

DECLARATION OF PERFORMANCE

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

1. Unique identification code of the product-type:

TWEHA SYNTHETIC PRIMER

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: Solvent-based, synthetic resin adhesion-promoting primer.

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

3. Intended use of the construction product:

TWEHA SyntheticPrimer is an adhesion-promoting surface treatment intended for use on specific synthetic, coated and powder-coated substrates with insufficient or low surface energy, where direct bonding with a TWEHA adhesive has been demonstrated to provide insufficient or insufficiently durable adhesion.

TWEHA SyntheticPrimer creates a uniform and stable intermediate surface onto which the applicable TWEHA adhesive can achieve improved adhesion.

The product shall only be used where specifically prescribed or approved by TWEHA following assessment of the substrate and, where required, adhesion and durability testing.

TWEHA SyntheticPrimer is not a structural adhesive or load-bearing component.

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. No specific AVCP system is declared for TWEHA SyntheticPrimer as a standalone adhesion-promoting surface-treatment product.

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

Inapplicable. No harmonized European product standard or European Technical Assessment applicable to TWEHA SYNTHETIC 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 SyntheticPrimer is intended to:

- **improve adhesion on specific low-surface-energy substrates;**

- provide a uniform and consistent bonding interface;
- improve the surface characteristics of approved synthetic and coated materials;
- provide a suitable substrate for subsequent bonding with the applicable TWEHA adhesive;
- form part of a tested and approved TWEHA surface-preparation procedure.

TWEHA SyntheticPrimer 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 structural connection is provided by the applicable TWEHA adhesive.

9. Declared product characteristics

Characteristic	Declared performance
Product type	Solvent-based adhesion-promoting primer
Color	Black
Binder basis	Synthetic resin combination
Primary function	Improvement of adhesion on approved low-surface-energy substrates
Suitable substrate categories	Selected plastics, coated metals and powder-coated materials
Primary function	Improvement of adhesion on specific low-surface-energy surfaces
Substrate approval	With applicable TWEHA adhesive systems, required before use
Application	Thin, continuous and fully covering layer within the bonding area
Adhesion-promoting function	Suitable for intended use, subject to substrate approval
Structural load-bearing function	None / Not applicable
Permanent load transfer	None
Heat resistance	Up to approx. +100°C
Density	Approx. 1.4 g/cm ³
Theoretical coverage	Approx. 9 m ² /litre, depending on substrate and application
Reaction to fire	NPD
Dangerous substances	Refer to current Safety Data Sheet
Packaging	1 ltr can
Shelf life	18 months from production date when correctly stored

10. Conditions of use

The 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 SyntheticPrimer is particularly intended for substrates such as selected plastics and powder-coated materials with low surface energy.



The suitability of the substrate shall be verified before application.

Visual similarity between coatings or plastics shall not be considered proof of identical surface properties or adhesion performance.

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 SYNTHETIC 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 SYNTHETIC PRIMER:

- **is not a structural adhesive;**
- **is not a structural fixing component;**
- **shall not independently be included in structural calculations;**
- **is not a universal primer for all substrates;**
- **shall only be used on substrate combinations specifically tested or approved by TWEHA;**
- **does not compensate for weak, unstable or poorly adhering underlying coatings;**
- **shall not be applied over contaminated or insufficiently prepared surfaces;**
- **shall not be substituted by another commercial primer without written approval from TWEHA.**

TWEHA SyntheticPrimer shall not be regarded as a general-purpose primer for the backside of façade cladding panels. Surface treatments on façade panels shall only be used when specifically prescribed by TWEHA for the relevant panel and adhesive combination.

Certain plastics, including very low-surface-energy materials such as PE and PP, may not be suitable for treatment with this type of primer and shall therefore always be assessed before use. All-Grund K51 documentation similarly advises testing plastics where suitability is uncertain.

12. Substrate testing and approval

The durability of a bonded connection depends on the complete substrate combination and not solely on the initial adhesion of the adhesive.

**Where TWEHA SyntheticPrimer is required, the complete combination of:
substrate + coating/surface treatment + TWEHA SyntheticPrimer + TWEHA adhesive
shall be regarded as the relevant tested system.**

Changes in:

- **substrate manufacturer;**
- **material formulation;**
- **powder-coating type;**
- **paint or coating system;**
- **colour or pigment;**

- production process;
- surface treatment;
- production batch;

may influence the surface energy and durability of the adhesive connection.

For this reason, TWEHA reserves the right to require renewed adhesion and/or durability testing where the substrate specification changes.

Initial adhesion alone shall not be considered sufficient evidence of long-term suitability.

Only combinations tested or otherwise expressly approved by TWEHA shall be regarded as approved 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 SYNTHETIC serves as an adhesion-promoting surface treatment between the façade-panel substrate and the applicable TWEHA adhesive.

TWEHA SYNTHETIC itself has no independent structural load-bearing capacity.

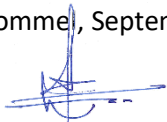
The performance and durability of the complete bonded façade connection depend on, amongst other factors:

- the façade panel and backside surface;
- compatibility of the substrate with TWEHA SYNTHETIC;
- 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:

Lomme, 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