

DECLARATION OF PERFORMANCE

TWEHA PRIMER #1; Document No.: TWEHA-PRIMER #1-4.0 / 07 September 2026

1. Unique identification code of the product-type:

TWEHA PRIMER #1

2. Type, batch or serial number or any other element allowing identification of the construction product: **The batch and/or production identification is indicated on the product label and/or packaging.**

Product type: Black coating / masking aid for aluminum supporting profiles

Chemical basis: Polyurethane-based, solvent-containing coating

Product identification and batch information are indicated on the product packaging.

3. Intended use of the construction product:

TWEHA Primer #1 is a specially developed adhesion-promoting surface treatment intended for use on specific low-surface-energy coatings or surface finishes on the backside of façade cladding panels where direct bonding with a TWEHA adhesive has been demonstrated to provide insufficient or insufficiently durable adhesion.

TWEHA Primer #1 modifies the bonding surface and promotes adhesion between the approved façade panel substrate and the applicable TWEHA adhesive.

The product shall only be used where specifically prescribed or approved by TWEHA on the basis of substrate assessment and/or adhesion and durability testing.

4. Name, registered trade name or registered trademark and contact address of the manufacturer:

TcB

Lepelstraat 1, bus 02.01 - B-3920 Lommel – Belgium

Chamber of Commerce: 56565860 - RSIN: 852189187

T: +31 88 600 36 00 - E: info@tweha.com - W: www.tweha.com

5. Authorized representative:

Inapplicable.

6. System of assessment and verification of constancy of performance (AVCP):

Inapplicable.

7. Harmonized standard / European Assessment Document / European Technical Assessment:

Inapplicable. No harmonized European product standard or European Technical Assessment applicable to TWEHA Primer #1 as a standalone product is referenced in this declaration.

This document shall therefore not be interpreted as a Declaration of Performance for CE marking under the Construction Products Regulation

8. Product function and limitations:

TWEHA PRIMER #1 is intended to: improve adhesion to specific low-surface-energy coatings or finishes on the backside of façade panels;

- modify the bonding surface where direct adhesive application does not provide the required adhesion;
- create a suitable bonding interface for the applicable TWEHA adhesive;
- form part of a tested and approved TWEHA substrate preparation procedure.

TWEHA Primer #1 is an auxiliary surface-treatment product.

It does not independently transfer permanent structural loads and shall not be considered a structural component of the façade fixing system.

The permanent load transfer between façade panel and supporting structure is provided by the applicable TWEHA adhesive.

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9. Declared product characteristics

Characteristic	Declared performance
Product type	Adhesion promoting primer / surface treatment
Color	Black
Consistency	Thin liquid
Odor	Characteristic
Intended application	Backside of approved facade cladding panels
Primary function	Improvement of adhesion on specific low-surface-energy surfaces
Compatibility	With applicable TWEHA adhesive systems, subject to approval
Application	Thin, continuous and fully covering layer within the bonding area
Structural load-bearing function	None / Not applicable
Permanent load transfer	None
Reaction to fire	NPD
Dangerous substances	Refer to current Safety Data Sheet
Structural load-bearing function	None / Not applicable
Substrate approval	Required before use
Durability	Subject to approved substrate/system combination



Packaging	1 liter can
Shelf life	18 months from production date when correctly stored

10. Conditions of use

The aluminum surface to be treated must be dry and free from dust, oil, grease and other contaminants which could adversely affect adhesion.

The surface shall be prepared and cleaned in accordance with the current TWEHA Instructions for Use, using the prescribed TWEHA cleaning product.

TWEHA PRIMER #1 shall be applied in a thin, uniform layer.

A second application over an already partially dried layer shall be avoided, as this may soften the existing coating and adversely affect its performance.

The treated surface shall be allowed to dry for a minimum of approximately 30 minutes at 20°C before application of the applicable TWEHA adhesive and/or TWEHA Tape.

Application shall always be carried out in accordance with the latest applicable TWEHA Technical Data Sheet and Instructions for Use.

TWEHA Primer #1 shall only be applied to the specific surface for which its use has been prescribed or approved.

Differences in coating composition, manufacturing process, panel type, production batch or surface finish may significantly affect adhesion.

Consequently, approval of one substrate shall not automatically be considered approval of another apparently similar substrate.

11. Limitations TWEHA PRIMER #1:

- is not a structural adhesive;
- is not a structural fixing component;
- shall not be included independently in structural calculations;
- shall only be used on substrates specifically approved by TWEHA;
- shall not be assumed suitable solely because two surfaces appear visually identical;
- does not compensate for contaminated, unstable, weak or unsuitable substrate layers;
- shall not be used as a universal primer;
- shall not be substituted by another primer without written approval from TWEHA.

12. Substrate testing and approval

The performance of an adhesive connection is determined not only by the adhesive itself but also by the mechanical and chemical properties of the surface onto which it is bonded.

Where TWEHA Primer #1 is prescribed, the complete combination of:

façade panel + backside coating/surface + TWEHA Primer #1 + TWEHA adhesive shall be regarded as the relevant tested substrate combination.

Where the panel type, coating, manufacturer, production process or surface condition changes, TWEHA may require renewed adhesion and/or durability testing before approval.

Only substrate combinations tested or otherwise expressly approved by TWEHA shall be regarded as suitable for use.

13. Declaration

The product identified above is manufactured and supplied in conformity with the product characteristics stated in this declaration and the applicable TWEHA technical documentation. When correctly applied to a substrate approved by TWEHA, TWEHA Primer #1 serves as an adhesion-promoting surface treatment between the façade-panel substrate and the applicable TWEHA adhesive.

TWEHA Primer #1 itself has no independent structural load-bearing capacity.

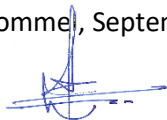
The performance and durability of the complete bonded façade connection depend on, amongst other factors:

- the façade panel and backside surface;
- compatibility of the substrate with TWEHA Primer #1;
- correct surface preparation;
- correct primer application;
- the applicable TWEHA adhesive;
- adhesive bead dimensions;
- environmental conditions during application;
- façade design and supporting structure;
- installation in accordance with the current TWEHA Instructions for Use.

This declaration is issued under the sole responsibility of the organization identified in section 3.

Signed for and on behalf of the manufacturer by:

Lommel, September 7, 2026



M.J.P. van Leeuwen, General Director

Annex to the declaration of performance in accordance with Article 6(5) of Building Regulation and the REACH Regulation No. 1907/2006, Article 31 or 33

- 1 (31) Material safety data Sheet (MSDS): available on www.tweha.com
- 2 (33) information on substances of very high concern (SCHC): inapplicable