

# Channel Bond Polycarbonate Adhesive

## Proprietary Product

### Application Instructions for Channel Bond™ Quick Setting High Strength Adhesive

#### General:

- Channel Bond is a One-Part Adhesive System. Use a #49 Hypo Applicator (pink tip) bottle to apply.
- Store in the original container when not in use. Keep lid tight. Store where the temperature is between 32°F to 80°F.
- Read the health and safety information on the container before using.
- Be sure surfaces to be bonded are clean and smooth.
- The shelf life of this product when stored properly is 2- 12 months.
- Try a small test on extra/scrap material before going into production.

#### How to apply on the following materials:

##### Sign Trim (Cellulose Acetate Butyrate) to Polycarbonate

1. Fix Sign Trim around polycarbonate per your normal retention fixture method. Apply a uniform bead between the Sign Trim and polycarbonate by flexing the Sign Trim to allow Channel Bond to flow down in-between materials. Bond should be strong after 10-15 minutes.
2. Apply a second uniform bead around the edge between the Sign Trim and polycarbonate material.
3. After 5-10 minutes remove material from the retention fixture and add a third thin uniform bead around the front between the Sign Trim arrow profile and polycarbonate face (provided that there is no vinyl applied on the first surface.)

##### Polycarbonate to Polycarbonate

Apply a uniform bead to the bonding area. Hold parts together securely while adhesive sets up. Bond should be strong after 15-60 minutes depending on the shape and size (area) to be bonded. Maximum strength after four hours.

##### Acrylic to Polycarbonate

Apply a uniform bead to the bonding area. Hold parts together securely while adhesive sets up. Bond should be strong after 60 minutes depending on the shape and size (area) to be bonded.

##### Sign Trim (Cellulose Acetate Butyrate) to Acrylic

1. Fix Sign Trim around acrylic per your normal retention fixture method. Apply a uniform bead of Resin Bond between the Sign Trim and acrylic.
2. Apply a second uniform bead with Channel Bond around the edge between the Sign Trim and acrylic material. After 5-10 minutes remove material from the retention fixture.
3. Add a third thin uniform bead around the front between the Sign Trim narrow profile and the acrylic face when the material (width) exceeds 3 feet.

For Modified Acrylic (DR) to Polycarbonate see Acrylic to Polycarbonate

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