



PVC
TRIMWELDER™

GET IT TOGETHER™

THE LAMINATOR™ *LAMINATING GRADE Adhesive for PVC TRIM™*

Product Description **Part Numbers: EXT-LG-220ML & EXT-LG-400ML & EXT-LG-1500ML**

EXTREME Adhesives™ PVC TrimWelder LAMINATOR Adhesive 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 LAMINATOR Adhesive is ready to handle in 45 minutes and may be cut and machined in 1 Hour**

EXTREME Adhesives™ PVC TrimWelder LAMINATOR Adhesive does not require special surface preparation. **Do Not** remove the skin of the cellular PVC. Our Laminating Grade System is so strong, it appears to weld the PVC together. The creamy consistency won't foam and spreads easily. See page 2 for complete instructions.

EXTREME Adhesives™ PVC TrimWelder LAMINATOR Adhesive is a moderate cure speed two-component product with an open time of 15 minutes at 70° F after thorough mixing. Packaged in convenient, easy to use 220, 400, and 1500 ml cartridges.

Why Should You Select This Adhesive?

- **Permanent Unitizing Structural Adhesive** **Excellent Adhesion to Plastics And Metals**
- **Impact Resistance - Peel Strength** **Matches white PVC Trim Boards**
- **Paintable** **Moderate Cure Speed – Thin Bonds**
- **Easy to Apply** **The Best Way to Laminate PVC Trimboard**

Typical Uncured Properties (LIQUID)
Applies to both adhesive and activator sides

Typical Cured Properties (SOLID)
Typical film thickness 0.010" to .030".

Viscosity	30,000cps mixed
Specific Gravity	1.01 (20/20C°)
Color	White
Flashpoint	51°F (COC method)
Toxicity	Moderate, see MSDS
Solvents	None
Mix Ratio	1 : 1
Fillers	Yes
Clean Up Solvents	Alcohol, MEK, Acetone

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 ² on Steel
Peel Strength	20-25 psi on Aluminum
Lap Shear Strength	3390 psi – aluminum

Instructions For Use

Combine resin and activator in equal volume and mix thoroughly. For convenience and accuracy use pre-measured 220ml & 400 ml cartridges with disposable static mixers. Open time is 14 to 18 minutes at room temperature. Handling strength within approximately 45 to 60 minutes.

Shelf Life

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

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How to use **EXTREME PVC TrimWeldertm LAMINATOR.**

Our **PVC TrimWeldertm LAMINATOR** 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 inch width at a .010 bond line. A single 400 ml cartridge will cover 22" of length. Therefore to cover a 10' by 4' lamination, approximately five 400 ml cartridges would be required.

This assumes enough clamping pressure to achieve the desired .010" bond line. On a 40 sq ft lamination, 1 to 2 psi should work well. That is a very considerable force since there are 144 sq in in each sq ft. That means about 3000 to 6000 lbs distributed over the entire sheet.

Although the **PVC TrimWeldertm LAMINATOR** is designed to flow easily under pressure, it is recommend that the bead be applied to the center of the part (Long Way) and only troweled slightly to provide a "stripe" 10 to 15 times the bead diameter. Do **not** brush or roll the adhesive as this exposes too much of the adhesive to air and the chemistry of the adhesive will change due to evaporation. For example, a 7/8" bead should be spread fairly evenly to about a 14" width.

The adhesive should be slightly higher in the center of the stripe to insure that no air is going to be 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 1/5th the width of the sheet (about 12" in this example). This will accomplish two objectives. First it makes sure the corners are not starved for adhesive and secondly, the 4 puddles of adhesive act as a slowly decreasing thickness shim to keep the top sheet parallel to the bottom. They also provide a temporary gap for air to exit the bond as the top sheet is pressed into place.

Leave the clamp or weight in place for 30 minutes or so and remove. Wait an extra 30 minutes before cutting. Use our sandable **PVC TrimWeldertm Fast Cure** to seal the ends and hide the cells

This is a starting point for successful laminations using **PVC TrimWeldertm LAMINATOR.**

Experiment with adhesive volume to fit your available clamping pressure or weight.

PVC TrimWeldertm LAMINATOR. Works best when temperatures are above 40 F. For application between 32 F and 45 F make sure the adhesive is warmed to **70 F WHEN IT'S APPLIED!**

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