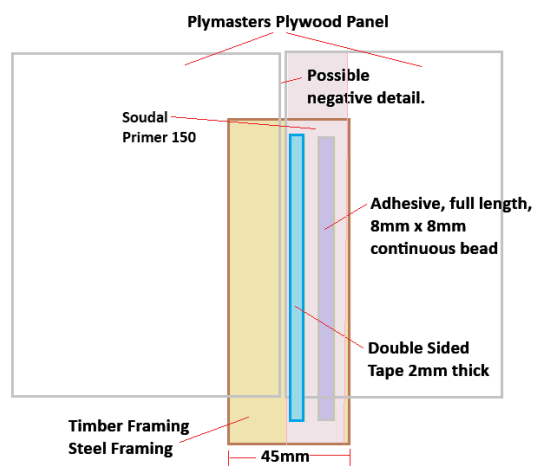
**Step 2** Ensure that the walls that you are working with are straight and flat, use a straight edge for this. Where this is not so, there may be additional stresses on the bonded joints once applied.

Batten placement for walls:

1. All Frame/Battens - No greater than 600mm apart, 45mm wide
  - a. *For Pre-lined walls we recommend that you work on the base of 450mm between beads of adhesive.*

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).



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Date: 24<sup>th</sup> March 2025

**Step 3** Ensure that the “coated non-visual side” of the “**Plymasters Plywood Un-Coated**” has Soudal Primer 150 applied in the corresponding locations to where the (Soudaseal 240FC/Fix All High Tack) will be applied in continuous beads.

**“All Framing” (Steel/Timber)** - the Soudal Solvent Cleaner needs to be wiped/applied along the full length of these to correspond with the adhesive that will be applied.

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 (Soudaseal 240FC/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** Set H-Packers (or an aluminum support angle) along the floor to set your predetermined height for the panel from the floor base.

Place 7mm – 8mm continuous beads of adhesive the full length approx. 10-25mm from the applied tape. When the 7-8mm bead of adhesive is compressed to 2mm thick, it is now approx. 15-18mm wide.

**Step 6** Set and press the un-coated plywood panel into position back against the wall. The Holdfast Double Sided Tape provides the initial bond while the Soudaseal 240FC/Fix All High Tack provides the secondary bond. As the adhesive cures the primary bond is taken up by the Soudaseal 240FC/Fix All High Tack.

**Note:** As environmental conditions cool, then the curing times of the adhesives are slower.

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

**Step 8** You need to avoid getting the adhesive (Soudaseal 240FC/Fix All High Tack) on to the un-coated surface.

**The following points should be noted:**

- Lower temperatures will dramatically increase the time 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)