

APPLICATION GUIDE

Door Panel Mounting

Important note: When the surface structure is not completely flat, special coatings are applied, or different materials are bonded, special attention is needed for this application. Please contact a tesa sales engineer for support.

Dead load support: We recommend a static dead load support for the door panel.

Workplace layout: The door sash needs to lie flat without any warpage.



1. Cleaning

- Clean the bonding area of the door sash and panel by using tesa® 60040 Industry Cleaner or isopropanol on a lint-free wipe.
- Frequently replace the cleaning wipes.

2. Scuffing/cleaning

- Scuff the bonding area* on both the door sash and panel with an abrasive pad (e.g. Mirlon abrasive pad VF 360).
- Scuff carefully, remove the top layer only.
- Remove the scuffing dust. Clean again (Step 1).

* No scuffing of PVC or laminate surfaces.

3. Priming

- Prime the bonding area of the door sash and panel with tesa® 60153 Adhesion Promoter Fast Cure by using either a lint-free wipe or a tesa® 50690 Primer Pen.
- Use protective gloves.
- Evaporation time of the primer solvents is 30 s to 5 min.
- Evidence of the primer can be traced with UV light.

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4. Application of tape

- For wrinkle- and bubble-free application of the tape to the sash, apply the tape to the profile by using our tesa® 6003 Special Taper or tesa® Edge Taper.
- Apply slight pressure during application.
- Apply the tape to all sides of the sash with an overlap in the corners.
- Precisely cut the tape in the corners to achieve an optimum water seal.



5. Positioning the door panel

- Cut out the hole for the cylinder lock.
- Lift off and fold over the ends of the liner in the corners of the sash (~ 5 cm).
- Position a glazing block (3 mm thickness) in each corner of the sash.
- For an exact positioning of the door panel, position the glazing blocks right next to the folded liner.
- Lift the door panel onto the sash and precisely align the panel with the sash.



6. Removing the liner

- Carefully remove the glazing block and the film liner.
- Remove the liner using continuous low speed and low force.
- Only use tape with a film liner.
- Remove one piece of liner after the other, going in one direction.



7. Applying pressure

- Apply a minimum pressure of 10 N/cm² for a few seconds onto the sash.
- Consult your tesa sales specialist for support regarding pressure tools.



8. Storage/transportation

- After pressure has been applied the door can immediately be shipped or stored.

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