



## PVC TrimWelder™ Laminating Grade

PVC TrimWelder™ Laminating Grade is a low viscosity, solvent-free structural adhesive system designed for laminating unmilled PVC sheets and boards. Its lower viscosity provides greater flow-out with less clamping pressure to insure a thin, void free bond. Cured performance shows excellent adhesion and bond strength in excess of the PVC. This material can withstand thermal cycling and shock loading between dissimilar materials. PVC TrimWelder™ Laminating Grade is ready to handle in 45 minutes and may be cut and machined in 1 hour.

PVC TrimWelder™ Laminating Grade adhesive does not require special surface preparation. Do not remove the skin of the cellular PVC. Our Laminating Grade system is so strong that it appears to weld the PVC together. This adhesive has a creamy consistency that will not foam, run or drip. See page 2 for application instructions.

PVC TrimWelder™ Laminating Grade is a moderate cure speed, two-component product with an open time of 15 minutes at 70°F after thorough mixing with approved mix tips.

<b>Technology / Base</b>	Two-component Methylmethacrylate (MMA)
<b>Type of Product</b>	MMA
<b>Curing Mechanism</b>	Polymerization
<b>Appearance / Color</b>	White
<b>Consistency</b>	Liquid

### Features and Benefits

- Permanent unitizing structural adhesive
- Great impact resistance and peel strength
- Excellent adhesion to PVC, plastics and metals
- Matches white PVC trim boards
- Paintable
- Moderate cure speed, easy to apply and solvent free
- Able to achieve thin bonds
- Meets 2009 EPA VOC & CARB requirements

### Technical Data

Property	Typical Uncured Values (Liquid)	
Viscosity	30,000 cp	mixed at 25°C
Specific Gravity	1.01	(20 / 20°C)
Flashpoint	51°F	(COC method)
Toxicity	Moderate	see SDS
Solvents	None	
Mix Ratio	1 : 1	
Fillers	Yes	
Clean Up Solvents	Alcohol, MEK, Acetone	

Applies to both adhesive and activator sides



**Technical Data (Continued)**

Property	Typical Cured Values (Solid)	
Shore D Hardness	75	
Adhesive testing on plastics, PVC, ABS glass filled nylon, styrene	Substrate failure	
Thermal Service Range	-65°F to 260°F	
Chemical Resistance	Excellent	
Elongation	30%	
Impact Resistance	20 ftlbs/in <sup>2</sup>	on steel
Peel Strength	20 to 25 psi	on aluminum
Lap Shear Strength	3,390 psi	aluminum

Typical Film Thickness 0.010" to 0.030"

**Typical Applications**

Combine resin and activator in equal volume and mix thoroughly. For convenience and accuracy use pre-measured 220ml and 400 ml cartridges with disposable static mixers. Open time is 10 - 15 minutes at room temperature. Handling strength within approximately 45 - 60 minutes.

**Typical Packaging**

Typically sold in 220, 400 and 1500 mL cartridges.

**Application Instructions**

Our PVC TrimWelder™ Laminating Grade is designed to work on the skin of the sheet. Removing the skin produces erratic results and uses more adhesive to fill in the cells, yet still produces a lesser bond.

We recommend you apply the adhesive to a clean (dust free) part. A 7/8" diameter bead will yield enough adhesive to cover a 60" width at a 0.010" bond line. A single 400 ml cartridge will cover 22" of length.

It is recommended that the bead be applied to the center of the part (lengthwise) and only troweled slightly to provide a "stripe" 10 - 15 times the bead diameter. Do not brush or roll the adhesive. The adhesive should be slightly higher in the center of the stripe to ensure that no air is captured by placement of the top sheet.

In addition, a 3" diameter spot of adhesive should be placed in each corner of the part inboard from the ends and sides by about 1/5<sup>th</sup> the width of the sheet. On a 40 sq ft lamination, apply 1 - 2 psi of clamping pressure. Leave the clamp or weight in place for approximately 30 minutes and remove. Wait an extra 30 minutes before cutting. Use our sandable PVC TrimWelder™ Fast Cure to seal the ends and hide the cells.

Consult your sales representative for more information.

**Storage Conditions**

Shelf Life is 9 months when properly stored in an unopened original container in a cool, dark area between 55°F to 75°F.

**Safety and Disposal**

Please refer to the SDS for safety advice and disposal instructions.

To minimize the risk of skin contact, we recommend the use of eye protection, gloves and protective clothing when working with this material. Prevent the build-up of vapors. Extinguish all sources of ignition during use.

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