

## Method Statement for BCI One-Component High Tack Adhesive BC S690

### Scope of Work

This method statement provides the procedure for the application of BCI one-component high tack adhesive BC S690 for bonding various construction materials such as wood, metal, concrete, and plastics.

### Materials and Tools Required

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| One-component high tack adhesive BC S690                 |
| Caulking gun or adhesive applicator                      |
| Spatula or spreader                                      |
| Cleaning cloths  |
| Acetone or other approved cleaner (for surface cleaning) |
| Protective gloves and safety goggles                     |
| Tape (for masking, if required)                          |

### Safety Precautions

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| Ensure adequate ventilation when applying adhesive indoors.                  |
| Wear gloves and protective goggles to avoid skin or eye contact.             |
| Follow the manufacturer's safety data sheet (SDS) for handling the adhesive. |
| In case of skin contact, wash immediately with soap and water.               |
| In case of eye contact, rinse thoroughly with water and seek medical advice. |

### . Surface Preparation

Clean the surfaces to be bonded. Ensure that they are free of dust, grease, oil, and loose particles. Use a clean cloth soaked in acetone or another approved cleaner to remove any contaminants.

Dry the surfaces completely before applying adhesive. Moisture or dampness can affect the bonding strength.

Roughen smooth surfaces slightly with sandpaper to improve adhesion, especially if the surface is non-porous like metal or plastic.

### Masking (If Required)

If precision is needed, apply masking tape around the area to be bonded to avoid adhesive spillover.

### Adhesive Application Procedure

Cut the nozzle of the adhesive cartridge at an appropriate angle to suit the application width.

Load the cartridge into the caulking gun or adhesive applicator.

Apply the adhesive evenly on one of the prepared surfaces. It can be applied in lines, dots, or a continuous bead, depending on the bonding area and weight of the material.

For larger surfaces, use a spatula or spreader to distribute the adhesive uniformly to ensure full coverage and avoid air pockets.

Press the surfaces together firmly within the open time specified by the adhesive manufacturer. Make sure the surfaces are aligned correctly.

Maintain pressure for a minimum of 10-15 minutes, either manually or with clamps, depending on the size of the bonded area. Some applications may require clamping for several hours or longer based on the manufacturer's recommendations.

### Curing

Allow the adhesive to cure for the recommended time stated on the adhesive packaging.

Initial tack will be achieved quickly, but full cure typically takes 24-48 hours, depending on environmental conditions such as temperature and humidity.

### Cleanup

Remove excess adhesive before it cures using a clean cloth and solvent such as acetone.

Once cured, the adhesive can be removed mechanically.



## Inspection and Testing

After curing, inspect the bond for uniform adhesion and coverage.

Perform a pull test if necessary to ensure the bond strength is adequate.

## Completion

Once the adhesive has cured, and the bond has been tested for strength, remove any remaining masking tape and clean the area.

Notes:

Always follow the our specific instructions for surface preparation, open time, and curing conditions.

Environmental factors such as humidity and temperature can affect the bonding process and cure time.