

## Conditions

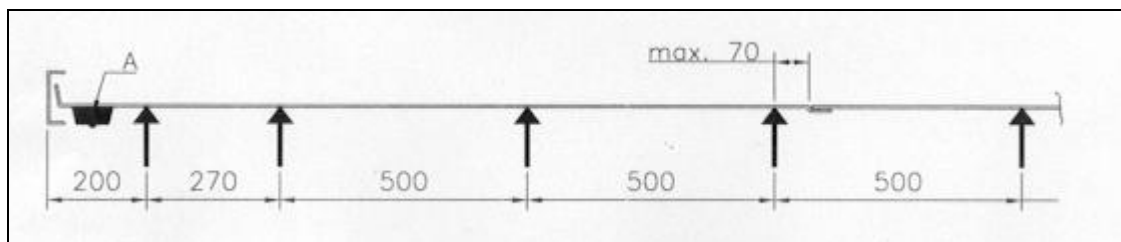
Glue-work may only be done when:

1. Temperature is between 5-25° C.
2. The weather is dry and the trays are dry.

## Sub support of the bench trays.

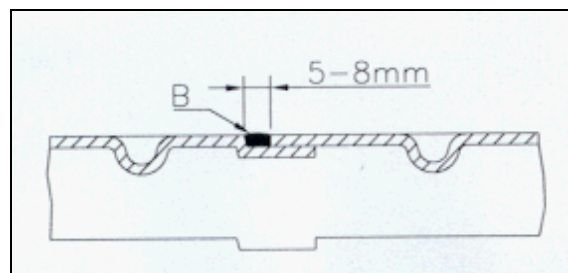
By a max. load of 70 kg/m<sup>2</sup> evenly distributed, the following demands to sub support must be met:

1. The bench trays must generally be supported with max. 500 mm. space.
2. A support is placed max. 70 mm. from the glue rim. **IMPORTANT:** This **MUST** be under the tray part **WITH** glue lip, see as an example the drawing below.
3. A support is placed max. 200 mm. from the edge of the bent tray. Notice the sump (A), which can **NOT** rest on the sub support.

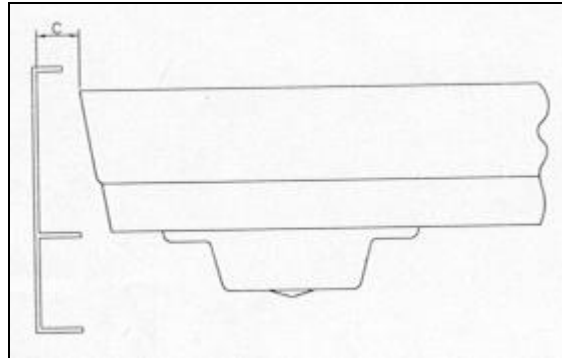


## Instalment

1. The bench trays are placed in the bench frames and distributed so a glue joint appears (B) of between 5- 8 mm.



2. Because of temperature changes the bench trays will "work" lengthwise. It is therefore necessary with a gab (C) between the tray edge and the end of the bench frame. The amount of gab depends on the length of the bench, and at 20° C be a min. of 1 mm. gap per meter bench length (distributed in both ends). This can be made into the following formula:  $Gab = Length\ of\ bench \times 0,001$ .



## Glue

1. When the bench trays are correctly placed in the bench frames, the glue is pressed into the groove (NOT between the overlapping of the trays), and any extra glue is scraped off with a steel putty knife.
2. Always use as little glue as possible. Excessive use will damage the trays which are NOT covered by warranty. As principal rule the use of glue must not exceed 1 litre of glue per 20 meter glue joint (1 tube per 6 meter glue joint).
3. The glue must dry for at least 24 hours at 20° Celsius. If the temperature is below 20° Celsius, the dry time must be expected to increase.

Use breath protection and gloves during the time of working with the glue, as the glue contains an organic solvent.