HOW DO YOU BOND NOVIPLAST ROOF SPOILERS?

Since 1994, all Noviplast roof spoilers have been bonded using polyurethane sealant. There are currently more than 100,000 bonded Noviplast roof spoilers in circulation in Europe. For optimum adhesion and durability of the roof spoiler, all the steps in these fitting instructions must be carried out carefully.

What you will need:

- Sikaflex 252 Polyurethane sealant
- Sika Cleaner 205 Primer
- Lashing straps (optional)
- Cleaning material

1 PREPARATION

1. **Check the temperature**
   - Make sure that the ambient temperature is at least 12 °C. If the temperature is below 8 °C, the sealant will not cure properly.
2. **Clean the surface**
   - Make sure that the surface is clean, dry and free of dust, grease and dirt. A surface that has been cleaned properly will ensure optimal adhesion.

2 USING PRIMER

Apply Sika Cleaner 205 Primer

- Apply the primer evenly to the surface to be bonded.
- Use approximately 20-50 g/m².
- Let the primer dry for 2 to 5 minutes before continuing.
- The application temperature of the primer should be between + 5 °C and + 35 °C.

3 APPLYING SIKAFLEX 252 POLYURETHANE SEALANT

Apply polyurethane sealant

- Apply a sufficiently thick layer of Sikaflex 252 sealant to the surface of the roof spoiler. Make sure that the layer is not too thin in order to ensure good adhesion.

4 ATTACHING THE ROOF SPOILER

Positioning and attaching

- Position the roof spoiler in the right place and make sure that it fits properly.
- If you secure the roof spoiler using lashing straps, do not apply too much pressure. If too much pressure is applied, the sealant may be pushed out, weakening the bond.

5 CURING

- Allow the polyurethane sealant to cure for at least 12 hours before delivering the vehicle.

Technical properties of the materials:

Sikaflex 252 Polyurethane sealant:	
Thickness:	116
Shore hardness:	55
Polymerisation rate at 20°:	4 mm/day
Application temperature:	-40°C to +90°C
Mechanical strength on polyester:	± 30 kg/cm²
Flexibility:	300%

Sika Cleaner 205 Primer:	
Thickness:	0,79
Consumption:	20-50 g/m²
Drying time:	2-5 minutes
Application temperature:	+ 5° to 35°

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