



TrimBonder™ HB Bonding System

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.

Intended Use: Used to fill cut edges of "free foam" or Celuka CPVC board to a smooth finish like the CVPC boards skin. Able to build edge in "one coat", and sand within 25 minutes.

Product features:
Fills Joints
Sandable "one coat" formula
Fills voids to 3/8" thick
Low exotherm
Sandable high build formula

Limitations:

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 Lap Shear[Al/Al]	2,559 psi
Adhesive Tensile Lap Shear[CPVC]	525 psi [substrate failure]
Coverage per Cartridge	1,243 in. @ 1/8" bead
Cured Density	8.2 lbs. / gal
Gap Fill	0.375
Impact Resistance	13.3 in-lb/in2
Minimum Time to Sand - 2nd coat	15-18 minutes
Shelf Lfie	1 year
Shore Hardness	75 Shore D
Solids by Volume	100%
Tpeel	26.7

TESTS CONDUCTED

Adhesive Tensile Shear ASTM D 1002
Cured Density ASTM D 792
Cured Hardness Shore D ASTM D 2240

Uncured

Color	White
Fixture Time	20-25 minutes
Flashpoint	51 °F
Full Cure	24 hours
Functional Cure	2 hours @ 72 °F
Mix Ratio by Volume	1:1
Mixed Density	8.2 lbs./gal
Mixed Viscosity	45,000 cps
Service Temperature	-40 F to 160 °F
Tack Free Time	15-20 min. @ 72 °F
Viscosity	Adhesive: 18,000 cps; Activator: 55,000 cps.
Weight	Adhesive 9.5 lbs/gal;Acitvator 6.93 lbs.gal
Working Time	3-5 minutes

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:

1. Unscrew retaining nut top of cartridge. Remove nose plug.
2. Insert TrimBonder™ HB adhesive cartridge in gun. *(See selection guide)
3. Dispense until both part A (white) and part B (tan) flow freely
4. Screw mix nozzle on cartridge. Tip can be trimmed to increase flow of mixed adhesive.
5. Dispense TrimBonder™ HB adhesive through mix nozzle. Be certain mixed Trim Bonder adhesive flows streak-free and white before applying to work surface.
 - If material flow slows or stops, replace the mix nozzle.
 - If the cartridge is not used for 8 minutes (at 72° F), replace the nozzle.
 - If the flow of TrimBonder HB adhesive is continuous, the nozzle can last for extended periods of time.
 - Working times and cure times are affected by the temperature of the adhesive.
 - Adhesive temperatures below 72° F extend the work, tack-free and functional cure time.
 - Adhesive temperatures above 72° F shorten the work, tack-free and functional cure time.

APPLICATIONS

- Bonding - TrimBonder™ HB adhesive is designed to bond PVC board. Wood, fiberglass, vinyl, aluminum, stainless steel, masonry and other surfaces can also be bonded. (Do not apply too much pressure when clamping)
- Gap Filling - TrimBonder™ HB adhesive is designed to fill gaps. A gap larger than 3/8" can be built up with multiple applications.
- Nail Holes - Over fill nail hole. After 20 minutes (72° F) sand or shave flush with surface. (Stanley® SurForm® Pocket Plane tool can be used)
- Painting - TrimBonder™ HB can be painted with latex, acrylic or enamel paints.

Technical Service is available at www.trimbonder.com

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:

None

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:

74801 400 ml cartridge