

Soltec Panel-Fix[®] elastic anchoring system for ventilated facades and panelling

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Soltec®- Soluciones técnicas en adhesivos y selladores



Table of contents

Preface.....	2
Description of the system and installation	3-10
Soltec Panel-Fix® elastic anchoring system	3
Description and composition of the system	4
Applications	4
Products Description	4
Technical data	4-6
Soltec Panel-Fix System Information®	6
Specification and characteristics of the substructure	6
Assembly details and specifications	7
System application	8
Consumptions	10
Hygiene and safety	11
Installation part	12 -14



Elastic anchoring system for ventilated facade and interior panels

Elastic hidden anchoring

Anchoring system Soltec Panel-Fix®

Due to the great development of the systems of anchoring for ventilated facades and the wide variety of materials used for its construction, Soltec® has created an elastic and hidden anchoring system developed exclusively for the assembly of panels in these cases.

The system is composed of a primer according to the type of panel (HPL, ceramic, fiber cement, ACM ...) and the support (substructure of wood, HPL, aluminum, etc.), a double-sided tape of 3 mm thickness and an elastic adhesive of high performance and resistance to aging. The primers act as adhesion promoters on the supports and facilitate a good traction of the adhesive on them. The double-sided Soltec Panel-Fix® C tape has a double function: it is responsible for the immediate fixing of the panel on the substructure while the adhesive polymerizes and at the same time works as a template, guaranteeing a minimum and continuous thickness of adhesive to ensure a result to the optimal traction.

The advantages of the system are several:

- Absorption of the expansion and contraction movements of the substructure and paneling.
- Uniform tensile distribution over the panel without causing peaks at specific points (mechanical anchoring).
- Greater structural stability in ceramic pieces since they do not have to be machined or perforated as in the mechanical anchoring system.
- Saving of time both in the assembly and in the elaboration of the ceramic pieces since they do not need a previous machining.
- Considerable cost reduction.
- The water inlets in the joints that caused for the mechanized perforations of the pieces with the traditional system, the freezing of the winter water in the interior of the perforations and possible breakages of the pieces due to this cause are avoided.
- At the same time, the adhesive acts as an acoustic insulator avoiding the warping of the pieces.
- The adhesive prevents electrical conduction and thus the oxidation of the mechanical elements of the substructure by ionic transfer.
- Adhesive free of solvents and isocyanates guaranteeing 0% of migrations and possible stains especially in ceramics.
- In this way we achieve a hidden and aesthetically adequate anchoring system that does not impact on the vision of the facade.



Data sheet No. T5024

SOLTEC Panel-Fix® system

Elastic anchoring system for facade and interior panels

Description and composition of the system

Gluing system for ventilated facades with indoor and outdoor HPL, ceramic, aluminum and concrete panels.

It is comprised of:

- Soltec Panel-Fix® elastic adhesive
- Soltec Panel-Fix® P202 promoter
- Soltec Panel-Fix® 451SW primer for gluing surface preparation
- Soltec Panel-Fix® C double sided tape



Applications

The SOLTEC Panel-Fix® system has been specially developed for fixing panels on ventilated façades using a gluing system that remains hidden. In this way we can apply it in:

- Construction of ventilated facades for buildings
- Interior renovations without remove the original coverings
- Inside and outside panelling

The main advantages are:

- Fast and economic fixing system
- Mono-component, ready for use
- Adhesive free of silicones, solvents and isocyanates
- Excellent resistance to aging outdoors
- Uniform distribution of tension on the panels
- Aesthetic finished
- Easy and clean application
- Absorption of vibrations and movements
- Avoid the formation of oxides



Description of products

Technical data:

- Soltec Panel-Fix® elastic adhesive:

Mono-component adhesive for Soltec Panel-Fix® system

Appearance	Pasty
Colour	Black (600 ml); White (600 and 290 ml)
Density at 20°C	White: 1,34 ± 0,02; Black: 1,27 ± 0,02
Sagging (ISO 7390)	< 2 mm
Application temperature	+ 5°C at + 35°C
Skin formation time at 23° C and 50 % HR	20 ± 10 min*
Cure time at 23° C and 50 % HR	> 3 mm / 24 horas
Shore A hardness (ISO 868 – 3 seconds)	Ca. 55
Modulus at 100 % (ISO 37)	≥1 MPa
Elongation at break (ISO 37)	> 350 %
Modulus at break (ISO 37)	Approx. 2,3 Mpa
Loss of volume (ISO 10563)	< 2 %
Time until panel fixing	Immediate (when finishing applying the bead of adhesive)

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- Soltec Panel-Fix® elastic adhesive (continuation):

Temperature resistance	- 40°C to + 100°C
UV resistance	Very good
Tear resistance	≥10 N/mm
Storage conditions	12 months in original packaging and hermetically sealed between + 5°C and + 25°C to the protection of frost
Packaging	25 cartridges 290 ml per box 20 sausages 600 ml per box

* This time depends on the humidity and ambient temperature. To ensure correct adhesion, it is mandatory to glue before the product has formed a skin.

- Soltec Panel-Fix® P202 promoter:

Adhesion promoter for panels and profiles.

Description	Organic solvent of polysilanes
Application	Promoter for profiles and panels
Colour	Transparent
Viscosity	Very low (ca. 1 mPa.s)
Density at 20°C	Ca 0.80 kg/l
Conventional content in solids (EN 827)	3%
Application temperature	5 to 35°C
Specific data (dry time)	10 min (security time)
Storage conditions	12 months in original packaging, hermetically closed between +5°C and +25°C away from sun and frost. Product validity: 1 month after opening (stored under the temperature conditions described above).
Packaging	250 ml and 1 L bottles
Caution	Extremely flammable Consult safety sheet before use. Do not smoke and keep out of reach of any source of ignition.

- Soltec Panel-Fix® 451SW primer:

Primer for strips and panels.

Description	Solvent with isocyanates
Application	Primer for structure and panels
Colour	Negra
Viscosity at 20°C	Viscosity to 20°C (DIN cup Ø 4mm, 100 ml): 11 to 14 s Dry time: 15 min. (≥ 20°C) > 15 min. (< 20°C)
Density at 20°C	0,935 ± 0.05 kg/l
Conventional content in solids (EN 827)	35 – 38%
Application temperature	+5°C to +35°C
Storage conditions	12 months in original packaging, hermetically sealed between +5°C and + 25°C protected from the sun and frost. Validity of the product: during the first 24 hours after opening.
Packaging	250 ml and 1L bottles
Caution	Extremely flammable Consult safety sheet before use. Do not smoke and keep out of reach of any source of ignition.

- Soltec Panel-Fix® C tape:

Self-adhesive double-sided tape.

Description	Self-adhesive double-sided tape for initial fixing of the panels until the adhesive has cured. The thickness of the tape guarantees the minimum thickness of adhesive to obtain adequate mechanical properties.
Application	Initial fixing between support (ribbon) and panel
Colour	Anthracite gray
Chemical composition	Closed cell polyethylene foam



- Soltec Panel-Fix® C tape (continuation):

Width	12 mm
Density	50 Kg/m ³
Thickness (without film)	3 mm ± 10%
10% Compression resistance (ISO-3386-1)	36 kPa
Temperature resistance	-30°C to +100°C
Adhesive	Acrylic
Adhesive strength AFERA 5001 (N/25 mm)	16 ± 1.5
Film	Silicone paper (White)
Storage conditions	12 months in an original packaging, well preserved and protected from frost and the direct action of sun, between + 5°C and + 25°C and a relative humidity of 50%. Low temperatures increase the risk of condensation by reducing the tack of the self-adhesive product.
Packaging	34 rolls per box / 20 m per roll
Caution	The total and long-term resistance of the system to the panels is achieved exclusively with the Soltec Panel-Fix® adhesive. The foamed tape Soltec Panel-Fix® C only provides the system with an initial and short-term fixation. Do not carry out long-term resistance calculations taking into account the mechanical fixation of the tape. The Soltec Panel-Fix® C tape must be applied over the entire length of the substructure.

Fire classification of the system with HPL Panel Bs1, d0 according to European standard 13501:1-2018	Bs1, d0
Fire classification of the system with ceramic panel A2s1, d0 according to European standard 13501:1-2018	A2s, d0

Information about the Soltec Panel-Fix® system**Specification and characteristics of the substructure:****- Aluminum substructure:**

Due to the different types of aluminum qualities and treatments that are available on the market, preliminary laboratory tests must be carried out but in all cases 6060 or higher alloys must be used in order to guarantee a proper adherence of the Soltec Panel-Fix® 451SW primer on this type of substructure.

- Wooden substructure:

The strips must be made of pine or fir, they must be flat and smooth, free of roughness and particles that could easily fall off the strip and deteriorate the mechanics of the system.

The maximum humidity content for the wooden strips must be 14% (dry). The areas where primer is going to be applied must not have been previously treated, grouted, painted or have any other type of residual primer applied. To ensure that there is no stress overload in the substructure due to expansion and contraction, a minimum distance between panels of 10 mm wide (horizontal and vertical) must be maintained. When applying any of the other components of the system, the temperature of the components to be bonded must be at least of 3°C above the dew point to prevent condensation from appearing on the surface and the relative humidity of the air must not exceed 80%.

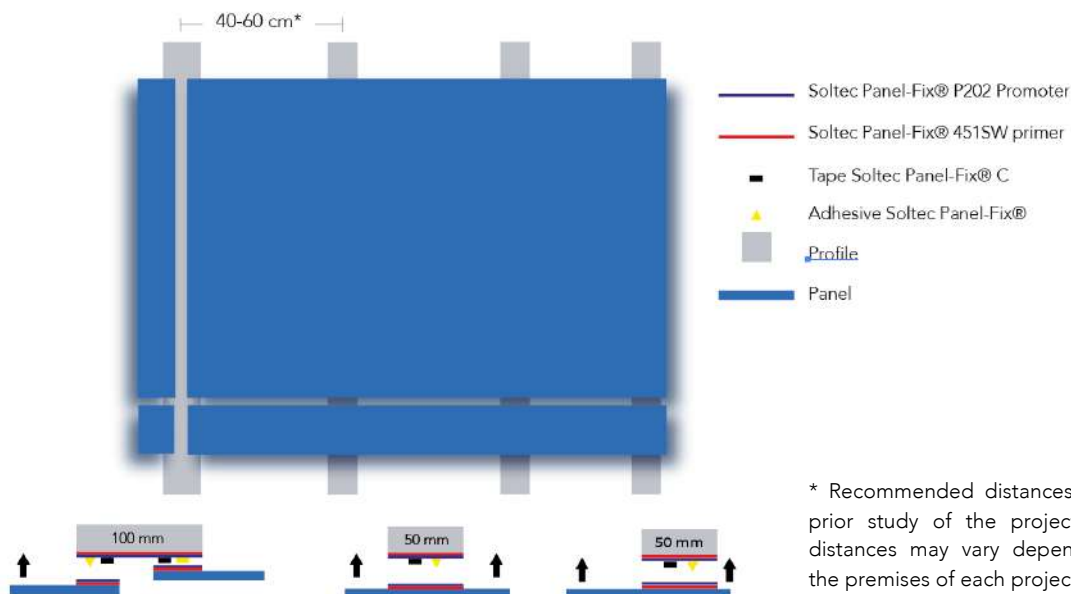
In case of rain, do not apply any of the components of the system.

The distance between strips should be 40 cm extendable up to 60 cm in specific cases depending the nature of panel (consult the manufacturer). To define this distance between panels, a prior study of the project is recommended. The profiles must always be arranged in a vertical position regardless of the position of the panel.



Assembly details and specifications

Page.7



* Recommended distances without prior study of the project. These distances may vary depending on the premises of each project.

The strips must be straight and smooth, they must be placed parallel to ensure a uniform distribution of efforts. The distance between panels must be sufficient to avoid compression between them at the moment of dilatation (minimum 10 mm) and thus avoid overloading the fixing system. Consult the manufacturer for the technical characteristics of the panel to obtain this information. At the same time, the possible movements of the substructure due to the thermal changes must be taken into account. It is necessary to maintain free circulation of air through the top and bottom of the panels to avoid an excess of temperature in these.

The strips on the substructure must be of the following minimum sizes:

- Strip shared by two panels: Width of 100 mm
- Strip for a single panel: Width of 50 mm (minimum)

The Soltec Panel-Fix® adhesive as well as the Soltec Panel-Fix® C tape must be continuously applied over the entire length (height) of the panel.

- Width of the Soltec Panel-Fix® adhesive bead: 12 mm
- Width of the Soltec Panel-Fix® C tape: 12 mm

The substructure must guarantee a ventilation behind the panels of at least 20 mm between the panel and the supporting wall of the substructure.

The panels to be installed must not exceed a maximum diagonal length of 3.300 mm (data to be consulted with the technical department depending on the thickness and type of panel). Check it with the Soltec technical department.



Application of the system

- On aluminum substructure:

- 1.- Guarantee a strip surface that is free of dust particles or other type of dirt that could weaken the bond. Cleaning with acetone or methyl ethyl ketone is recommended (do not use turpentine). **In the case of raw aluminum profiles, prior cleaning with acetone or methyl ethyl ketone is imperative to eliminate oxide dust from the surface of the profile.**
- 2.- Let it evaporate for 10 minutes.
- 3.- Shake the bottle of Soltec Panel-Fix® P202 promoter several times. If you detect that the Soltec Panel-Fix® P202 promoter has turned into a paste, has changed colour or is not homogeneous, replace it with another bottle of Soltec Panel-Fix® P202 promoter that is in good material condition.
- 4.- Apply a fine layer of Soltec Panel-Fix® P202 promoter to the support (strip) using a disposable cellulose paper and rubbing it from top to bottom (not in a circular motion) as many times as required until the paper no longer stains and always in the same direction. Discard the paper with each new application.
- 5.- Let it evaporate for 10 minutes.
- 6.- Shake the bottle of black Soltec Panel-Fix® 451SW primer until you can hear the ball located inside the bottle several times. If we detect that the Soltec Panel-Fix® 451SW primer has turned into a paste, has changed colour or is not homogeneous, replace it with another bottle of Soltec Panel-Fix® 451SW primer that is in good material condition. Using a flat brush or paint brush that is clean and not contaminated by external agents, apply the black Soltec Panel-Fix® 451SW primer to the entire contact surface with the Soltec Panel-Fix® adhesive from top to bottom (not in a circular motion). Apply a single layer. Once it has dried, do not apply a second layer over it. Apply Soltec Panel-Fix® 451SW primer within 15 min after Soltec Panel-Fix® P202 promoter has dried.
- 7.- Let it evaporate between 15 and 25 min (ref. technical table page 2/10)



The Soltec Panel-Fix® P202 promoter or the Soltec Panel-Fix® 451SW primer cannot be applied unless the system is going to be applied within the time frame stipulated in this dossier. The surfaces cannot be treated with the Soltec Panel-Fix® P202 promoter or the Soltec Panel-Fix® 451SW primer from one day to the next under any circumstance. The application times as well as the temperatures and the humidity must be observed in order to obtain a good result with the system.

- On Wooden substructure:

- 1.- Guarantee that the strip surface is free of dust and loose particles, paint or any other contaminating agent by vacuuming or blowing using compressed air. Eliminate possible contaminating agents using a scraper if required.
- 2.- Shake the bottle of Soltec Panel-Fix® 451SW primer until you can hear the ball located inside the bottle. Otherwise, if we detect that the Soltec Panel-Fix® 451SW primer has turned into a paste, has changed colour or is not homogeneous, replace it with another bottle of Soltec Panel-Fix® 451SW primer that is in good material condition.
- 3.- Apply a fine layer of Soltec Panel-Fix® 451SW primer on the support (strip) using a paint brush or flat brush that is clean and not contaminated by external agents. Apply a single layer from top to bottom (not in a circular motion). Once it has dried, do not apply a second layer over it. Apply Soltec Panel-Fix® 451SW primer within 15 min after Soltec Panel-Fix® P202 promoter has dried.
- 4.- Let it evaporate between 15 and 25 min (ref. technical table page 2/10)



In order to guarantee that the bottles of Soltec Panel-Fix® P202 promoter and Soltec Panel-Fix® 451SW primer are not contaminated during use we must pour the amount of Soltec Panel-Fix® P202 promoter or Soltec Panel-Fix® 451SW primer we are going to use in a container and immediately place the cap back on the bottle.

Once a bottle of Soltec Panel-Fix® P202 promoter or Soltec Panel-Fix® 451SW primer is opened, it must be used within the next 24 hours. Do not expose the Soltec Panel-Fix® P202 promoter or the Soltec Panel-Fix® 451SW primer to the sun while they are being applied or stored.

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The drying times must be observed for the Soltec Panel-Fix® P202 promoter and the Soltec Panel-Fix® 451SW primer under all circumstances. When the Soltec Panel-Fix® P202 promoter and Soltec Panel-Fix® 451SW primer have dried, these can only be removed mechanically.

The Soltec Panel-Fix® P202 promoter or the Soltec Panel-Fix® 451SW primer cannot be applied unless the system is going to be applied within the time frame stipulated in this dossier. The surfaces cannot be pre-treated with Soltec Panel-Fix® P202 promoter or Soltec Panel-Fix® 451SW primer one day and Soltec Panel-Fix® adhesive applied the next day or days thereafter under no circumstances. The application times as well as the temperatures and the humidity must be respected in order to obtain a good result with the system.

If the substructure is made of any other type of metal (i.e. galvanized metal, lacquered, pre-lacquered, etc.), consult with the technical department.

- Façade panels:

- 1.- Guarantee a panel surface that is free of dust particles or other type of dirt that could weaken the bond. The panels that have a shiny finish through a silicone treatment must be treated by abrasion (sanding) in the contact area with the primer (consult our technical department). For extreme dirt, clean with acetone or methylethylketone (no turpentine).
- 2.- Let evaporate for 10 minutes.
- 3.- Shake the bottle of Soltec Panel-Fix® P202 promoter several times. If we detect that the Soltec Panel-Fix® P202 promoter has turned into a paste, has changed colour or is not homogeneous, replace it with another bottle of Soltec Panel-Fix® P202 promoter that is in good material condition.
- 4.- Apply a fine layer of Soltec Panel-Fix® P202 promoter to the panel using a disposable cellulose paper and rubbing it from top to bottom (not in a circular motion) as many times as required until the paper no longer stains and always in the same direction. Discard the paper with each new application.
- 5.- Let evaporate for 10 minutes.
- 6.- Using a flat brush or paint brush that is clean and not contaminated by external agents, apply a single coat of the black Soltec Panel-Fix® 451SW primer to the entire contact surface with the Soltec Panel-Fix® adhesive from top to bottom (not in a circular motion). Once it has dried, do not apply a second layer over it. Apply Soltec Panel-Fix® 451SW primer within 15 min after Soltec Panel-Fix® P202 promoter has dried.
- 7.- Let it evaporate between 15 and 25 min (ref. technical table page 2/10)



Do not expose any of the components that comprise this system to sunlight or extreme temperatures during the application (consult the panel manufacturer). Do not expose any of the components that comprise this system to sunlight during the application.

The Soltec Panel-Fix® P202 promoter or the Soltec Panel-Fix® 451SW primer cannot be applied unless the system is going to be applied within the time frame stipulated in this dossier. The surfaces cannot be pre-treated with Soltec Panel-Fix® P202 promoter or Soltec Panel-Fix® 451SW primer one day and Soltec Panel-Fix® adhesive applied the next day or days thereafter under no circumstances. The application times as well as the temperatures and the humidity must be respected in order to obtain a good result with the system.

- Soltec Panel-Fix® C tape:

- 1.- Apply the Panel-Fix® C tape to the entire length (height) of the strip in a uniform manner and press firmly, guaranteeing that the entire height of the panel will be in contact with the tape. Do not remove the protective tape for now.



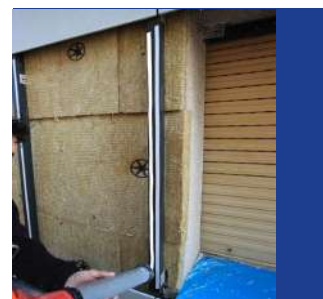
- Soltec Panel-Fix® adhesive:

- 1.- Longitudinally and without interruptions, apply a bead of Soltec Panel-Fix® adhesive parallel to the tape (on the strip) 10 mm wide and 8 mm high using the triangular tip that is included with the system. The Panel-Fix® adhesive is applied



using a manual or pneumatic extrusion gun. Once the cartridge is opened, the product must be applied within 24 hours. During the polymerisation, avoid coming in contact with polyurethanes and non-polymer-based silicones. Apply the bead of adhesive immediately before installing the panel. If high temperatures or humidity is present, the exposed part of the adhesive may begin to harden in just a few minutes and may not bond properly to the panel once it has polymerised.

Apply the Soltec Panel-Fix® adhesive no later than 2 hours after the Soltec Panel-Fix® 451SW primer has dried.



- Fix the panel:



- 1.- Remove the protective tape from the Soltec Panel-Fix® C tape.
- 2.- Install the panel in its location and ensure it is properly positioned because you will not be able to change its position once it comes in contact with the Soltec Panel-Fix® C tape.
- 3.- Press the panel in the contact areas with the Soltec Panel-Fix® adhesive.

The final fixing of the panel must be carried out during the first 5 minutes after applying the Soltec Panel-Fix® adhesive.

This document is the latest version of the Soltec Panel-Fix® system and replaces and rescinds any previous version.

Important note: The information provided about the primers and preliminary treatment of the panels are to be used as a general guide and will be dependent on the type of panel that is used. Due to the large number of HPL panels and ceramics that are available, another type of treatment may be required. Always consult the instructions and data sheets with the manufacturer of the panel. We recommend to always carry out preliminary tests. The tasks to be carried out for this system must be carried out by specialised personnel. The materials to be bonded must be kept 3°C above the dew point to prevent condensation from occurring on the surface. The materials must be protected against dust and dirt in order to guarantee we keep the working environment free of contaminating agents for the materials.

Consumptions

Per linear meter: (installation of the substructure with strips each 40 to 50 cm)

Soltec Panel-Fix® adhesive:	0.8 x 10 mm triangular bed	~52 ml/m
Soltec Panel-Fix® 451SW primer:	Width of 50 mm	~8,5 ml/m
Soltec Panel-Fix® P202 promoter:	Width of 50 mm	~4 ml/m
Soltec Panel-Fix® C tape:	Width of 12 mm	1 m/m

Per m²: (installation of the substructure with strips each 40 to 50 cm for 100 m²)

Soltec Panel-Fix® adhesive:	0.8 x 10 mm triangular bed	50 cartridges or 24 sausages
Soltec Panel-Fix® 451SW primer:	Width of 50 mm	3,5 bottles with 1L each
Soltec Panel-Fix® P202 promoter:	Width of 50 mm	1,5 bottles of 1L each
Soltec Panel-Fix® C tape:	Width of 12 mm	15 rolls with 20 ml each



Hygiene and safety

Read the safety data sheet prior to using any product. Use rubber gloves to protect your hands. Avoid having the product come in contact with the skin and eyes. If product comes in contact with the eyes, rinse with abundant water and immediately seek medical attention. Do not pour the product down the drain or on the ground neither before or after it has polymerised.

NOTE: The present and technical indications for the materials and for the specific system are based on the knowledge and experience we have acquired under normal conditions for application, storage and handling and any error, inaccuracy, omission or inadequacy of the document resulting from technological advances and from the search between the issue date of this document and product purchase date may not be invoked against us. The possible differences in the materials and supports and the current conditions are such, from the information included in this document or from any other written recommendation or recommendation that may be provided, that no guarantee can be deduced in terms of the commercialisation or suitability for specific purposes, nor any obligation from any legal relationship that may exist.

The consumer of the product will conduct a test to verify that the product is suitable for the intended use. Also, any consumer, before the seller or manufacturer, shall review all the technical information relevant to a hypothetical use and should ascertain if all available indications seem to be suitable for normal use as well as for any specific use of our product.

Our guarantee is provided within the context of legal provisions and regulations as well as the current professional rules and still in accordance with our terms of sale. The information resulting from this document are purely indicative and not comprehensive, as is all the information provided verbally through telephone conversations with the client.

All the technical data included in these sheets are based on the results of laboratory tests. At the moment of the application, changes may occur to this data due to circumstances that are out of our control.



Daily installation part – Soltec Panel-Fix® system

(1/3)

Data installation company:

Project:

Name:	Name:
Address:	Address:
	Start date:

Operator data:

Name:	Application dossier delivered: Yes ☐ No ☐
-------	--

Weather conditions:

Minimum temperature (morning) °C:		Environment:	
		Of the panel:	
		Of the profiles:	
Relative humidity of environment %:			
Cloudy ☐	Sunny ☐	Rainy ☐	
Minimum temperature (midday) °C:		Environment:	
		Of the panel:	
		Of the profiles:	
Relative humidity of environment %:			
Cloudy ☐	Sunny ☐	Rainy ☐	



Daily installation part – Soltec Panel-Fix® system

(2/3)

Panel data:

Panel type:	Brand and business model:
Maximum length (mm):	Maximum width (mm):
Maximum thickness (mm):	Maximum weight (gr):

Substructure data:

Type of material:	Minimum profile width, contact surface (mm):
Distance between profiles (mm):	

Panel treatment:

Sanded: Yes ☐ No ☐	Surface: Wet: ☐ Moist : ☐ Dry: ☐
Soltec Panel-Fix® 451SW primer: Yes ☐ No ☐	Wait time in minutes:
Soltec Panel-Fix® P202 promoter: Yes ☐ No ☐	Wait time in minutes:

Substructure treatment:

Sanded: Yes ☐ No ☐	Surface: Wet: ☐ Moist: ☐ Dry: ☐
Soltec Panel-Fix® 451SW primer: Yes ☐ No ☐	Wait time in minutes:
Soltec Panel-Fix® P202 promoter: Yes ☐ No ☐	Wait time in minutes:



Daily installation part – Soltec Panel-Fix® system

(3/3)

Glued execution:

<i>Soltec Panel-Fix® C tape:</i> Yes ☐ No ☐		<i>Application over full panel length:</i> Yes ☐ No ☐	
<i>Soltec Panel-Fix® adhesive:</i> Yes ☐ No ☐		<i>Application over full panel length:</i> Yes ☐ No ☐	
		<i>Packaging of the Soltec Panel-Fix® adhesive:</i> ☐ Sausage ☐ Cartridge	
		<i>Batch number of Soltec Panel-Fix® P202 promoter:</i> _____	
		<i>Batch number of Soltec Panel-Fix® 451SW primer:</i> _____	
		<i>Batch number of Soltec Panel-Fix® adhesive:</i> _____	
		<i>Batch number of Soltec Panel-Fix® C tape:</i> _____	

at _____ on _____ of the

Signature:

In order to ensure the correct application of the system, it's necessary to complete the installation part every day throughout the installation.

