

	Varia Ecoresin Fizz, Float	Duo Koda XT	Chroma	Stone	Glass	Unsealed Wood	Sealed Wood	Metal ³
Varia Ecoresin Fizz, Float	Primer 94 with VHB 4496 ¹ + Weld-On 55/58	Primer 94 with VHB 4496 ¹ + Weld-On 55/58	Primer 94 with VHB 4496 ¹ + Seam It 304	Primer 94 with VHB 4496 ¹ + Seam It 304	Primer 94 with VHB 4496 ¹ + SilGlaze II ²	Plexus MA310 SilGlaze II ²	Weld-On 55/58 SilGlaze II ² VHB 4496 ¹ +94	Plexus MA310 SilGlaze II ² VHB 4496 ¹ +94
Duo Koda XT	Primer 94 with VHB 4496 ¹ + Weld-On 55/58	Primer 94 with VHB 4496 ¹ + Weld-On 55/58	Primer 94 with VHB 4496 ¹ + Seam It 304	Primer 94 with VHB 4496 ¹ + Seam It 304	Primer 94 with VHB 4496 ¹ + SilGlaze II ²	Plexus MA310 SilGlaze II ²	Weld-On 55/58 SilGlaze II ² VHB 4496 ¹	Plexus MA310 SilGlaze II ² VHB 4496 ¹
Chroma	Primer 94 with VHB 4496 ¹ + Seam It 304	Primer 94 with VHB 4496 ¹ + Seam It 304	Primer 94 with VHB 4496 ¹ + Seam It 304	Primer 94 with VHB 4496 ¹ + Seam It 304	Primer 94 with VHB 4496 ¹ + SilGlaze II ²	SilGlaze II ²	SilGlaze II ² Primer 94 with VHB 4496 ¹	SilGlaze II ² Primer 94 with VHB 4496 ¹
Stone	Primer 94 with VHB 4496 ¹ + Weld-On 55/58	Primer 94 with VHB 4496 ¹ + Weld-On 55/58	Primer 94 with VHB 4496 ¹ + Seam It 304	Primer 94 with VHB 4496 ¹ + Seam It 304	Primer 94 with VHB 4496 ¹ + SilGlaze II ²	Plexus MA310 SilGlaze II ²	Weld-On 55/58 SilGlaze II ² VHB 4496 ¹	Plexus MA310 SilGlaze II ² VHB 4496 ¹
Glass	Primer 94 with VHB 4496 ¹ + Loctite H5004	Primer 94 with VHB 4496 ¹ + Loctite H5004	Primer 94 with VHB 4496 ¹ + Loctite H5004	Primer 94 with VHB 4496 ¹ + Loctite H5004	Primer 94 with VHB 4496 ¹ + SilGlaze II ²	SilGlaze II ² Loctite H5004	Primer 94 with VHB 4496 ¹ + SilGlaze II ²	Primer 94 with VHB 4496 ¹ + Loctite H5004

All products are available for purchase from 3form. Please see product fabrication manuals for application techniques and surface preparation.

¹Clear VHB 4910 or white 3M 3496 foam tape can be used when necessary. Use 3M Primer 94 when adhering VHB to Varia Ecoresin or Chroma.

²Silicone is to be used for glazing and sealing ONLY. Choose a structural adhesive for applications like adhering a panel directly to a wall.

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 Seam It (ICE 304 clear) for seaming Chroma.
- Use Plexus MA310 for applying plastic panels to non-plastic substrates.
- Use 3M VHB tape when you want clean lines or in place of mechanical fasteners in applications like stair treads or countertop mounting.
- Use GE Silicone for most structural glazing and sealing 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 Ecoresin Fizz, Float	Duo Koda XT	Chroma	Stone	Profile	Glass	Unsealed Wood	Sealed Wood	Metal ³	Primed/ Painted Drywall ⁴
Varia Ecoresin Fizz, Float, PEP	Primer 94 with VHB 4496 ¹ + Weld-On 55/58	Primer 94 with VHB 4496 ¹ + Weld-On 55/58	Primer 94 with VHB 4496 ¹ + Seam It 304 Plexus MA310	Primer 94 with VHB 4496 ¹ + Seam It 304 Plexus MA310	Primer 94 with VHB 4496 ¹ + Loctite 1390595 ⁵	Primer 94 with VHB 4496 ¹ + SilGlaze II ²	3form recom- ends sealing	Primer 94 with VHB 4496 ¹ + Plexus MA310 or SilGlaze II ²	Primer 94 with VHB 4496 ¹ + Plexus MA310 or SilGlaze II ²	Primer 94 with VHB 4496 ¹ + SilGlaze II ²
Duo Koda XT	Primer 94 with VHB 4496 ¹ + Weld-On 55/58	Primer 94 with VHB 4496 ¹ + Weld-On 55/58	Primer 94 with VHB 4496 ¹ + Seam It 304	Primer 94 with VHB 4496 ¹ + Seam It 304	Primer 94 with VHB 4496 ¹ + Loctite 1390595 ⁵	Primer 94 with VHB 4496 ¹ + SilGlaze II ²	3form recom- ends sealing	Primer 94 with VHB 4496 ¹ + Weld-On 55/58 or SilGlaze II ²	Primer 94 with VHB 4496 ¹ + Weld-On 55/58 or SilGlaze II ²	VHB 4496 ¹ + SilGlaze II ²
Chroma	Primer 94 with VHB 4496 ¹ + Seam It 304 Plexus MA310	Primer 94 with VHB 4496 ¹ + Seam It 304	Primer 94 with VHB 4496 ¹ + Seam It 304	Primer 94 with VHB 4496 ¹ + Seam It 304	Primer 94 with VHB 4496 ¹ + Loctite 1390595 ⁵	Primer 94 with VHB 4496 ¹ + SilGlaze II ²	3form recom- ends sealing	Primer 94 with VHB 4496 ¹ + SilGlaze II ²	Primer 94 with VHB 4496 ¹ + SilGlaze II ²	Primer 94 with VHB 4496 ¹ + SilGlaze II ²
Stone	Primer 94 with VHB 4496 ¹ + Seam It 304	Primer 94 with VHB 4496 ¹ + Seam It 304	Primer 94 with VHB 4496 ¹ + Seam It 304	Primer 94 with VHB 4496 ¹ + Seam It 304	Primer 94 with VHB 4496 ¹ + Loctite 1390595 ⁵	Primer 94 with VHB 4496 ¹ + Loctite 3035	3form recom- ends sealing	Primer 94 with VHB 4496 ¹ + Weld-On 55/58 or SilGlaze II ²	Primer 94 with VHB 4496 ¹ + Plexus MA310 or SilGlaze II ²	VHB 4496 ¹ + SilGlaze II ²

All products are available for purchase from 3form. Please see product fabrication manuals for application techniques and surface preparation.

¹Clear VHB 4910 can be specified when necessary. Use 3M Primer 94 when adhering VHB to Varia Ecoresin or Chroma.

²Silicone is to be used for glazing and sealing ONLY. Choose a structural adhesive for applications like adhering a panel directly to a wall.

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

⁴Drywall is a poor substrate to achieve high bonding strength. 3form does not recommend bonding panels greater than 1/4" directly to drywall. See 3form load bearing aluminum angle detail.

⁵Loctite 1390595 is the intended for primary adhesion. 3form recommends scuffing the surface of Profile panels (100 grit) before applying the 1390595 to improve bond.

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 Seam It (ICE 304 clear) for seaming Chroma.
- Use Devcon Plexus MA310 for applying plastic panels to non-plastic substrates.
- Use 3M VHB tape when you want clean lines or in place of mechanical fasteners in applications like stair treads or countertop mounting.
- Use formerly GE Silicone for most structural glazing and sealing applications.

	Varia Ecoresin Fizz & Float	Koda XT	Chroma	Alabaster	100 PERCENT	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	Momentive SilGlaze II SCS 2801	Momentive SilGlaze II SCS 2801
Structural Glazing	Momentive SCS 1201	Momentive SCS 1201	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
Seam It 304	3-20-318	3-20-320	3-20-319	35	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
Loctite H5004	3-20-315	3-05-0056	3-05-0057	50	colorless	3 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 (capsule)	3-05-0068	Use tip of capsule		0.66	colorless	5 min	n/a	n/a
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 SCS2801	3-05-0069	Use standard caulk gun		295	translucent	6-12 min.	2-4 days	neutral cure
Momentive SCS1201	3-05-0070	Use standard caulk gun		295	translucent	30 min	3-4 days	acid-cure

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

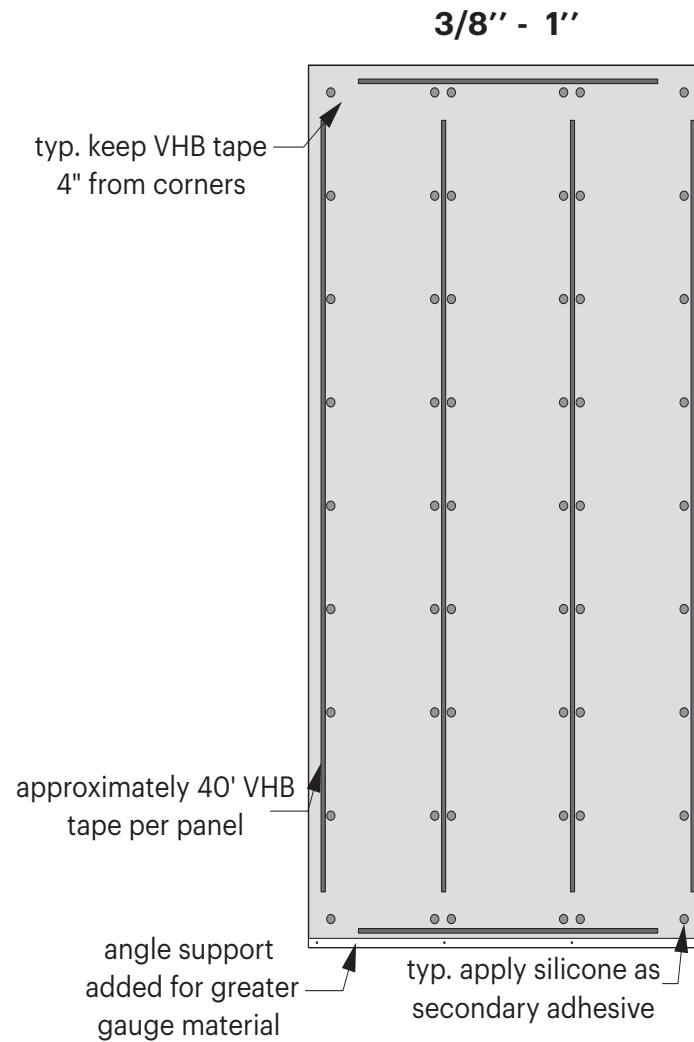
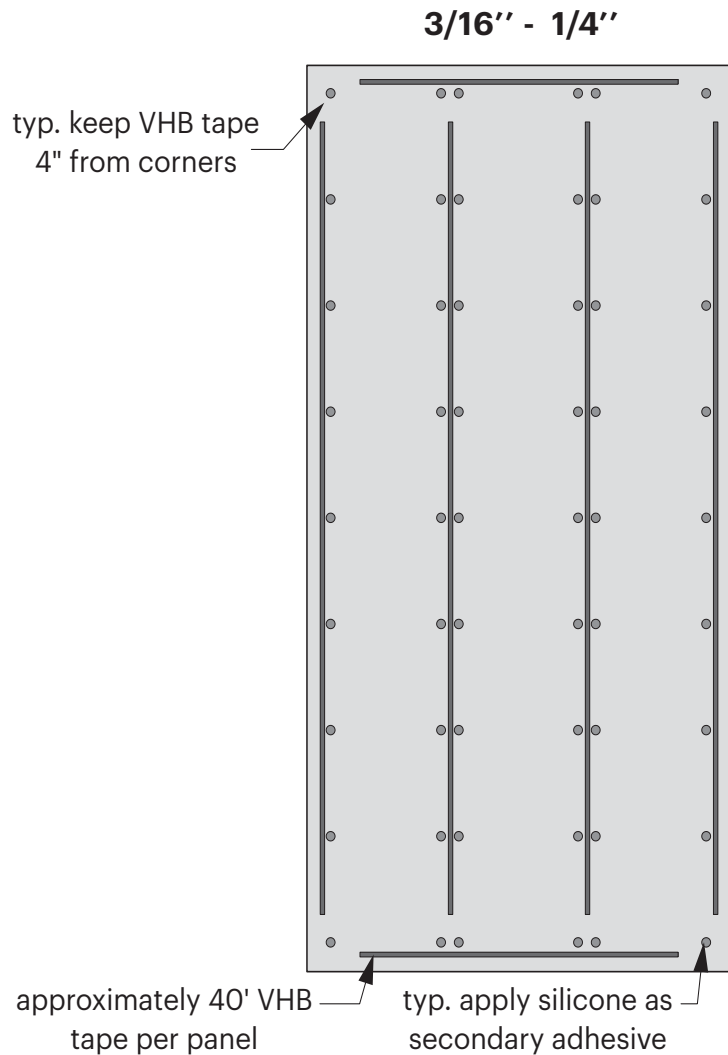
All technical specification sheets and MSDS forms are available upon request. email: technical@3-form.com

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

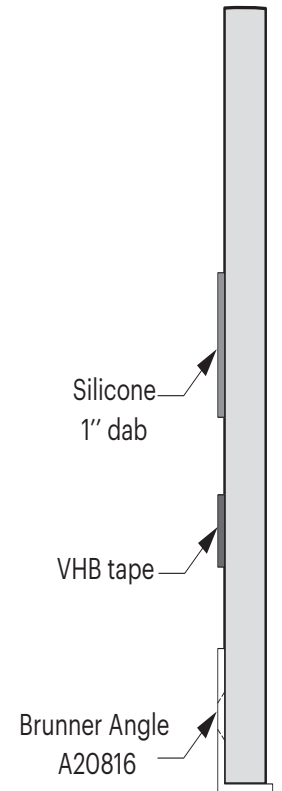
Square ft per 35ml	Square ft per 50ml	Square ft per 230ml
2	2.5	11.5

Masking Tape Recommendations

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



**angle support
section detail
3/8" - 1"**



**!adhesives will be visible through translucent materials!
!specify a layer of Avalanche to hide adhesives!**