

	Varia	Koda XT	Chroma	Unsealed Wood	Sealed Wood	Metal ³
Varia	Weld-On 55/58 (Corner Condition)	N/A Contact Tech Support	Plexus MA310 Contact Tech Support	SilGlaze II ²	Primer 94 with VHB 4496 ¹ + SilGlaze II ²	Primer 94 with VHB 4496 ¹ + SilGlaze II ²
Koda XT	N/A Contact Tech Support	N/A Contact Tech Support	N/A Contact Tech Support	Requires Hardware	Requires Hardware	Requires Hardware
Chroma	Plexus MA310 Contact Tech Support	N/A Contact Tech Support	3form Light Seam (corner condition) or Structural Seam Integra Surface Bonder	SilGlaze II ²	Primer 94 with VHB 4496 ¹ + SilGlaze II ²	Primer 94 with VHB 4496 ¹ + SilGlaze II ²
Glass	N/A Contact Tech Support	N/A Contact Tech Support	N/A Contact Tech Support	SilGlaze II ²	Primer 94 with VHB 4496 ¹ + SilGlaze II ²	Primer 94 with VHB 4496 ¹ + SilGlaze II ²

Please see product fabrication manuals for application techniques and surface preparation.

¹Primer 94 required when adhering using 3M VHB 4996 white foam tape to substrate.

²Silglaze II is to be used for structural bonding per substrates listed above. See specification list on page 3.

³Metal represents carbon steel, stainless steel and aluminum. Contact 3form Technical Service if bonding to other types of metal.

Although many adhesives listed are translucent or colorless, the bond will NOT be invisible.

Do NOT use cyanoacrylate thread locking materials (Loctite™) or solvent type adhesives with 3form panels.

- Use Weld-On® 55 or 58 for seaming and edge-sealing of Varia Ecoresin.
- Use Integra Surface Bonder for seaming Chroma.
- Use Plexus MA310 for applying plastic panels to non-plastic substrates.
- Use SilGlaze II for most structural glazing and sealing applications.



adhesives selection matrix vertical applications

Important: This chart is for panels 1/4" thick and less. If you have a thicker panel call 3form Technical Support. You can use VHB Tape or an aluminum angle/wood blocking under the panel for support during curing. It is important that the panel be supported until the adhesive reaches full cure. See 3form load bearing aluminum angle detail (page 4).

	Varia	Koda XT	Chroma	Profile	Glass	Unsealed Wood	Sealed Wood	Metal ³	Primed/Painted Drywall ⁴
Varia	Weld-On 55/58 (Mitered Corner Condition)	N/A Contact Tech Support	N/A Contact Tech Support	N/A Contact Tech Support	N/A Contact Tech Support	Requires Hardware	see page 4	see page 4	see page 4
Koda XT	N/A Contact Tech Support	N/A Contact Tech Support	N/A Contact Tech Support	N/A Contact Tech Support	N/A Contact Tech Support	Requires Hardware	Requires Hardware	Requires Hardware	N/A Contact Tech Support
Chroma	N/A Contact Tech Support	N/A Contact Tech Support	Integra Surface Bonder (Light Seam or Structural Seam)	N/A Contact Tech Support	N/A Contact Tech Support	Requires Hardware	see page 4	see page 4	see page 4
Profile	N/A Contact Tech Support	N/A Contact Tech Support	N/A Contact Tech Support	See 3form Solutions Document	N/A Contact Tech Support	Requires Hardware	Primer 94 with VHB 4496 ¹ + Liquid Nails 903	Primer 94 with VHB 4496 ¹ + SilGlaze II ²	Primer 94 with VHB 4496 ¹ + Liquid Nails 903
Glass	N/A Contact Tech Support	N/A Contact Tech Support	N/A Contact Tech Support	N/A Contact Tech Support	Primer 94 with VHB 4496 ¹ + SilGlaze II ²	Requires Hardware	see page 4	see page 4	see page 4
Hush Clad	N/A Contact Tech Support	N/A Contact Tech Support	N/A Contact Tech Support	N/A Contact Tech Support	N/A Contact Tech Support	Liquid Nails 903	Liquid Nails 903	N/A Contact Tech Support	Liquid Nails 903

Please see product fabrication manuals for application techniques and surface preparation.

¹Primer 94 required when adhering using 3M VHB 4496 white foam tape to substrate.

²Silglaze II is to be used for structural bonding per substrates listed above. See specification list on page 3.

³Metal represents carbon steel, stainless steel and aluminum. Contact 3form Technical Service if bonding to other types of metal.

⁴Drywall must be primed or painted prior to adhering 3form materials.

Although many adhesives listed are translucent or colorless, the bond will NOT be invisible.

Do NOT use cyanoacrylate thread locking materials (Loctite™) or solvent type adhesives with 3form panels.

- Use Weld-On® 55 or 58 for seaming and edge-sealing of Varia Ecoresin.
- Use Integra Surface Bonder Clear for seaming Chroma joinery.
- Use Devcon Plexus MA310 for applying plastic panels to non-plastic substrates.
- Use SilGlaze for most structural glazing and sealing applications.

	Varia	Koda XT	Chroma	Glass
Sealing in a frame	Momentive SilGlaze II SCS 2801	Momentive SilGlaze II SCS 2801	Momentive SilGlaze II SCS 2801	Momentive SilGlaze II SCS 2801
Structural Glazing	Momentive SCS 1201	Momentive SCS 1201	Momentive SCS 1201	Momentive SCS 1201

Sealing/Weathersealing - These silicones are designed to be used as a general-purpose weather and glazing sealant. This will provide a water-tight seal, but is not designed to provide structural support. For edge sealing specifically see the 3form Edge Sealing Guidelines White Paper.

Structural Glazing - These silicones are NOT structural adhesives, but can be used for structural glazing applications. Structural glazing is an application where a sealant not only functions as a barrier against the passage of water and air, but also primarily provides structural support and the attachment of glazing components in a window, curtain wall or framing system.

Adhesive	3form Part#	Gun Part#	Tip Part#	Size (ml)	Color	Working Time	Full Cure	Type
Weld-On 55	3-05-0055	3-05-0056	3-05-0057	50	colorless	10-12 min.	+72 hours	Urethane
Weld-On 58	3-05-0058	3-05-0056	3-05-0057	50	colorless	2-3 min.	72 hours	Urethane
Integra Surface Bonder	TBD	TBD	TBD	250	colorless	5-12 min.	24 hours	Acrylic
Plexus MA310	3-20-308	3-05-0056	3-05-0057	250 or 400	straw	15-20 min.	24 hours	Acrylic
3M VHB 4910*	3-20-301	Use J-roller to apply		1" x 36 yd	colorless	n/a	72 hours	Acrylic
3M VHB 4496* White	3-20-313	Use J-roller to apply		1" x 36 yd	white	n/a	72 hours	Acrylic
3M Primer 94 (1/2-pint)	3-05-0072	Use clean rag or foam brush		236.6	colorless	5 min	n/a	n/a
Momentive SCS1201	3-05-0070	Use standard caulk gun		295	translucent	30 min	3-4 days	acid cure
Momentive SCS2801	3-05-0069	Use standard caulk gun		295	translucent	6-12 min	2-4 days	neutral cure

*Use 3M Primer 94 when adhering 3M VHB Tape to 3form Varia or Chroma. Coverage of Primer 94 is 25in²/capsule or 38 ft²/halfpint (14.7 m²/l)

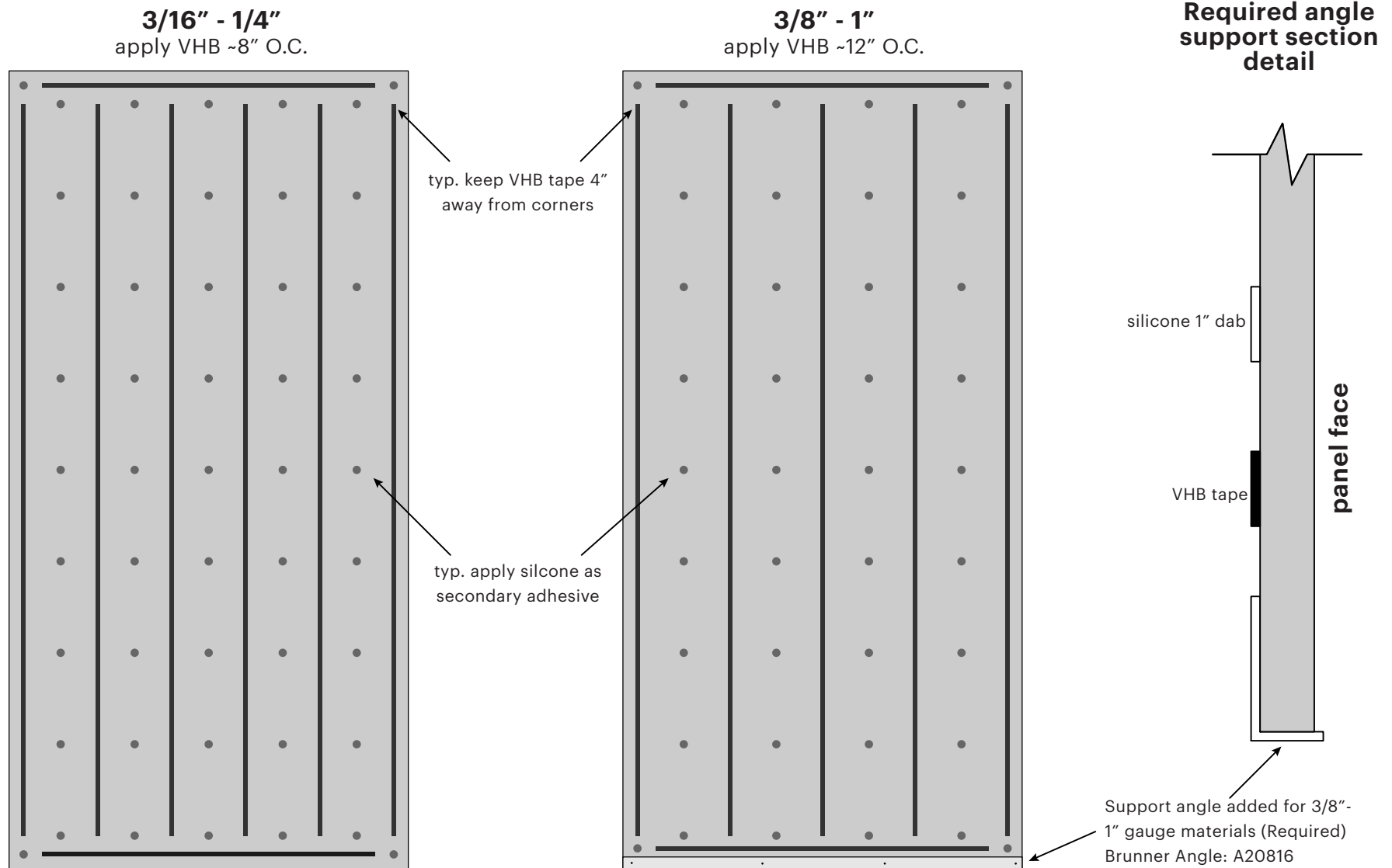
All technical specification sheets and MSDS forms are available upon request. email: technical@3-form.com

Approximate adhesive coverage in square feet with 0.008" bond line (does not include nozzle waste)

Square ft per 35ml	Square ft per 50ml	Square ft per 230ml
2	2.5	11.5

Masking Tape Recommendations

Use 3M 8952 tape for masking. We specify this tape because it provides a tight seal against the adhesive.



**adhesives will be visible through translucent materials
ensure an opaque film is specified**

Adhering material less than 3/16" thick not recommended. Please contact tech support