

# Shell Tixophalte: Usage Advice

## Preparation

It is recommended to have surfaces clean, dry, free of dust, grease and unbound particles. Prior to application adhesion tests are recommended.

## Primer

In most cases no primer is required. If a primer or a pre-treatment is recommended, the best results will be obtained with a bituminous primer. A bituminous primer is particularly recommended for porous substrates. In case of any doubt please ask for advice from your supplier or from Shell.

## Application

Shell Tixophalte can be applied by hand or a compressed air-gun. Using the cartridge, the aluminium seal in the front screw hole has to be completely opened. The screw spout has to be cut slantwise so that it has the size of the desired band of Shell Tixophalte. A clean spout is important for a uniform dose and a smooth finish. In order to obtain adequate adhesion on a wet substrate, it is important that the distance between substrate and spout is as small as possible and not more than 3mm, so that the initial adhesion is obtained by displacing the water.

When compressed-air guns are used, the piston and the cylinder have to be greased properly. Shell Tixophalte must be applied in strips or spots, so that the solvent is able to evaporate easily. Ensure that there is adequate ventilation during use.

## Curing

The curing rate is influenced by factors such as temperature, type of substrate, absorbency behaviour of the materials and the applied layer-thickness of Shell Tixophalte. Immediately after applying Shell Tixophalte, the adhesion is sufficient to resist a low load.

Maximum strength is obtained after curing by evaporation of the solvent. The final adhesive strength is strongly dependent on the type and nature of the bond.

## Usage

When bonding insulation material or roofing felt with for instance 5 strips each 4cm wide, the consumption is a minimum of 400 g/m<sup>2</sup> (depending on the substrate). This can be increased at the corners and edges of the roof.

## Cleaning advice

Shell Tixophalte can be mechanically removed (e.g. with a palette knife). Finally the residue of Shell Tixophalte can be cleaned by dissolving in an hydrocarbon solvent (white-spirit).

## Compatibility

Shell Tixophalte can be used for bonding plastics without plasticisers. With light coloured plastics use of Shell Tixophalte may cause staining. Contact with mineral oil, (gasoline, kerosine, gas oil) softens the product.

Compatibility with extruded polystyrene can vary. In this case, Shell Tixophalte is best applied on the substrate. After a while the boards can be adhered. Avoid making the Shell Tixophalte layers too thick. Shell Tixophalte does not tolerate solvent based paint.

