



Properties of PVC TrimWelder Products

PVC TRIMWELDER Fast Cure

Mixed (Fluid) Properties

Mix Ratio A:B	1 to 1
Viscosity	200,000 centipoise
Thixotropy Ratio (Static to Flow)	5:1
Specific Gravity	1.01 @ 20C
Color	White
Odor	Self Limiting Acrylate
Flash Point	51°F COC method per ASTM
Toxicity	Moderate
Work Life	5-8 Minutes

Cured Properties

Functional Cure	20 – 30 Minutes
90% Cure	90 Minutes
Full Cure	24 Hours
Hardness	75 Shore D
Elongation	40%
Impact Strength	20 ft/lbs on steel coupons
Peel Strength	20 – 25 pli on aluminum
Tensile Strength on:	

Cellular PVC	Substrate Failure
Solid PVC	Substrate Failure
FiberGlass	Substrate Failure
ABS	Substrate Failure

Tensile Shear Strength on:

Aluminum	3400 psi (ASTM D1002)
As Rec-d CRS	2230 psi (ASTM D1002)
	<u>No Primer Required</u>

Solvent Resistance

Strength Retention in:	
Water at 100°F/100hrs	92%
Mineral Oil 100°F/100 hrs	94%

Environmental Properties Post Cure

VOC's	< 2 gms/kg
CARB Compliant	Yes
Fillers for improved working properties	Yes
Color Stability	Very Good
Service Temperature	-50F to 250F
Gap Filling Capability	< 3/16"

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Formerly Adhesive Engineering & Supply, Inc.

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<http://www.pvctrimwelder.com> <http://www.extremeadhesives.com/>



PVCTRIMWELDER Slow Cure

Mixed (Fluid) Properties

Mix Ratio A:B	1 to 1
Viscosity	250,000 centipoise
Thixotropy Ratio (Static to Flow)	6:1
Specific Gravity	1.01 @ 20C
Color	White
Odor	Self Limiting Acrylate
Flash Point	51°F COC method per ASTM
Toxicity	Moderate
Work Life	18 -23 Minutes

Cured Properties

Functional Cure	90 – 120 Minutes
90% Cure	240 Minutes
Full Cure	24 Hours
Hardness	75 Shore D
Elongation	40%
Impact Strength	20 ft/lbs on steel coupons
Peel Strength	20 – 25 pli on aluminum

Tensile Strength on:

Cellular PVC	Substrate Failure
Solid PVC	Substrate Failure
FiberGlass	Substrate Failure
ABS	Substrate Failure

Tensile Shear Strength on:

Aluminum	3390 psi (ASTM D1002)
As Rec-d CRS	2340 psi (ASTM D1002)
	No Primer Required

Solvent Resistance

Excellent

Strength Retention in:

Water at 100°F/100hrs	91%
Mineral Oil 100°F/100 hrs	96%

Environmental Properties Post Cure

VOC's	< 2 gms/kg
CARB Compliant	Yes
Fillers for improved working properties	Yes
Color Stability	Very Good
Service Temperature	-50F to 250F
Gap Filling Capability	1/2"

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PVC TRIMWELDER Laminating Grade

Mixed (Fluid) Properties

Mix Ratio A:B	1 to 1
Viscosity	27,000 centipoise
Thixotropy Ratio (Static to Flow)	2:1
Specific Gravity	1.01 @ 20C
Color	White
Odor	Self Limiting Acrylate
Flash Point	51°F COC method per ASTM
Toxicity	Moderate
Work Life	18 - 20 Minutes

Cured Properties

Functional Cure	45 - 60 Minutes
90% Cure	170 Minutes
Full Cure	24 Hours
Hardness	75 Shore D
Elongation	60%
Impact Strength	20 ft/lbs on steel coupons
Peel Strength	20 – 25 pli on aluminum
Tensile Strength on:	
Cellular PVC	Substrate Failure
Solid PVC	Substrate Failure
FiberGlass	Substrate Failure
ABS	Substrate Failure
Tensile Shear Strength on:	
Aluminum	3390 psi (ASTM D1002)
As Rec-d CRS	2340 psi (ASTM D1002)
	No Primer Required

Solvent Resistance

Excellent

Strength Retention in:

Water at 100°F/100hrs	97%
Mineral Oil 100°F/100 hrs	94%

Environmental Properties Post Cure

VOC's	< 2 gms/kg
CARB Compliant	Yes
Fillers for improved working workability	Yes
Color Stability	Very Good
Service Temperature	-50F to 250F
Gap Filling Capability	< 1/16"

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Notes:

The three primary PVC TRIMWELDER products share many cured and uncured properties. The primary functional differences are viscosity and cure speed. This allows the user to utilize the best performing product for their needs.

The Thixotropic Ratio reflects the difference in viscosity between flowing adhesive (as when being mixed and dispensed) and the viscosity when at rest. This property is unique to PVCTRIMWELDER and is what allows the products to flow through the mixer easily with little resistance and still stay within a joint or cling to a vertical surface without sag. The recovery of the full “at rest” viscosity takes only several seconds after dispensing.

The exceptionally low Thixotropy Ratio on the Laminating Grade allows large laminations to be processed with minimal clamping force. This works well for jobsite laminating. The flow characteristics allow completely bubble and void free laminations eliminating the need for post fill and finish operations when cutting or milling the lamination. It is recommended that Laminating grade be applied in the proper amount **only** in the center of the parts being glued. Do not spread, brush, or roll out the adhesive to cover the surface. Use pressure on the top part to flow out the adhesive. This will result in the strongest laminations with no voids.

Solvent resistance of PVC TRIMWELDER is many times greater than PVC since, upon curing, PVCTRIMWELDER becomes a cross linked thermosetting plastic.

Work Life is defined as the time which the user has to align and position the parts. They should remain in that position until functional strength is achieved. Although full cure requires 24 hours on all products, it is a laboratory definition and really accomplishes only the last 5% of the cure. Functional cure is the time point when parts may be unclamped and handled.

Note: PVC TrimWelder Fast Cure provides faster and stronger “core to core” or “end cut” bonds than does Slow Cure and actually reinforces the joint.

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Extreme Adhesives, Inc

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