

Title: **Recommendations for the correct seal application**

**1. SCOPE**

This Instruction describes the steps of a proper installation of intumescent seals on door- frames or door-leaves.

**2. INSTALLATION.**

This Instruction applies whenever the thermo-expanding seals (Tecnoflame or co-extruded seals) with adhesive tape must be installed on frames of any material.

FRAME	Surfaces of the frame where seals must be applied must be perfectly clean and dry. Surfaces should be kept free from dust, grease and without any coat of oil and chemicals during installation. Formation of condensation and humidity has to be avoided (these formations can happen when moving cold object in a warmer environment).
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**Uncorrect**

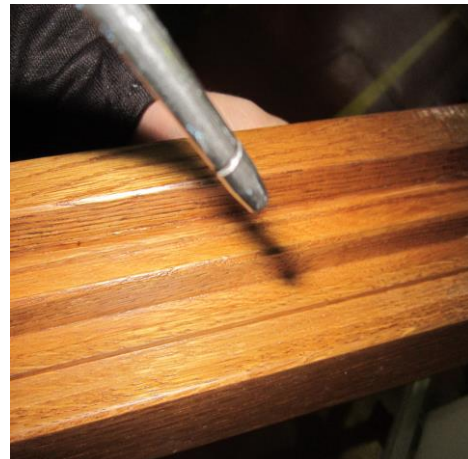
**Uncorrect**



CLEANING OF SURFACES	For cleaning of surface, use only clean cloths and solvents compatible with the materials of the frames such as gasoline, alcohols, esters or ketones. In the case of dust, compressed air must be used to dust off with the sediment caused by machining (i.e. milling) in any groove and angles.
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**CORRECT**

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INSTALLATION OF THE SEALS.

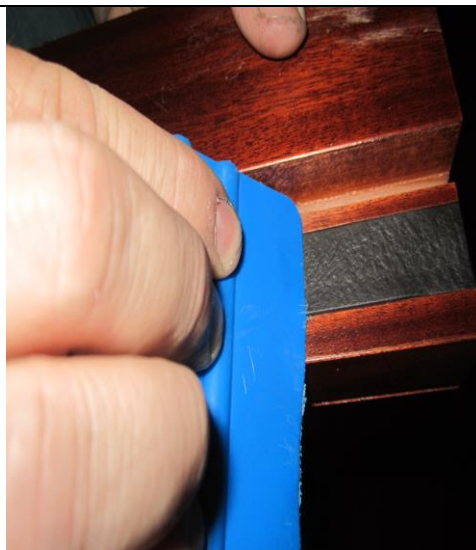
1. Remove the liner using gloves or clean fingers to protect adhesive to be damaged. Make sure not to touch the adhesive to avoid altering the adhesive chemical proprieties and its performance.

2. Start to stretch the seals on the surface taking attention not to contaminate adhesive surface with the dust or dirt and not to touch adhesive surface with fingers even if protected by gloves.



INSTALLATION PRESSURE.

To ensure best adhesion, it is necessary to apply a pressure of about 10-15 N/cm<sup>2</sup> uniformly on the entire surface, by means of a roller or a pressing tool where possible.



TIPS

**Avoid unnecessary loads**

Adhesive cohesion must be done in order to not allow any leverage effect (stress of cleavage). Any shear stress or traction has to be distributed on the whole adhesive surface. Constant stripping stress compromise the permanent elastic adhesive union (e.g. plates to be used on curved surfaces must be properly preformed ). Avoid stress on the ends of the materials to be adhered.

**Installation temperature**

The ideal apply temperature for the seal with adhesive lies between +18°C and +25°C. If the seal is applied at low temperatures, the initial seal's adhesive force is reduced.



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**Storage**

Our seal must be stored packed at room temperature and conditions of normal humidity (from 50 to 70%).

If stored in extremely cold or excessively hot conditions, before of installation seals must be kept at room temperature for some hours to allow normalizing and to avoid temperature gap between seals and frames.

In addition, if unpacked (for example in assembly department during installation operations) seals must be protected from dust or any other substances that could penetrate between the liner and the adhesive making it void its performance.