

Panel Bond

The adhesive system
for the invisible
fastening of façade
panels.





→ Reference project
Wijnhavenkwartier, Den Haag,
Netherlands

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Area of application and components

The fischer Panel Bond system makes the invisible fastening of particularly thin façade panels on a subframe possible, thus ensuring an elegant and attractive appearance for the building as well as saving material costs.



Primer for porous materials

Primer PU

Solvent mix for pre-treating the surfaces of subframes or façade panels before application of Panel Bond PU. Primer PU is used **on porous materials** (e.g. wood or stone), **strengthens the surface of the materials** and ensures an **ideal connection** to the Panel Bond PU adhesive.

Can, 1l
Primer PU, art. no.: 576456



Primer for non-porous (smooth) materials

Cleanprimer SI

Solvent mix for **cleaning** and **activating** the subframe or façade panels before application of Panel Bond SI. Cleanprimer SI is used **on non-porous**, i.e. smooth surfaces (such as metals, plastics or painted surfaces).

Can, 1l
Cleanprimer SI, art. no.: 576452

Cleanprimer PU

Solvent mix for **cleaning** and **activating** the subframe or façade panels before application of Panel Bond PU. Cleanprimer PU is used **on non-porous**, i.e. smooth surfaces (such as metals, plastics or painted surfaces).

Can, 1l
Cleanprimer PU, art. no.: 576455

Panel Bond System

The fischer Panel Bond System was specially developed for bonding façade panels directly to subframe profiles on the construction site.

It can also be used within the context of prefabrication in the factory to bond mechanical fasteners to the back of façade panels. Controlled ambient conditions are an advantage of prefabrication in the factory. Depending on the production process, prefabrication could be done without the Panel Bond Tape.



Double-sided adhesive tape for initial bonding

Panel Bond Tape

The Panel Bond Tape is a **powerful, elastic, double-sided** adhesive tape. It ensures **sufficient initial bond** until the liquid adhesives Panel Bond SI or Panel Bond PU are fully cured. In addition, Panel Bond Tape sets a defined joint thickness of 3 mm, so that the joint can absorb **movements later**.

Roll 25 m, width: 12 mm, thickness: 3 mm
Panel Bond Tape, art. no.: 576457

The following pages focus on bonding on the construction site.

For more information on bonding in the factory please contact: → info@bwm.de

Certificate



ETA-24/1211, ETA-25/0354
Adhesive for wall cladding



Adhesive for permanent and safe fastening

fischer Panel Bond SI

Single-component, elastic silicone adhesive for bonding façade panels. Compared with Panel Bond PU, Panel Bond SI offers an **extended temperature range of -40°C to 110°C**, which is advantageous in extremely hot regions or for surfaces with very high light absorption. No isocyanate training is necessary for users either. Following project-specific testing and release by fischer, Panel Bond SI can also be used for natural stone panels.

Foil bag, 600 ml
Panel Bond SI, art. no.: 576451

fischer Panel Bond PU

Single-component, elastic polyurethane adhesive for bonding façade panels. With a **temperature range of -40°C to 90°C**, Panel Bond PU is the **cost-efficient** alternative to Panel Bond SI.

Foil bag, 600 ml
Panel Bond PU, art. no.: 576454

→ Reference project
Office building, Venlo,
Netherlands



Ambient and workplace conditions

The Panel Bond System is suitable for the bonding of façade panels on the construction site. Nevertheless, ambient conditions have a decisive impact on the safety of the bond, which is why the limits described below must always be observed.

Generally speaking, the workplace should be as **dust-free and dry** as possible. **The temperatures permitted for processing are in the range of 5 - 40 °C.** In addition, the temperature of all the materials to be bonded and the adhesive must be **at least 3 °C above dewpoint**. The **relative air humidity** must not exceed **maximum 80%**.

This prevents the condensation of air humidity on the materials, which would have a negative impact on the adhesion of the adhesive and lead to failure. Bonding must not be carried out in rain or fog. The workplace and the materials to be bonded should be protected as well as possible from direct influences of the weather.

Closed and open components of the Panel Bond System should be protected as well as possible from direct sunlight, particularly during storage at the construction site.

Within the first few hours after bonding, the ambient temperature must not fall below +5 °C, since the adhesive cures through humidity in the ambient air, which means the curing process is interrupted if the air is too cold and thus dry.

Overview of the conditions

- Workplace as dust-free and dry as possible
- Ambient temperature +5 °C to + 40 °C
- The relative air humidity must not exceed maximum 80%
- No rain or fog
- Temperature of the materials to be bonded and the adhesive at least 3 °C above the dewpoint
- Protect the materials to be bonded and the adhesive from the weather and direct sunlight

Adhesive application

Adhesive

The Panel Bond adhesives can be applied with the aid of manual, pneumatic or battery-powered dispensers from the 600 ml foil bag. It is mandatory to use the V-nozzle included in order to ensure the required joint dimension of at least 12 mm x 3 mm in the installed state → Fig. 1 and 3. Application should be as even as possible and especially bubble-free. Hold the dispenser vertically to the surface and align the V-opening 180° to the direction of application so that the bead forms the necessary V-shape → Fig. 2.

The panels must be installed before the skin formation time is reached. After the skin formation time has been reached, a thin skin forms on the surface of the adhesive, which would interfere with the adhesion on the panels. The skin formation time depends on the temperature, air humidity and age of the adhesive. The table below shows the skin formation time of the Panel Bond adhesives depending on temperature and relative humidity.

Skin formation time (orientation)

Panel Bond adhesives				
Type	Temperature	Relative air humidity		
	[°C]	40%	60%	80%
Panel Bond SI	10 °C	20 min	> 40 min	> 40 min
	20 °C	15 min	25 min	35 min
	30 °C	10 min	20 min	30 min
	40 °C	5 min	15 min	20 min
Panel Bond PU	10 °C	> 40 min	> 40 min	> 40 min
	20 °C	> 30 min	> 25 min	> 20 min
	30 °C	20 min	15 min	10 min
	40 °C	15 min	10 min	5 min

As can be seen in the table, higher temperatures in particular reduce skin formation time, which is why it always has to be determined each day and in the event of major deviations in the weather conditions (for how to determine the skin formation time under different ambient conditions see → Page 14 Quality assurance → Measures).

The table is for orientation only and does not take the age and storage conditions of the adhesive into account. The skin formation time becomes shorter as storage time increases, particularly if storage is outside the specified storage temperatures (max. 25 °C). For this reason, the skin formation time must always be determined every day on site.



Nozzle included
Fig. 1

Adhesive application

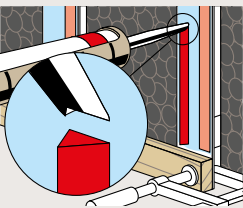


Fig. 2

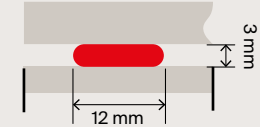
Dimension of the nozzle and the finished adhesive joint

Shape of the bead applied



Fig. 3

Resulting adhesive joint after the façade panel has been mounted



Primer application

Primer

There are different primers available for each Panel Bond adhesive (Panel Bond SI and Panel Bond PU). Which primer has to be used depends on the materials to be bonded and can be taken from the substrate table. Clean primers (Cleanprimer SI and Cleanprimer PU) must be applied using a lint-free cloth → Fig. 4 and film-forming primers (Primer PU) with a solvent-resistant roller or brush → Fig. 5. Clean primers clean and activate the surface in the same step and are to be used for non-porous, i.e. smooth surfaces (such as metals, plastics or painted surfaces). Here, the cloth is wetted with the clean primer and applied by wiping in one direction (e.g. from top to bottom), at the same time removing dirt. Film-forming primers are brushed on and leave a thin film on the material which strengthens the surface. They must be used for porous materials (such as stone or wood).

Do not apply the primer directly out of the original packaging onto the cloth, roller etc. in order to avoid soiling in the original packaging. Use solvent-resistant intermediate containers such as small trays or bottles in which you pour small amounts of the primer from the original packaging as required. Make sure that the cloths, rollers and intermediate containers are and remain free of dirt. Cloths and rollers in particular must be replaced regularly. Primers must always be applied to the subframe and the panel material.

The flash-off time of the various primers is 10 minutes at 23 °C and 50% relative humidity (is reduced at higher temperatures). Bonding must take place within the open time of 12 hours after primer application.

Flash-off times

Primer	Cleanprimer SI, Cleanprimer PU, Primer PU
Flash-off time (at 23 °C / 50% rel. hum.)	10 min
Open time	12 h

Substrate table

	Manufacturer	Type	Sanding down	Cleaning	Primer	Adhesive
Subframe	E.g. BWM	Vertical profiles, uncoated aluminium EN AW 6063 T66	Abrasive cloth Sandpaper grit > 300	Cleanprimer SI, Cleanprimer PU, solvent cleaner which flash off completely without residue ¹⁾	Cleanprimer SI Cleanprimer PU	Panel Bond SI Panel Bond PU
Subframe	E.g. BWM	Vertical profiles, anodised aluminium EN AW 6063 T66 - E6 / C-35 black	–	Cleanprimer SI, Cleanprimer PU, solvent cleaner which flash off completely without residue ¹⁾	Cleanprimer SI Cleanprimer PU	Panel Bond SI Panel Bond PU
HPL façade panels	Trespa	Meteon	–	Cleanprimer SI, Cleanprimer PU, solvent cleaner which flash off completely without residue ¹⁾	Cleanprimer SI Cleanprimer PU	Panel Bond SI Panel Bond PU
Ceramic façade panels	Cosentino	Dekton	–	Cleanprimer SI, Cleanprimer PU, solvent cleaner which flash off completely without residue ¹⁾	Cleanprimer SI Primer PU	Panel Bond SI Panel Bond PU
Metal composite façade panels	Mitsubishi	Alpolic	–	Cleanprimer SI, Cleanprimer PU, solvent cleaner which flash off completely without residue ¹⁾	Cleanprimer SI Cleanprimer PU	Panel Bond SI Panel Bond PU
Natural stone	Exclusively after project-specific testing and release by fischer.					Panel Bond SI

¹⁾ e.g. fischer solvent cleaner PUR500 or 100% ethanol. Note the information on page 10.

Application of Cleanprimer with a lint-free cloth

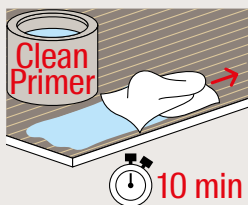


Fig. 4

Primer application with solvent-resistant roller (comparatively small paint roller)

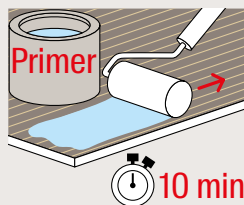


Fig. 5

Installation steps

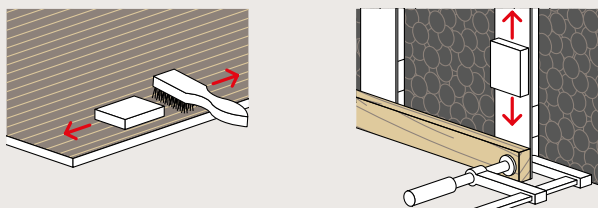
1. Complete the installation log

The Panel Bond installation log (see → **Page 17** and → www.fischer.de) must always be completed fully and stored. If the installation log is not completed fully, warranty will be voided. The installation log must be completed every day and every time there are major weather changes.

2. Pretreatment and cleaning

All surfaces must be clean, dust- and grease-free as well as dry before primers or clean primers are applied. Some materials have to be sanded additionally with an abrasive cloth or very fine sandpaper (min. grit 300). This is the case with uncoated i.e. non-anodised aluminium subframes, in order to remove the oxide layer. Whether or not sanding is necessary can be seen in the substrate table.

General information on cleaning: With porous materials (e.g. stone or wood) no liquid cleaner should be used since the substrate can become saturated with cleaner. In these cases, dust or soiling must be removed by brushing or sanding. On non-porous i.e. smooth surfaces, soiling may only be removed using cleaners that flash off completely residue-free. Solvent cleaners such as Cleanprimer SI, Cleanprimer PU, the acetone-based cleaner PUR 500 (art. no. 53085) or 100% ethanol are recommended. Care must be taken that the surfaces are compatible with the cleaner, particularly in the case of plastics.

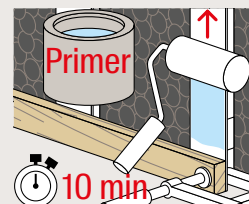
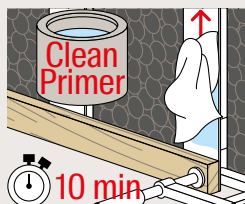
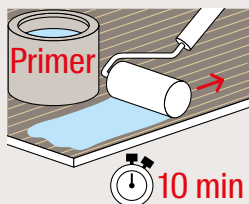
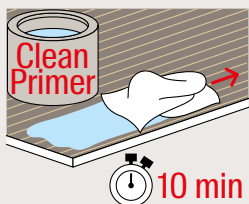


3. Apply clean primer or primer

After sanding or cleaning, the primer is applied in the next step. Which primer has to be used depends on the materials to be bonded and can be taken from the substrate table. Clean primers (Cleanprimer SI and Cleanprimer PU) must be applied with a lint-free cloth and film-forming primers (Primer PU) with a felt sponge or brush. Clean primers clean and activate the surface in the same step and are to be used on non-porous i.e. smooth surfaces (e.g. metals, plastics or painted surfaces). Here, the cloth is wetted with the clean primer and applied by wiping in one direction, at the same time removing dirt. Film-forming primers are brushed on

and leave a thin film on the material. They must be used for porous materials (such as stone or wood). Primers and clean primers should only be applied in single layers as far as possible. The subframe and the panel material always have to be treated with the respectively recommended primer.

The flash-off time of the clean primers and primers is 10 minutes at 23 °C and 50% relative humidity (is reduced at higher temperatures). Bonding must take place within the open time of 12 hours after primer application. If this time is exceeded, the installation steps from point 1 must be repeated.

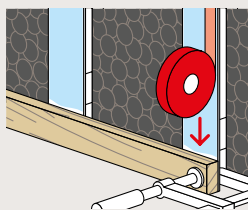


General note

Always only prepare as many panels with primer and adhesive as can be installed within the processing time (see → **Page 8 and 9** section adhesion and primer application).

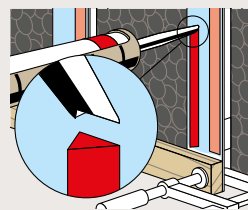
4. Install adhesive tape

Attach the Panel Bond Tape along the entire length of the subframe parallel to the edges. Do not remove the protective film from the outside yet.



5. Apply adhesive

Apply the Panel Bond adhesive along the entire length of the subframe parallel to the adhesive tape at a minimum clearance of 5 mm to the adhesive tape as well as to the outer edge of the subframe. It is mandatory to use the V-nozzle included → **Fig. 1, Page 8**. Application should be as even as possible and especially bubble-free. Hold the dispenser vertically to the surface and align the V-opening 180° to the direction of application so that the adhesive bead forms the necessary V-shape.



6. Attach façade panel

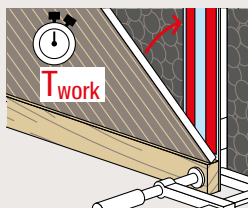
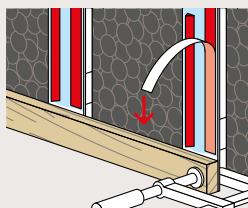
Once the protective film has been removed from the adhesive tape, the façade panel can be attached.

It is particularly important here to ensure that the façade panel is positioned exactly before it is pressed in place, since it can no longer be moved following contact with the adhesive tape.

A profile can be used here to align the façade panels before they are pressed in place.

After the façade panel has been aligned, press it evenly onto the adhesive tape and adhesive, without crushing the adhesive tape.

The façade panel must be pressed in place before the skin formation time is reached (for duration of the skin formation time see → **Page 8** section adhesive application). The skin formation time starts as soon as the adhesive is applied.



Structure of the façade system

Structure of the subframe

Every subframe must be designed in accordance with the local regulations and be accepted by the construction site manager responsible. The specifications and design recommendations of the panel manufacturers must also be taken into account.

Loads and movements of the load-transferring building shell must not be transferred to the adhesive joint. In addition, the subframe should be designed in such a way that it can compensate the thermal expansion of the panels in order to keep the mechanical load on the adhesive caused by thermal expansion to a minimum.

The profiles of the vertical subframe must be installed levelled and parallel in order to ensure an even load transfer between the subframe and the panels. The centre distances between the subframe profiles and their width must take the design limits of the panels and the adhesive and the local regulations and environmental influences into account. Subframes approved for bonding using the fischer Panel Bond adhesive system can be found in the substrate table on → [Page 9](#). The dimensioning values of the fischer Panel Bond adhesive system are summarised on → [Page 13](#).

Structure of the adhesive system

The schematic structure of the adhesive system is explained below. This must always be taken into account. Deviations must be agreed in advance with fischer and approved by fischer.

Figure 6.1 illustrates the state of the adhesive bead and the Panel Bond Tape before installation of the façade panels. If two panels or a panel joint is fixed to a subframe profile, the tape must be located at the outer edge of the panels to provide additional weather protection for the adhesive. If the panels overlap the subframe profile, adhesive and Panel Bond Tape are positioned centrally on the profile. Generally speaking, positioning is recommended to be as central and symmetrical as possible, taking the necessary clearances → [Fig. 6.1](#) and [6.2](#) into account.

Figure 7.1 illustrates the state after installation of the façade panels. The upper diagram shows the installation of two façade panels on a subframe profile, and the lower diagram shows a panel that overlaps the subframe profile. The adhesive is pressed to the thickness of the tape by pressing the panels in place. Thus the height of the adhesive joint is 3 mm and the width 12 mm. This is why the outer edge of the non-pressed adhesive bead must always be positioned at least 5 mm away from the edge of the profile and the Panel Bond Tape. The clearance between the façade panels must be chosen in such a way that a collision caused by movement (e.g. thermal expansion) is avoided.

Fig. 6.1
Before installation of
the façade panels.

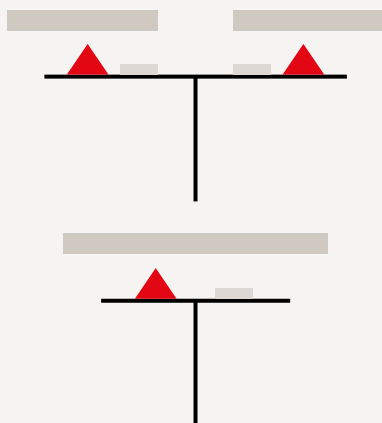


Fig. 6.2
Clearance between
tape and adhesive
bead of at least
5 mm, and 5 mm
away from the
outer edge.



Fig. 7.1
After installation of
the façade panels.

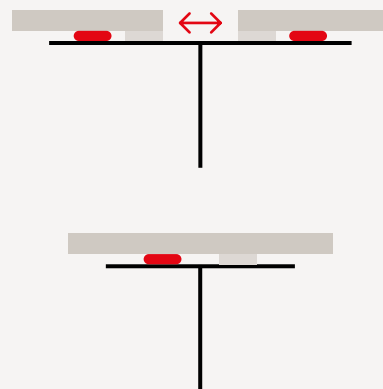
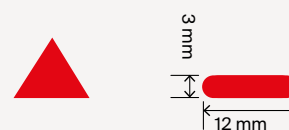


Fig. 7.2
The adhesive bead
is pressed together
by the façade module
during installation.
It results in a width
of 12 mm and a
height of 3 mm.



Dimensioning

Dimensioning of the façade structure

A structural analysis of the entire façade structure in accordance with local regulations must be carried out and approved by the structural façade designer. The requirements and limits of the subframe as well as the façade panels must be taken into account here; these are prescribed by the respective manufacturers.

General note

fischer does not accept any responsibility for the dimensioning or approval of the façade structure.

The following dimensional values must be taken into account for dimensioning of the adhesive bond with the fischer Panel Bond systems:

Dimensional values for load-bearing capacity	
Thickness of the adhesive bead	3 mm
Width of the adhesive bead	12 mm
Dimensional value of the load resistance for tensile load	0.15 N/mm ²
Dimensional value of the load resistance for shear load	0.03 N/mm ²
Max. approved shear strain	1.50 mm

The loads on the adhesive bond relevant for dimensioning are a result of the size of the façade panels and thus the surface exposed to local wind pull and wind pressure loads as well as the weight load. In addition, the maximum shear strain acting on the adhesive joint must be checked. Loads and movements of the load-transferring building shell must not be transferred to the adhesive joint. In addition, the subframe should be designed in such a way that it can compensate the thermal expansion of the panels in order to keep the mechanical load on the adhesive caused by thermal expansion to a minimum. The load on the adhesive joint depends on the adhesive area, which is a result of the clearances between the subframe profiles as well as panel size and geometry.

If you need support in dimensioning the adhesive bond for your project, please contact fischer

→ **BWM façade systems**

→ **info@bwm.de**

Quality assurance

Quality control

Bonding on the construction site is a manual process and is influenced by ambient conditions which can fluctuate especially outdoors. For this reason, it is absolutely necessary to take every specification and every step into careful consideration and execute high-quality work. The processor is responsible for quality checks. fischer recommends the following quality assurance measures as a minimum and excludes warranty if they are not heeded.

Skin formation time

After the skin formation time is reached, a thin skin forms on the surface of the adhesive, which would interfere with the adhesion on the panels. The skin formation time depends on the temperature and air humidity. The skin formation times of the Panel Bond adhesives under different climatic conditions are given on → **Page 8** as an orientation. Due to the high relevance for the safety of the bond, this must be checked every day on the construction site under real conditions and documented. The panels must be installed before the skin formation time is reached.

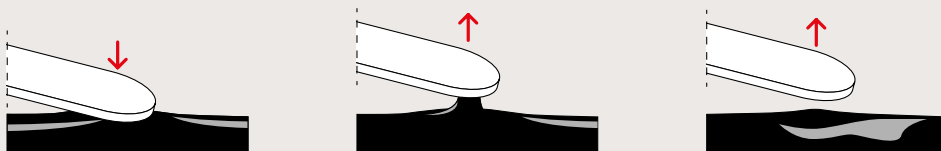
Training and certification

Every person responsible on the construction site must have taken part successfully in user training on the Panel Bond System and have received a certificate. The training is carried out directly on site or at a training facility by fischer or an authorised fischer partner. The certificate is issued after a training unit and remains valid for 5 years. Training must be repeated for the certificate to be renewed. In addition, repeating the training is recommended if the worker has not done any bonding for the past 12 months.

Test sequence:

1. Application of an adhesive bead about 20 cm long on any surface (e.g. paper, cardboard or film); the stopwatch is started.
2. The adhesive surface must be touched lightly with a blunt object (e.g. wooden spatula or plastic adhesive nozzle) every 5 minutes.
3. Check whether the adhesive sticks to the object following the slight contact and produces tails when it is moved away. If this does not happen, skin has already formed. This point in time must be recorded on the installation log. A new spot on the adhesive bead must be chosen for each test.

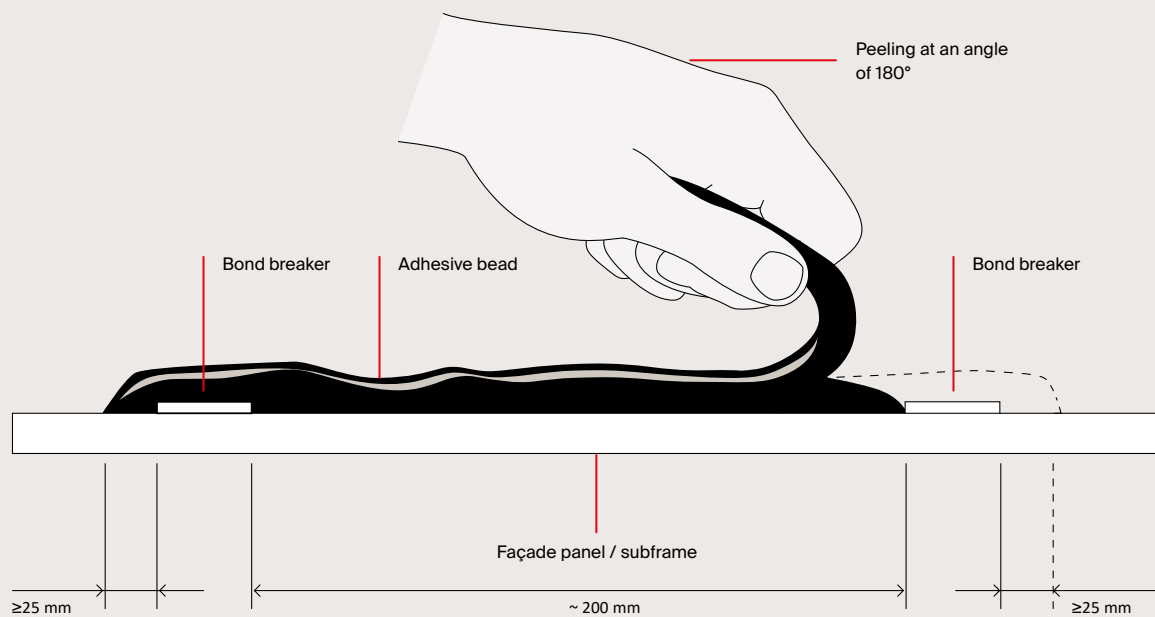
In addition to daily testing, this must also be repeated in the event of more major fluctuations in weather conditions.



Peel test

Due to the numerous subframes and panels available, the fischer Panel Bond adhesive must be tested on the panels and subframe before every project by means of a peel test. The same surface pre-treatment (sanding if necessary, cleaning, priming) must be carried out as in the later project. Approved materials and the corresponding surface pre-treatment are listed in the substrate table on → **Page 9**. Only approved materials may be bonded using the fischer Panel Bond adhesive. Other materials must be agreed with fischer in advance and released by tests.

Instructions for a 180° peel test are shown below. The test is done manually and without mechanical force measurement. It serves as a simple visual test to get a qualitative estimate of the adhesive adhesion to a façade module.



Instructions: manual 180° peel test

Materials and equipment:

- Façade panel
- Subframe profile
- Adhesive
- Flexible film or commercially available adhesive tape (as “bond breaker”)
- Cutting tool (e.g. cutter or scissors)

1. Preparing the samples

Pre-treatment of the surfaces:

- Depending on the material, sand and/or clean the surfaces in accordance with the sections substrate table and installation steps and apply primer (the pre-treatment for the peel test must be the same as in the final project).

Adhesive application:

- Apply two strips of the bond breaker 200 mm apart on the surface of the material to be tested (façade panel or subframe profile).
- Apply the adhesive in accordance with the instructions on → **Page 8** to the surface and beyond the bond breakers.
- Make sure that no air bubbles or folds develop in order to guarantee even bonding.

Curing time:

- Allow the adhesive to cure for at least 3 days.

2. Carry out the test

Manual peeling:

- Cut into the adhesive up to the start of one of the bond breakers in such a way that you can grasp the adhesive bead and pull it off the surface of the bond breaker.
- Pull the adhesive bead at an angle of 180° off the surface evenly up to the other bond breaker.

Observations during the test:

- Pay attention to whether a layer of adhesive remains bonded to the surface or disbonds completely. It is important to recognise whether there is an adhesion failure (adhesive disbonds completely from the surface) or a cohesion failure (adhesive tears within the adhesive layer and a layer of adhesive remains bonded to the material).
- If part of the adhesive is still liquid on the inside, the curing time was insufficient and the test must be repeated.

3. Evaluation of the results

Requirement:

- Cohesive failure of the adhesive bead of at least 90% (means a maximum possible adhesive failure of 10%).
- If this requirement is not fulfilled, the material is not suitable for bonding with the fischer Panel Bond.
- If the surface of the material to be tested is torn out, i.e. still bonded to the adhesive after peeling, the load-bearing capacity of the surface is not sufficient and the material cannot be used for bonding either.
- Document the failure pattern with photos.

Quality assurance

Measures

Visual inspection

A visual inspection is necessary for every installation step and during installation of every panel. fischer recommends occasional photo documentation in relation to the questions below.

Procedure / control question:

- Are the surfaces (subframe and panel) dry, dust- and grease-free?
- Has the surface (subframe and panel) been sanded if necessary (e.g. with uncoated aluminium)?
- Has primer been applied to the subframe and panel (recognisable through a faintly visible film on the surface)?
- Is the Panel Bond Tape sticking to the surface of the subframe?
- Has the triangular bead of the Panel Bond adhesive been applied correctly and continuously?
- Is the clearance between Panel Bond Tape and tape, adhesive and outer edge of the subframe correct (each min. 5 mm)?
- Has the protective film been removed from the Panel Bond Tape?

Optional measures

Structure and testing of a system in real system

For large-scale projects in particular, fischer recommends building a complete system (comprising subframe structure, Panel Bond adhesive system and façade panels) as ventilated rainscreen façade in real size, and carrying out destructive testing. When testing the panel for pressure, tensile strength or shearing over the subframe, the failure mode must only be cohesion failure in the adhesive joint (min. 90% cohesive failure, max. 10% adhesive failure) or failure of the panel or substructure.

Keep a daily installation log!

The Panel Bond installation log → **Page 17-18** and at → **www.fischer.de** must always be completed fully and stored. If the installation log is not completed fully, warranty will be voided. The installation log must be completed every day and every time there are major weather changes.

Summary

No.	Quality assurance measure	Frequency of the test	Requirement
1	User training and certification	One-off participation and renewal every 5 years. Repeating the training is recommended if the worker has not done any bonding for the past 12 months.	Every person responsible on the construction site must have taken part in user training on the Panel Bond System and have received a certificate. The training is carried out directly on site or at a training facility by fischer or an authorised fischer partner.
2	Peel test	Before every project	Cohesive failure of the adhesive bead (min. 90%) (= max. 10% adhesive failure). Photo documentation.
3	Skin formation time	Daily and in the event of more major fluctuations in weather conditions	Skin formation time and installation time are documented on the installation log. The installation time must be within the skin formation time
4	Update installation log	Daily and in the event of more major fluctuations in weather conditions	Log filled out completely
5	Visual inspection	Every work step and every panel	All requirements are fulfilled (all control questions answered yes)



To the download

Installation log – Part 1 of 2

Part 1: To be completed once per project resp. every time there are changes to the contents queried

1. General information

Customer	Street, house number	
Project name	Postcode	City
Surname, first name of the processor	Participation in training: ☐ Yes ☐ No	Date of the training

2. Subframe (profiles)

Material	Surface:	
	☐ Dust-free	☐ Dry
Brand name	☐ Grease-free	☐ Smooth
Type		

3. Panels

Material	Dimensions:	Surface:
	Max. length mm	☐ Dust-free ☐ Dry
Brand name	Max. width mm	☐ Grease-free ☐ Smooth
Type	Thickness mm	

4. Pre-treatment: subframe

Has it been sanded? ☐ Yes ☐ No

Primer used: ☐ Primer PU
☐ Cleanprimer SI
☐ Cleanprimer PU

Flash-off time: _____ Min.

5. Pre-treatment: panel

Has it been sanded? ☐ Yes ☐ No

Primer used: ☐ Primer PU
☐ Cleanprimer SI
☐ Cleanprimer PU

Flash-off time: _____ Min.

6. Panels installation tape and panels adhesive

Panel installation tape used? ☐ Yes ☐ No

Adhesive used: ☐ Panel Bond SI
☐ Panel Bond PU

7. Bead peel test

Date of application	Date of the test
Subframe: > 90% cohesive failure	☐ Yes ☐ No
Panel: > 90% cohesive failure	☐ Yes ☐ No



Part 2: To be completed daily or following more major fluctuations in weather conditions

[illegible]¹⁾Time between adhesive application and pressing the panel on

System illustration, product range and accessories



Product range

fischer Panel Bond System

					
Panel Bond SI	Panel Bond PU	Cleanprimer SI	Cleanprimer PU	Primer PU	Panel Bond Tape
Type	Art. no.	Language on the product	Contents	Sales unit [units]	
Panel Bond SI	576451	DE / ES / IT / AR / DK / NO / EN / TR / PT	600 ml 4 V-nozzles per sales unit	12	
Cleanprimer SI	576452	DE / ES / IT / AR / DK / NO / EN	1 l	5	
Panel Bond PU	576454	DE / ES / IT / AR / DK / NO / EN	600 ml 4 V-nozzles per sales unit	12	
Cleanprimer PU	576455	DE / ES / IT / AR / DK / NO / EN / TR / PT	1 l	10	
Primer PU	576456	DE / ES / IT / AR / DK / NO / EN	1 l	10	
Panel Bond Tape	576457	Multilingual	5x25m	1	

Accessories

fischer Panel Bond System



KPM 600 dispenser

PUR 500 universal cleaner

Type	Art. no.	Language on the product	Contents	Sales unit [units]
KPM 600 foil bag dispenser	540941	Multilingual	–	1
PUR 500 universal cleaner	53085	DE / EN	500 ml	12

Dealer:

www.fischer.de



What fischer stands for

Fixing systems
fischertechnik
Consulting
Electronic Solutions

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