

PVC TrimWelder™ Slow Cure

PVC TrimWelder[™] Slow Cure is a medium viscosity, solvent-free structural adhesive system that provides flexibility, toughness and surface adhesion for bonding all forms of PVC to itself, metals or wood. Cured performance shows excellent adhesion and bond strength to nylons, polystyrenes, fiberglass, reinforced plastics, stone, ceramics and most plain and plated metal components. This material can withstand thermal cycling and shock loading between dissimilar materials. Slow Cure is ready to handle in 90 - 120 minutes.

PVC TrimWelder[™] Slow Cure adhesive does not require special surface preparation and does not contain any solvents. It will work successfully in most applications without preparation. Our slow cure 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.

PVC TrimWelder[™] Slow Cure is a fast curing, two-component product with an open time of 20 - 25 minutes at 73°F after thorough mixing with approved mix tips. It will cure satisfactorily at application temperatures as low as 40°F.

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

Features and Benefits

- Excellent adhesion to plastics and metals
- Great impact resistance and peel strength
- Matches white PVC trim boards
- Paintable, sandable and UV resistant
- Longer open time for larger applications
- Easy to apply and solvent free
- Fills nail holes and gaps up to 3/8"
- Meets 2009 EPA VOC & CARB requirements

Technical Data

Property	Typical Uncured Values (Liquid)		
Viscosity	50,000 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	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,	Substrate failure	
ABS glass filled nylon, styrene		
Thermal Service Range	-65°F to 260°F	
Chemical Resistance	Excellent	
Elongation	60%	
Impact Resistance	20 ftlbs/in ²	on steel
Peel Strength	20 to 25 psi	on aluminum
Lap Shear Strength	3,390 psi	aluminum
	3,365 psi	grit blasted steel

Typical Film Thickness 0.030"

Typical Applications

Combine resin and activator in equal volume and mix thoroughly. For convenience and accuracy use premeasured cartridges with disposable static mixers. Open time is 20 - 25 minutes at room temperature. Handling strength within approximately 90 - 120 minutes.

Typical Packaging

Side-by-side cartridges.

Application Instructions

Consult the packaging instructions on proper preparation, application and clean up.

Storage Conditions

Shelf Life is 12 months when properly stored in an unopened original container in a cool, dark area between 55°F to 75°F.

Safety and Disposal

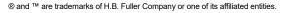
Please refer to the SDS for safety advice and disposal instructions.

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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