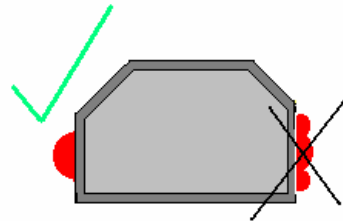


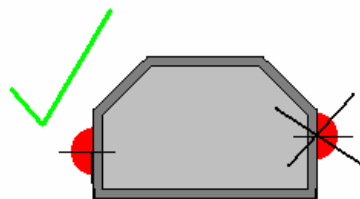
## Applying GD115 correctly

### 1.) Amount and geometry



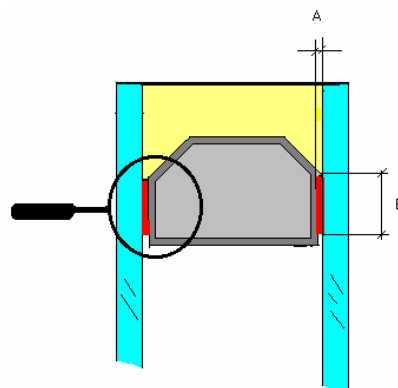
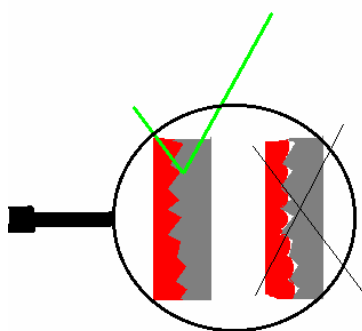
Apply **2.5 ± 0.5g** (GD115 with a density of 1,05 kg/litre) per side and running metre of spacer irrespective of spacer bar width. The bead should have a semi circular shape. Apply the bead continuously. The surface of the applied butyl should be free of indentations.

### 2.) Position



The bead should be applied centrally as shown. Avoid placing the bead too far back since it may slip onto the back of the spacer bar. Similarly placing the bead too far forward may result in butyl ingress into the airspace.

### 3.) Pressing



Two issues are important here :

#### 3.1 The time during which pressure is applied.

In order for the butyl to wet the surface correctly a minimum pressing time of 3 seconds must be adhered to. On a microscopic scale the glass surface is very uneven and therefore some time is needed for the butyl to flow into the cavities.

### 3.2 The dimension of the seal after pressing.

After pressing the width of the butyl ( Dimension B in the drawing ) should be at least **3mm**. The thickness of the butyl ( Dimension A in the drawing) must be at least **0.3 mm**.

## 4. Advice on processing the GD115 correctly

For full details please refer to the relevant data sheets.

Butyl extruders have two means of control:

1. The temperature setting controls the tackiness of the butyl bead upon application. Set the temperature to no more than 150 °C ( otherwise the butyl will thermally degrade). Remember to allow for the system to adapt to any changes in temperature settings before altering these.
2. The coating weight is determined by the feed pressure of the system and /or by the belt speed

The coating weight prescribed under point 1. should be checked periodically..