



Assembly instructions

Instructions for the processing of all RALMO[®]-films and RALMO[®]-tapes:

- All profile openings, e.g. cut edges of widenings and window sill profiles or continuous grooves in attached roller shutter boxes, must be sealed with RALMO[®]-Fix sealant.
- The surfaces to be bonded to the frame and masonry must be clean and dry, free of dust, grease and separating agents (such as in the case of new plastic profiles).
- The surface coating on wooden windows should be a few days old, as the solvents, that would otherwise still escape, may reduce the adhesion of the tape. If necessary, remove soiling with grease-dissolving cleaning agents. Attention must be paid to material compatibility.
- In case of highly absorbent, sanding substrates, pre-treat the structure with an adhesion promoter e.g. RALMO[®]-Spray Primer, RALMO[®]-Spray Adhesive or RALMO[®]-Primer Solvent Free or RALMO[®]-Primer 150 complete.
- In case of chipping in the masonry, a clean smooth coat must be created again. We recommend the quick-setting mortar from Botament M37 in a 13 kg bucket with a drying time of approx. 15 minutes or Maxit in a 5 kg bucket and 25 kg bag with a drying time of 30-45 minutes, depending on the temperature.
- When bonding, the tapes must be applied to the frame without folds, in parallel and pressed on continuously. Allow the tapes to overlap at the corners and bond in a rain-tight or airtight manner.
- Movement absorption must be ensured by forming sufficient loops in the area of the connection joint.
- Recommended minimum adhesive width at the window is 10-20 mm. On the wall 25-30 mm, depending on the substrate (25 mm wood construction and clean smooth surface, coarse surface min. 30 mm).
- The joint sealing tape must be sufficiently bonded to the masonry in the area of the later plaster covering (rule of thumb: at least 75% of the contact area).
- All RALMONT tapes (except RALMO[®]-Window Vario) are covered with a fleece lamination and thus suitable as plaster base. (According to RAL-Gütegemeinschaft Fenster und Haustüren, guidelines for installation).
- The storage time of the films with self-adhesion is 1 year at +20 °C ± 5 °C and 50 % ± 10 % humidity. The optimum processing temperature is between +15 °C and +30 °C.

We recommend:

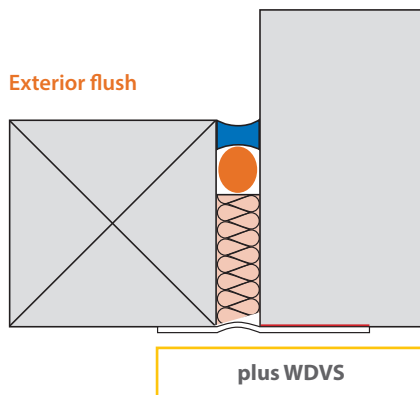
Rolling the tapes makes it easier for you to stick them and you get a uniform contact pressure.

Art. No.	Title	Art. No.	Title
2194	RALMO [®] -Andrückrolle Professional hart	21901	RALMO [®] -Andrückrolle weich

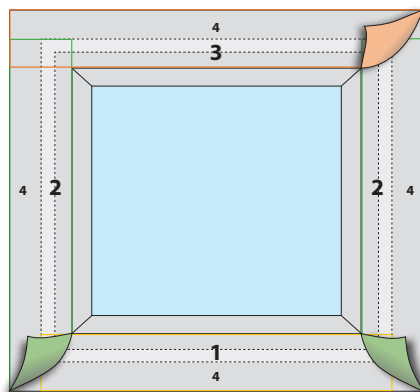
In case of leakage, the tapes can be re-glued with RALMO[®] adhesive. (Observe the compatibility according to the respective data sheet).

Important: Before each bonding of the tapes, the adhesive surfaces must be checked and, if necessary, pretreated with a RALMO[®] adhesion promoter (primer)!!!

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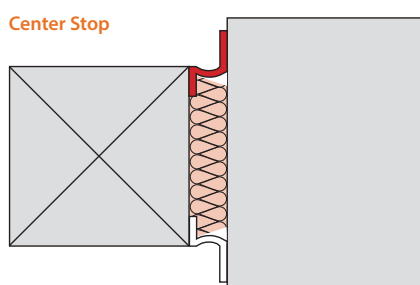


- Install windows exterior flush with masonry on the outside
- Insert insulation and cut slightly diagonally, glue foil tightly inside and outside
- On the Inside spray with RALMO®-Hybrid window and on the outside glue foil tightly to the building structure
- Bonding from the front is possible if there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

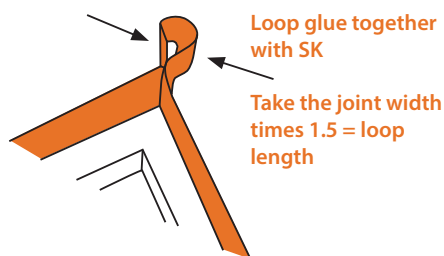


Bonding suggestion for exterior flush:

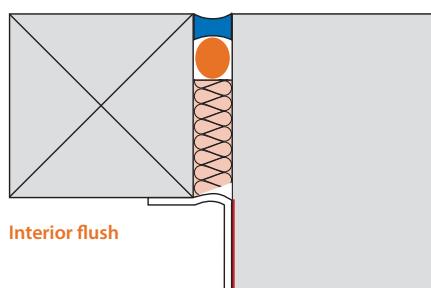
- **Apply outer band 1 parallel at the bottom with self-adhesive strip and wrinkle-free**
- **Attach outer band 2 to the side**
- **Attach outer tape 3 at the top**
- Observe the cutting length of the foils according to the picture



- 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 to the masonry all around 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 fully bonded to the contact surface on the masonry (at least 25-30 mm).

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The bottom connection outside must be installed very neatly with a tray. We recommend RALMO®-FBA complete insulation/sealing wedge, RALMO®-EURO diffusion sheet or RALMO®-EPDM foil.

A clean smooth coat must be present at each installation. We recommend the quick-setting mortar



from Botament M37 in a 13 kg bucket with a drying time of approx. 15 minutes or Maxit in a 5 kg bucket and 25 kg bag with a drying time of 30-45 minutes, depending on the temperature.

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



RALMO®-Mounting corners

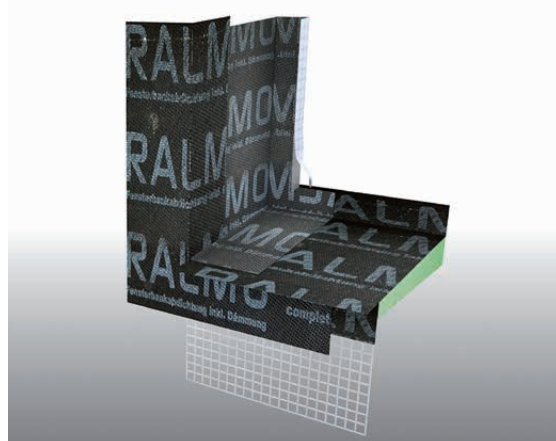
Self-adhesive mounting corners for a perfect and quick sealing of the lower corner areas of windows and floor-to-ceiling doors.

The lower connections on doors are subjected to the most stress and must be processed very carefully in order to permanently withstand pressing water, standing water, snow and driving rain.

With the ready-made **RALMO®-Mounting corners**, corner connections are made quickly, cost-effectively and permanently tight.

All RALMO®-Mounting corners are made to measure.

- RALMO®-FBA mounting corner incl. corner plaster
- RALMO®-Mounting corner made of TAPE 4000
- RALMO®-Mounting corner made of EPDM
- RALMO®-Mounting corner made of EURO-Diffusion
- RALMO®-Mounting corner made of Flex outside
- RALMO®-assembly corner made of Flex inside SD 40



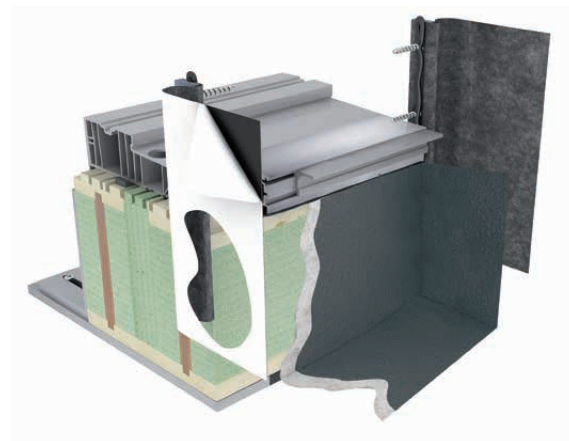
RALMO®-FBA Mounting corner incl. corner patch

- RALMO®-Mounting corner from Flex inside SD 70
- RALMO®-Mounting corner of D-A-2 Alu inside SD 1500
- RALMO®-Mounting corner wood construction beige

Connection flange

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

Prime masonry with RALMO®-LFB Primer and roll the bitumen cloth neatly without folds with an expansion loop. If necessary, glue 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.



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Fill the assembly joint:

- Screw the RALMO®-DÄMM fine cell can onto the foam gun.
- Put the plastic tip on the gun and cut it off, thus the DÄMM-finecell-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 and the foam quality is optimized. The pistol must point downwards.
- Moisten the assembly joint with water using the RALMO®-Pump bottle (do not water) (window frame and masonry). This process is very important for the structure of the foam.
- Foam the joint up to approx. 10 mm behind the window edge. Cut off any excess, hardened foam flush.



Tip: If you want to get the maximum yield from the foam can and a perfect foam pattern, the PU foam and the substrate must be moistened (not watered), then the foam can only expand cleanly. As the window profiles become thicker and thicker, it is advisable to foam from the inside and outside, or twice from one side, because the foam gets too little moisture in the air when applied once, which can cause holes to form in the foam pattern.

Pre-treatment of the substrate:

Primers are often also referred to as adhesion promoters. This designation describes the function very well, because these products create a bonding bridge between the material and the adhesive on surfaces that are difficult to bond, thus improving the adhesive properties of the bonded joint.

Primers are most effective when applied in very thin layers. Thin application is also advisable because of rapid drying. It is important to observe the specified minimum drying times.

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

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RALMO®-Multiprimer-LFB

Product description:

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

Application:

RALMO®-Top Folien 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 substrates in construction to improve the bonding surfaces of absorbent substrates.

Basis: solvent-based synthetic rubber.

Application:

RALMO®-Top Folien self-adhesive

RALMO®-TAPE 4000 (Butyl)

RALMO®-R3 window plus Multiband

RALMO®-MS Foil adhesive

Particular care must be taken with finished facades to ensure that the work is carried out cleanly, as the transparent spray primer may turn yellow. If necessary, mask or apply precisely with a brush.



RALMO®-Primer complete 150

Product description:

RALMO®-Primer complete 150 is a universal adhesion primer for the pretreatment of porous substrates and metals. The transparent epoxy resin-based reaction primer can be used as an adhesion promoter for RALMO®-MS Polymer, RALMO®-Butylene, RALMO®-Tape 4000, the RALMO®-Top films, silicones and PU sealants. It has a short flash-off time and is isocyanate-free.

Application:

RALMO®-Top Folien self-adhesive

RALMO®-TAPE 4000 (Butyl)

RALMO®-R3 window plus Multiband

RALMO®-MS Foil adhesive

Fields of application:

- Sealing of glass panes with silicone.
- Grouting of assembly joints during window installation and expansion joints with RALMO®-MS polymer or PU.
- On dry and slightly damp, porous, absorbent building materials and on metals (but not on bitumen).