



Trim Bonder™

Description: A 100% reactive, toughened structural acrylic adhesive formulated for bonding PVC trimboard, wood, urethane, metals, aluminum, fiberglass, masonry, rigid plastics, and all other synthetic wood products. TrimBonder™ in the 250ml uTAH cartridge is sold exclusively through AZEK™ Trimboard distributors.

Intended Use: Used to fill nail holes, fill gaps and joints, laminate PVC trimboard, bond aluminum cleats to PVC window/door trim moldings, and fill voids in all other synthetic wood products.

Product features:
White color matches pvc trimboards
Non-sagging formula
Laminates trimboard
Fill Gaps and joints in trimboard
Sandable formula

Limitations: None

Typical Physical Properties: *Technical data should be considered representative or typical only and should not be used for specification purposes.*

Cured 7 days @ 75° F

Adhesive Tensile Shear [AL/AL]	2,354 psi
Adhesive Tensile Shear [CPVC]	586 psi [substrate failure]
Adhesive Tensile Shear [PVC]	1,300 psi [substrate failure]
Coverage per Cartridge	1,243 in. @ 1/8" bead
Gap Fill	0.50 in.
Impact Resistance	20 ft.lb./in2.
Shelf Life [250ml uTAH cart]	9 months
Shore Hardness	75 Shore D
Solids by Volume	100
Tensile Elongation	5-15%
Tpeel	15-20 pli

TESTS CONDUCTED

Impact Resistance ASTM D 950
T-Peel Strength ASTM D 1876
Cured Hardness Shore D ASTM D 2240
Adhesive Tensile Shear ASTM D 1002

Uncured

Color	White
Coverage/lb	620 linear inches @1/4" bead
Fixture Time	18-20min. @ 72°F
Flashpoint	51 °F
Full Cure	24 hrs.
Functional Cure	2-4 hrs.
Mix Ratio by Volume	1:1
Mixed Density	8.8 lbs./gal.
Mixed Viscosity	30,000 cps
Service Temperature	-40° to 160 °F
Viscosity	Adhesive: 18,000 cps; Activator: 45,000 cps
Weight	Adhesive 9.5 lbs./gal.; Activator: 8.10 lbs./gal.
Working Time	5-8 min. @ 72 °F

Surface Preparation: Clean surface by solvent-wiping any deposits of heavy grease, oil, dirt, or other contaminants. Surface can also be cleaned with industrial cleaning equipment such as vapor phase degreasers or hot aqueous baths. If working with metal, abrade or roughen the surface to significantly increase the microscopic bond area and optimize the bond strength.

Mixing Instructions: ---- Proper homogenous mixing of resin and hardener is essential for the curing and development of stated strengths. ----

- 25 ML DEV-TUBE
1. Squeeze material into a small container the size of an ashtray.
 2. Using mixing stick included on Dev-tube handle, vigorously mix components for one (1) minute.
 3. Immediately apply to substrate.

35ML/50 ML/250 ML/380 ML/400 ML CARTRIDGES

1. Attach cartridge to Mark V™ [50ml], 380ml, 250ml [15:1 caulk gun], or 400ml dispensing systems [manual or pneumatic].
2. Open tip.
3. Burp cartridge by squeezing out some material until both sides are uniform (ensures no air bubbles are present during mixing).
4. Attach mix nozzle to end of cartridge.
5. Apply to substrate.

Application Instructions:

PROPER USE OF THE UNIVERSAL CARTRIDGE

1. Unscrew retaining nut from the 250ml universal cartridge and keep nearby.
2. Remove nose plug from cartridge and set aside.
3. Load 250ml cartridge into caulking gun. [The Z-Pro #349 [15:1] or Albion B-26 [26:1] manual guns are recommended for best application technique.
4. For non manual dispensing battery operated units are recommended. Pneumatic dispensing guns are not recommended unless they have a piston drive system like the Cox #61004 LP unit.
5. Dispense a slight amount of TrimBonder™ until both sides are flowing evenly and discard.
6. Attach the mix nozzle [#74601] to the cartridge, and take the retaining nut and tighten down until firm.
7. Apply mixed product directly to one surface in an even film or as a bead.
8. Assemble with mating part within recommended working time.
9. Squeeze trimboards together to ensure adhesive fills both surfaces you intend to bond (a small fillet of product should flow out the edges to display adequate gap fill).
10. Adhesive will fill gaps as small as 1/64 inch and as thick as 1/2 inch with one application.

APPLICATION TECHNIQUES

FILLING LARGE GAPS:

1. If gap to be filled is larger than 1/2 inch, apply first coat, let fixture set for approximately 20 minutes, then apply second coat to build up gaps.
2. Let bonded assemblies stand for recommended functional cure time prior to handling.

SURFACE PREPARATION:

- TrimBonder™ is tolerant to some surface contaminants. Typical wiping of the surface with a clean dry rag to remove dust and dirt is recommended.
- For best results, surface contamination, loose paint, dirt, and grease should be removed before applying TrimBonder™.

ALUMINUM APPLICATIONS:

- Take a dry rag and wipe the aluminum clean from dust, dirt, and grease.
- Apply TrimBonder™ to the aluminum surface then attach your PVC trimboard. Clamp if tight joint is needed.

WORKING TIME:

- If material is stored at temperatures above 72°F the working time will decrease. The following chart will help to calculate your working time:

Temperature	Working Time	Fixture Time
50°F	10-14 minutes	45-55 minutes
72°F	5-8 minutes	20-25 minutes
100°F	2-4 minutes	15-18 minutes

SHELF LIFE AND STORAGE

- Material will not cure under 50°F. TrimBonder™ and the substrate must stay above 50°F during the cure cycle to achieve the physical properties stated above.
- Storing TrimBonder™ over 98°F for any extended time will cause material to thicken with age, and will impact cure speed of the material [see above chart].
- Shelf life is nine months if stored at 72°F.

Storage:

To store opened or partially used cartridges, remove nozzle, clean excess adhesive, re-install nose plug. Shelf Life is based on storage between 55°F and 75°F. Prolonged exposure/storage above 90°F reduces product reactivity and stability. Shelf life can be extended when stored between 45-55°F. DO NOT FREEZE.

Compliances:

Approved for use for filling nail holes, gaps and joints with AZEK™ Trimboards.

Chemical Resistance:

Chemical resistance is calculated with a 7 day, room temp. cure (30 days immersion) @ 75°F

Ammonia	Fair
Cutting Oil	Excellent
Glycols/Antifreeze	Excellent
Hydrochloric 10%	Very good
Motor Oil	Excellent
Sodium Hydroxide 10%	Excellent

Precautions:

Please refer to the appropriate material safety data sheet (MSDS) prior to using this product.

For technical assistance, please call 1-800-933-8266

FOR INDUSTRIAL USE ONLY

Warranty: Devcon will replace any material found to be defective. Because the storage, handling and application of this material is beyond our control, we can accept no liability for the results obtained.

Disclaimer: All information on this data sheet is based on laboratory testing and is not intended for design purposes. ITW Devcon makes no representations or warranties of any kind concerning this data.

Order Information: **74201 250 ml cartridge**
 74601 250 ml nozzle