

# Glueing Instruction

## - Useful Tips for the Glued Application -



### Necessary Equipment in Addition to Your Regular Farrier Tools:

- Glue-on Collars (Pro / Easy) or Wolf Busch® Glue-on Tabs  
Pay attention to the correct size and special instructions for the „soft” variant when using Wolf Busch® tabs.
- suitable adhesive (depending on the temperature and behavior of the horse)
- degreasing hoof cleaner and a non-linting cloth
- a permanent marker
- an abrasive block or sanding paper
- hot-air gun with reduction nozzle, e.g. Steinel HL 1920 E
- gloves and appropriate safety equipment
- optional: our welding device for stable welding seams.

### The Right Combination of Horseshoe and Glue-On Product

Our recommendation is the Nailless horseshoe, which has been designed for the glued application. Depending on the hoof situation and the horse's usage, you may need a different model. In general, all glue-on tabs / collars can be combined with (almost) all of our horseshoes. Depending on your combination of horseshoe (Standard / Extra / Regranulate) and glue-on collar (Standard / Extra) or Wolf Busch® tabs (regular / soft / Edition), you may need to adjust the rolling speed, apply slightly more or less pressure during welding, and sometimes adjust the temperature of the heat gun.



### Our Tip: The Right Glue-On Product for Your Horseshoe - A General Recommendation

Horseshoes	Glue-On Collars Easy / Pro	Wolf Busch® Glue-On Tabs
Round / Oval Shape	well-suited	well-suited  Please note that the size of the tabs depends on the size of the horseshoe.
Straight Toe / Open Toe	You will have to divide the collar.	
Pony Sizes	Only after the appropriate modification.	Cut off the largest tab and place it in front of the clips, position the other tabs behind them.
Clipped Horseshoes	Split the collar into several pieces and place them accordingly in front of and behind the clips.	



### (1) Preparations

- The **preparation of the bare hoof** is the same as before any other shoeing and has to be done professionally.
- Choose a horseshoe that matches hoof (size and shape), temperature (Standard or Extra) and the intended use of the horse (model).
- Adapt the **horseshoe** to the hoof and leave a protrusion of 1mm where the glue-on tabs / collars will be placed.
- Remove all **knobs**, also the softer knobs of the Nailless or Classic.

### (2) Plastic Welding Process

- Mark the correct position of the tabs on the horseshoe. In case of the Wolf Busch® tabs, the smallest tab points towards the heels and the smooth side towards the hoof wall.
- Slightly preheat the initial welding area until the synthetic material starts glistening.
- Position the horseshoe at 90 degrees to the glue-on tabs. Make sure that the tabs don't reach the profiled area of the horseshoe and that they don't exceed the bottom edge of the horseshoe.
- Slowly but constantly roll the horseshoe over the glue-on tab/collar.
- Deliberately mark the starting and terminal point by a bit more pressure.
- There should be a small glassy ridge visible along the complete welded edge.
- Be careful to correctly adjust the temperature of the hot-air gun: 550°C (1022°F) to max. 630°C (1166°F)
- When using Wolf Busch® tabs make sure that no heat must radiates towards the elastic inner layer of the tab.



### Tips for Solid Welding Seams

- Use our **Welding Device** for stable and uniform welding seams.
- **Tear test:** Once the horseshoe has cooled, pull on the tabs with all your strength.
- Here you can find our **video application guide:** <https://youtu.be/kgYvDIKU1Fk>



### (3) Checking the Fit

- Slide the horseshoe on the hoof from the toe towards the heels. If necessary, you can strut the tabs a little bit apart.
- The front edge of the horseshoe should not be visible any more if looked at from above. If looked at from underneath, the toe should be minimally visible or just out of sight.
- The horseshoe should now be fixated enough to be finely adjusted.

### (4) Further Adjusting the Horseshoe

- Round the welded edges off towards the bottom side of the horseshoe.
- Add a bevel on the hoof side of the horseshoe just behind the glue-on tabs in order to reduce the risk of forging.
- If necessary, you can grind a toe rocker that facilitates breakover.
- Attention: You may also need to adjust the height of the tabs to fit the hoof.

### (5) Final Preparations

- Roughen the hoof wall with an abrasive block (grain size 80-120).
- We recommend to degrease the roughened hoof wall with Megafoam and letting the foam react for about 30 seconds. Afterwards, wipe everything thoroughly off and wait until the hoof is completely dry before glueing. Alternatively, you can use isopropanol of 99%. We advise against using brake cleaner.



### Recommendations for Glueing

- Take notice of the final strength of the glue (about 24h).
- High air humidity (rain, fog) usually doesn't compromise the glueing process.
- When choosing the glue, pay attention to the temperature, and be aware that the glue absorbs humidity if left open for too long. It begins to cure, and its bonding reliability may decrease.
- Detailed information about each product can be found online.



### (6) Glueing and Sealing

- Wear gloves and respect the safety information for the glue you use.
- Make another person lift the horse's opposing hoof so the horse will keep still.
- Glue each tab individually: Strut the tab apart from the hoof wall and apply glue around the edge. Add a cross and four dots. When glueing, the principle „less is more” applies. Be careful not to use too much glue.
- Evenly apply pressure to the tab with two fingers, starting from the bottom, for about 10-15 seconds.
- Seal the top edge of the glue-on tabs with some glue.

### (7) Remove a Glued Horseshoe

- You can separate the tabs from the hoof wall using the hoof knife.
- Another option is to carefully pull the tabs off the hoof using pliers.
- The choice of the right method depends, among other factors, on the condition of the hoof.


Please pay attention to the safety instructions applicable to our products. For further details regarding the application and potential re-use of your glued horseshoe, you can find detailed information online. If you have questions or face individual challenges, our Customer Service Team is ready to assist you!

### Duplo Composite Horseshoes

H. Frank Kunststofftechnik GmbH  
Vorderfreundorfer Straße 20  
94143 Grainet, Germany

Phone: +49 (0) 8585/96926-0  
Fax: +49 (0) 8585/96926-119

 duplo\_composite\_horseshoes

 Duplo Composite Horseshoes

 info@duplo-frank.de

 www.duplo-frank.de

