

Assembly instructions

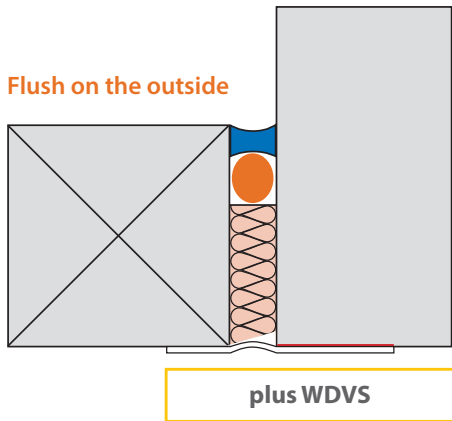
Instructions for processing of all RALMO[®] foils and RALMO[®] tapes:

- All profile openings, such as cut edges of extensions and windowsill profiles or end-to-end grooves in mounted roller shutter casings, must be sealed with RALMO[®]-Fix sealant.
- The surfaces of the blind frame and the masonry to be bonded must be clean and dry, free of dust, grease and release agents (as used for new plastic profiles).
- The surface coating on wooden windows should be a couple of days old, as otherwise escaping solvents may reduce the tape adhesion. If necessary, remove dirt with grease-dissolving cleaning agents. Pay attention to material compatibility.
- In the case of highly absorbent, sandy surfaces, pre-treat the building structure with an adhesion promoter such as RALMO[®] spray primer, RALMO[®] spray adhesive, RALMO[®] solvent-free primer or RALMO primer 150 complete.
- In case of breakouts in the masonry, a clean smooth coat must be created again. We recommend the quick-setting mortar RALMO[®]-SanReMo Joint Filler, Racofix, Botament M37 or e.g. Maxit. Grain size max. 1.5 mm.
- Apply the tapes to the blind frame wrinkle-free and parallel and press them on the whole length. Let the tapes overlap at the corners and seal them hermetically and secured against driving rain.
- Sufficient movement absorption must be ensured by an adequate loop in the area of the connection joint.
- Recommended minimum adhesive width on the window is 15 mm, on the wall 30 mm.
- The joint sealing strip should sufficiently overlap the masonry in the area of the later plaster (rule of thumb: at least 75% of the contact surface).
- All tapes from RALMONT (except for RALMO[®]-Window Vario) are covered with a fleece lamination and therefore suitable as a plaster base. (In conformity with the RAL Quality Association for Windows and Front Doors, installation guide.)
- The storage time of the self-adhesive films is 1 year at +20 ° C ± 5 ° C and 50% ± 10% humidity. The optimal processing temperature is between +15 ° C and +30 ° C.
- **We recommend:**
Rolling tapes make bonding easier and enable a uniform contact pressure. In the event of a leakage, the foils can be re-sealed with RALMO[®]-EPDM adhesive or RALMO[®] foil adhesive. (Pay attention to compatibility of materials according to the respective data sheet).

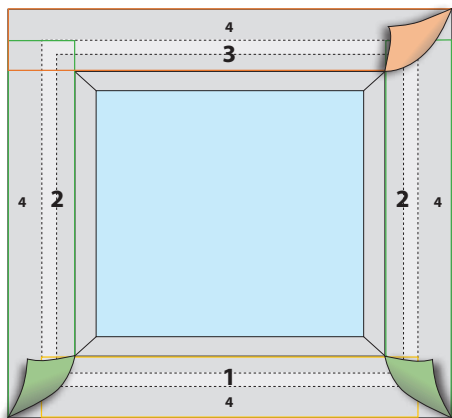
Art. Nr.	Bezeichnung
18-1-9-1	RALMO [®] -Professional hard pressure roller

Art. Nr.	Bezeichnung
18-1-9-2	RALMO [®] -Pressure roller soft

Important: Prior to any bonding of the tapes, holding surfaces must be checked and, if necessary, pre-treated with a RALMO adhesion promoter (primer) !!!

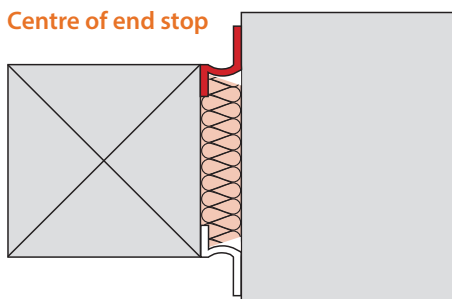


- Install windows flush with masonry on the outside
- Insert insulation and cut it slightly diagonally, glue foil inside and outside tightly
- Inside spray with RALMO®-Hybrid window and outside glue foil tightly to the building structure
- Bonding from the front is possible if no aluminum shell is present. With aluminum shell must be glued alternately

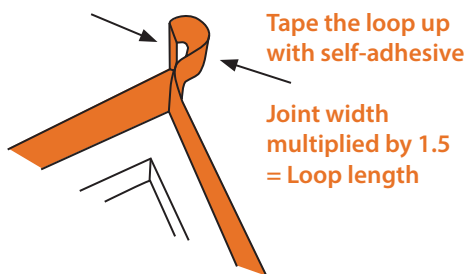


Bonding suggestion for flush outside:

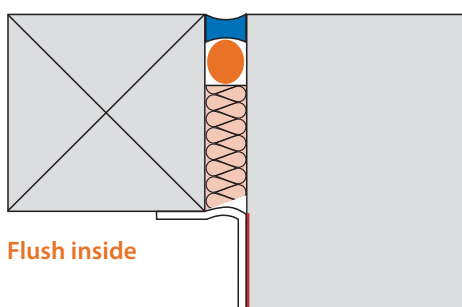
- **pply outer band 1 parallel at the bottom with self-adhesive strip and wrinkle-free**
- **ach outer band 2 to the side**
- **Attach outer tape 3 at the top**
- Observe the cutting length of the foils according to the picture



- Before mounting, mount the hinges on the window frame with the self-adhesive strip



- Form a loop at the top
- Mount window
- Mount tape at the bottom
- Insert insulation and cut at a slight angle



- Glue the tapes all around the masonry with **RALMO®-Top self-adhesive** in a driving rain-proof way, if necessary, glue the corners with **RALMO®-MS Polymer Öko**.

Our recommendation: The tapes must be bonded to the masonry over the entire surface (at least 25-30 mm).

ASSEMBLY INSTRUCTIONS

The lower connection on the outside must be installed very cleanly with a trough. We recommend RALMO®-FBA complete insulation/sealing wedge, RALMO®-EURO diffusion sheet or RALMO®-EPDM foil.

Before each installation, the substrate must be checked all around for unevenness, holes, wall joints, etc. and, if necessary, a smooth coat must be applied by the executing shell



construction company (grain size max. 1.5 mm). If this is not the case, concerns must be raised or the substrate prepared with RALMO®-SanReMo-Fugenfüller, Racofix, Botament M37 or e.g. from Maxit.

Poor substrates must be pre-treated with RALMO®-Primer.



RALMO mounting corners

Self-adhesive assembly corners for perfect and quick sealing of the lower corner areas of windows and floor-to-ceiling doors.

The lower door connections are the parts most subject to heavy exposure and must be processed very carefully, in order for them to permanently withstand pressing water, standing water, snow and driving rain.

With the ready-to-use RALMO® installation corners, corner connections can be sealed quickly and cost-effectively and are durably leak-tight.

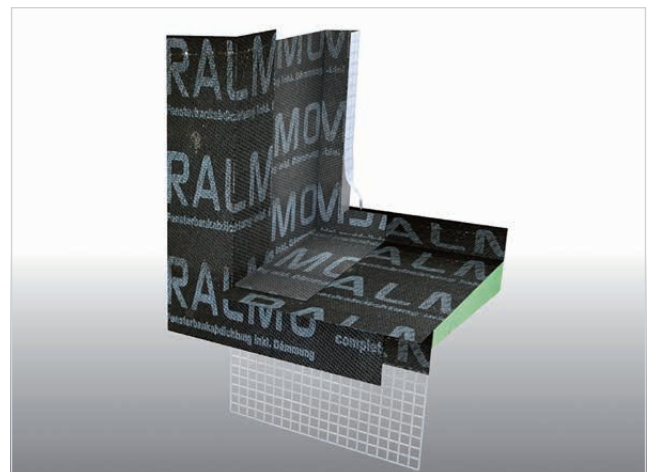
All RALMO assembly corners are made to measure.

- RALMO®-FBA mounting corner including corner patch
- RALMO® mounting corner with TAPE 4000
- RALMO® mounting corner with EPDM
- RALMO® mounting corner with EURO diffusion
- RALMO® assembly corner with Flex outside
- RALMO® installation corner with Flex inside SD 40
- RALMO® installation corner with Flex inside SD 70
- RALMO® mounting corner with D-A-2 aluminium inside SD 1500
- RALMO® mounting corner woodwork beige

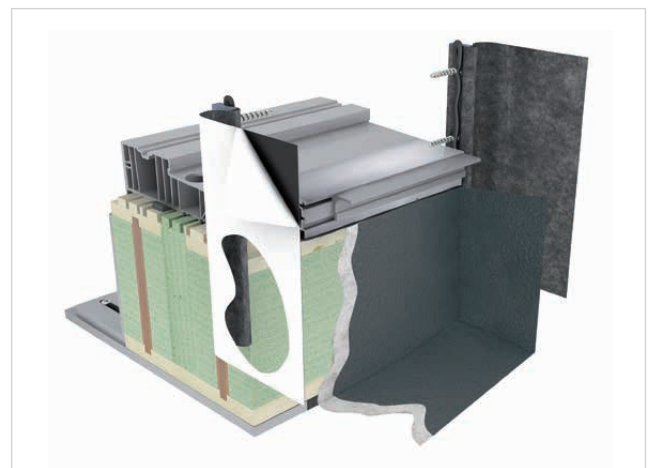
Connection flange

At low temperatures, priming or scarfing is required when bonding to masonry!

Prime the masonry with RALMO®-LFB Primer and roll the bitumen cloth neatly without folds with an expansion loop. If necessary, bond the surrounding edges with RALMO®-Montage FIX ALL SEASONS. This prevents the film from rolling up if the masonry is not plastered for a longer period of time or the lower connection remains free. We recommend warming up the surfaces during the cold season. If necessary, prime the area to be plastered over with RALMO®-LFB Primer and use the enclosed RALMO® Plaster Fleece (white) as a plaster base.



RALMO®-FBA Assembly corner including corner paving



Fill assembly joint:

- Screw the RALMO®-DÄMM fine cell can onto the foam gun.
- Put the plastic tip on the gun and cut it off, with it the DÄMM fine cell foam swirls very well and gets its fine structure.
- Screw the PU foam can tightly onto the gun thread and shake the can vigorously approx. 30 times with the gun pointing downwards, so that the can contents mix well for optimized foam quality. Gun must point down.
- Moisten the assembly joint with water with the help of the RALMO® pump bottle (do not water) (window frame and masonry). This procedure is very important for the structure of the foam.
- Foam the assembly joint up to approx. 10 mm behind the window edge. Cut off any excess hardened foam flush.



Tip: In order to obtain the maximum yield from the foam can and a perfect foam appearance, the PU foam and the surface must be moistened (not watered), by this the foam can expand evenly. Since the window profiles are getting

thicker, it is advisable to foam from the inside and outside or in two steps from one side, since the foam may get too little humidity when applied in one single step, and holes may thus form in the foam pattern.

Pre-treatment of the surface:

Primers are often referred to as adhesion promoters. This designation describes their function very well, as in the case of poorly bondable surfaces these products create a bonding bridge between the material and the adhesive, improving the adhesion properties of the bonded joint.

Primers are most effective when applied in very thin layers. Thin application is also advisable for quick drying. Compliance with the specified minimum drying times is important.

Solventborne primers

RALMO®-Primer complete 150,

RALMO®-Spray Primer and

RALMO® spray adhesive must be dry before the films can be bonded. This takes between 20 and 40 minutes, depending on the temperature.

Solvent-free primers

RALMO®-Multiprimer-LFB - are permanently adhesive, so that primer application and bonding can also be carried out separately in time.

Flash-off approx. 20 minutes, depending on temperature.

RALMO® - Multiprimer-LFB

Product description:

RALMO®-Multiprimer-LFB is a solvent-free primer / contact adhesive, also for bitumen surfaces.

Application:

RALMO®-Top Foils self-adhesive

RALMO®-TAPE 4000 (Butyl)

RALMO®-R3 window plus Multiband

RALMO® - Spray primer / adhesive

Product description:

RALMO® Spray primer / adhesive are ready-to-use, transparent adhesion promoters for common surfaces on construction sites, for improved adhesion on absorbent surfaces. Basis: solvent-based synthetic rubber.

Application:

RALMO®-Top Foils self-adhesive

RALMO®-TAPE 4000 (Butyl)

RALMO®-R3 window plus Multiband

RALMO®-MS Foil adhesive



On finished facades, clean work is particularly important, as the transparent spray primer can turn yellow. If necessary cover with a masking tape or apply accurately with a paintbrush.

RALMO - Primer complete 150

Product description:

RALMO-Primer complete 150 is a universal adhesive primer for pre-treatment of porous surfaces and metals. The transparent reaction primer based on epoxy resin can be used as an adhesion promoter for RALMO-MS polymer, RALMO butylene, RALMO-TAPE 4000, the RALMO top foils, silicones and PU sealants. It has a short flash-off time and is isocyanate-free.

Application:

RALMO-Top Foils self-adhesive

RALMO-TAPE 4000 (Butyl)

RALMO-R3 window plus Multiband

RALMO-MS Foil adhesive

Application areas:

- Sealing of glass panes with silicone
- Jointing of assembly joints for window installation as well as expansion joints with RALMO-MS polymer or PU.
- on dry or slightly damp, porous, absorbent construction materials as well as on metals
(but not on bitumen)