

**Gradus Grip – for use with Stair Trims (Welded Corners)**

(sheet 1 of 3) 25th October 2016

Gradus Grip data sheet applicable to the following products: TA2C, TA1, TA5, TA5B, TA5C, HT38, HT44, HT47, TP32, HT42, MT42, TA42, TAC42, TAXT5B, HXT44, HXT47, TAXT42, HXT42, TAXT5212, TAXT523, BT42, TA50, TA66

Site conditions vary - to ensure that this product is suitable and to confirm that this data sheet is current please contact our Technical Support department.

**Introduction**

Gradus Grip is a rapid curing flexible adhesive with excellent gap filling properties that is suitable for bonding Gradus Stair Trims (Welded Corners) to most solid surfaces in internal environments.

**Surface Preparation**

Prior to application ensure that all surfaces are smooth, level, sound, clean and free of laitance, dust and contamination. If a levelling compound or repair mortar is required, ensure that the manufacturer's instructions are followed to ensure the material is ready to provide a level and strong surface. The product to be adhered should also be clean and free from contamination such as oil or grease, or anything else that may impair adhesion.

Suitable Substrates:*	Non-suitable Substrates:
Electroplated Metal	Weak, friable, dusty concrete/ screed etc
Concrete / Powerfloat	Asphalt / Bitumen
Floor Smoothing Compounds	Polyethylene / Polypropylene
Repair Mortars (Cement and Epoxy)	Oil / grease contaminated surfaces
Terrazzo / Marble / Ceramics / Engineering Brick	
Fibre Glass	
Plywood / OSB / Chipboard / MDF / Wood	
Plaster / Plaster Board	
Paint / Epoxy / PU Coatings and Screeds	

\*This table is a guide only and you may encounter different substrates and other factors that will affect the suitability such as undulations, flaking paint or weak plaster.

**Application**

The adhesive should be applied in straight lines\*\* by means of a suitable applicator gun. Fix nozzle and cut the aperture to the required width dependant on application. Apply the adhesive to one surface only and then press the two surfaces together within the open time of the adhesive.

The following table has been compiled to provide a guide as to how much adhesive is required for each trim, dependant on the trim size and surface type. You must also refer to and follow the product specific installation instructions available from gradus.com before installation takes place. Ensure you apply the correct amount of adhesive to ensure a suitable bond.

Product Code	Absorbent Surface		Non-Absorbent Surface	
	Size of Bead	No. of Beads	Size of Bead	No. of Beads
TA2C, TA1, TA5, TA5B, TA5C, HT38, HT44, HT47, TP32	5mm	1	3mm	2
HT42, MT42, TA42, TAC42, TAXT5B, HXT44, HXT47, TAXT42, HXT42	5mm	1	3mm	2
TAXT5212, TAXT523, BT42, TA50, TA66	5mm	2	3mm	2

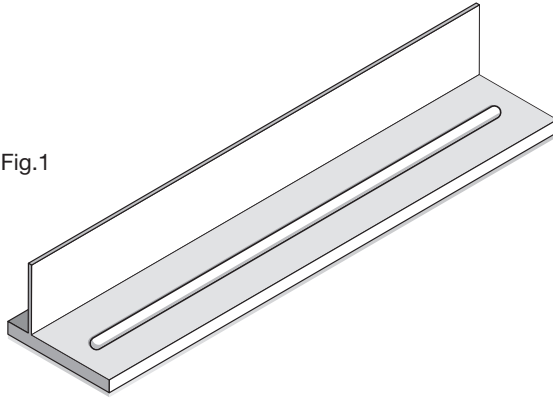
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**Absorbent Surfaces**

Apply the adhesive to the stair trim in accordance with the application table above. Where more than one bead is required ensure the beads are spread equidistant across the width of the base leaving a 5mm gap at the edges. (see Fig.1)

Fig.1



Place the trim on to the substrate and apply pressure along the length to ensure complete contact. Take care to remove any excess adhesive with a proprietary wipe. The fixed flange or fixing clip will hold the trim in place whilst the adhesive sets.

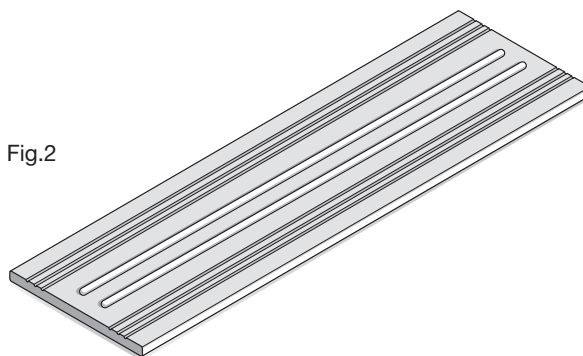
**Cure Time** – allow approximately 1 hour after fixing. The installation should be checked to ensure the bond is sufficiently secure before opening the area.

**Non-Absorbent Surfaces**

When bonding stair trims to metal substrates or other suitably smooth non-absorbent surfaces first dampen or mist the area with water. **Do not** leave standing water on the surface. In addition, mist the underside of the stair trim with water before applying adhesive. This method will accelerate the cure time of the adhesive and allow the area to be opened after a minimum of 2 hours, however the bond strength should be checked to ensure it is safe to open.

Apply the adhesive to the stair trim in accordance with the application table above. Where more than one bead is required ensure the beads are spread equidistant across the width of the trim leaving a 5mm gap at the edges. (see Fig.2)

Fig.2



Place the trim on to the substrate and apply pressure along the length to ensure complete contact. Take care to remove any excess adhesive with a proprietary wipe. The fixed flange or fixing clip will hold the trim in place whilst the adhesive sets.

**Cure Time** – allow approximately 2 hours after fixing. The installation should be checked to ensure the bond is sufficiently secure before opening the area. When bonding to non-absorbent surfaces that are not suitably dampened the cure time will be extended.

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**Cleaning**

Remove any excess wet adhesive from surfaces with a proprietary wipe.

**Precautions**

**Temperature** – adhesive must be applied onto substrates which are above 5°C and remain so whilst curing takes place.

**\*\*Do not snake / zig zag the adhesive beads, as this can significantly reduce bond strength** – always apply in straight (linear) beads.

Thicker beads take longer to cure, however always ensure sufficient material is applied relative to the installation being undertaken.

Always check the bond is secure before opening the area to traffic.

Do not apply adhesive above the locating flange or fixing clip. Do not remove fixing clips until the adhesive has set.

**Technical Information**

Colour	White
Consistency	Paste
Open Time @ 23°C and 50% RH	Maximum 10 minutes

**Coverage**

Tube Size	Bead Diameter	Coverage Per Tube (single bead)
290ml	3mm	38 metres <sup>†</sup>
290ml	5mm	14 metres <sup>†</sup>

**Note** – Coverage rates will depend on the condition and absorbency of the substrate

<sup>†</sup> Coverage per tube relates to total length of a single bead

**Packages**

290ml composite cartridge  
12 cartridges per carton

**Standards**

Conditions must comply with the relevant British Standards

**Tools**

Heavy duty applicator gun (preferably with an 18:1 trigger ratio)

**Storage & Shelf Life**

Store between 5°C and 25°C. Protect from frost.

18 month shelf life in unopened cartridges stored under good conditions.