

TECHNICAL DATA SHEET

<div><div>bonding people fixing problems</div><div>INNOVA</div><div>solutions</div></div>	TDS No:	029	Issue No:	2
	Issue Date:		27/07/16	
	Revision Date:		28/07/17	
	Page No:		1 of 3	
PRODUCT		NovaWeld SignFix 12		

NovaWeld SignFix 12 is a high strength two component structural acrylic adhesive, designed to bond a variety of substrates that require a totally clear, high viscosity adhesive.

This ultra-high strength is achieved by using a bespoke blend of advanced acrylic polymers which, when combined with a non-phthalate and non-MCL cure system, provide a fast bond speed with ultra-high clarity.

Protect against the elements, and protects the look of the finished product. **NovaWeld SignFix 12** is the clear structural adhesive that delivers uncompromising bond strength without the visible bond lines.

Applications

- High impact, high strength bonding of most signmaking materials including metals, plastics and composites.
- Especially suited to clear acrylics where you need a virtually invisible bond to enhance the visual appeal of your sign.

Features & Benefits

The traditional method of hand-mixing some alternative two- component clear systems, adds considerable time to the assembly process, as the mixed material is often left for any induced air to rise to the surface, and leave the mixture. **NovaWeld SignFix 12** eliminates this waste of production time, as no air is induced during mixing, due to the bespoke cartridge and mixer nozzle system, which also ensures that the user will attain a bubble-free bondline. In almost every conceivable way, **NovaWeld SignFix 12** takes the traditional two-part structural adhesive and improves on it with:

- Greater shear, peel and tensile strength for stronger performance under stress
- Impact resistance
- Long lasting bonds
- Clear formulation for a sharper finish

Please note: If you intend to bond different materials for exterior use (e.g. rimless letters) ensure you choose an adhesive that will compensate for differential expansion. Please call for advice.

Disclaimer

This information relates only to the specific material designated and may not be valid for such material used in combination with any other materials or in any process. Such information is, to the best of the company's knowledge and belief, accurate and reliable as of the date indicated. However, no warranty guarantee or representation is made to its accuracy, reliability or completeness. It is the user's responsibility to satisfy himself as to the suitability of such information for his own particular use.

TECHNICAL DATA SHEET

<div><div>bonding people fixing problems</div><div>INNOVA</div><div>solutions</div></div>	TDS No:	029	Issue No:	2
	Issue Date:		27/07/16	
	Revision Date:		28/07/17	
	Page No:		2 of 3	
PRODUCT		NovaWeld SignFix 12		

How to apply NovaWeld SignFix 12 clear structural adhesive

1. Consult the SignFix material safety data sheet (MSDS) before using for the first time.
2. Carry out surface preparation where required.
3. Remove cap. Repeatedly press the gun trigger until both parts are dispensing **before** attaching mixer nozzle. This ensures you mix equal amounts of adhesive and activator.
4. Apply the mixed adhesive to one surface. Assemble components carefully and clamp if required. Take care not to over-tighten – you need to leave some adhesive between the joint.
5. Remove any excess adhesive at this point, before the structural glue starts to cure. Use a suitable cleaner such as **NovaBond Surface Cleaner**.
6. Allow the adhesive sufficient time to achieve handling strength (working time is 3-5 minutes depending on environmental conditions) before moving or unclamping. Full cure and ultimate bond strength will take 24 hours to achieve.

NovaWeld SignFix 12 technical information – Uncured material

Property	Parameter
Resin	Methyl Methacrylate
Colour	Transparent
Appearance	Clear liquid
Viscosity Brookfield T Bar	175,000cps @ 25°C
Cure System	Exothermic
Open Time 10g Mass	2-3 Minutes @25°C
Handling Strength 10g Mass	5-7 Minutes@ 25°C
Shelf-life	12 months if stored out of direct sunlight in a cool dry place

Disclaimer

This information relates only to the specific material designated and may not be valid for such material used in combination with any other materials or in any process. Such information is, to the best of the company's knowledge and belief, accurate and reliable as of the date indicated. However, no warranty guarantee or representation is made to its accuracy, reliability or completeness. It is the user's responsibility to satisfy himself as to the suitability of such information for his own particular use.

TECHNICAL DATA SHEET

<div><div>bonding people fixing problems</div><div>INNOVA</div><div>solutions</div></div>	TDS No:	029	Issue No:	2
	Issue Date:		27/07/16	
	Revision Date:		28/07/17	
	Page No:		3 of 3	
PRODUCT		NovaWeld SignFix 12		

NovaWeld SignFix 12 technical information – Cured material

Property	Parameter
Gap Fill	0.6 – 1.5mm
Temperature Range	-55°C to 120°C
ASTM D1002 Lapshear	Average Nmm ²
Acrylic	4.05 (Substrate Failure)
Polycarbonate	7.36 (Substrate Failure)
PVC	5.01 (Substrate Failure)
ABS	5.44
PETg	7.15
Stainless Steel	16.5
Mild Steel	13.17
Aluminum	5.76

Packaging

Available in 25ml, 50ml and 400ml Cartridges to be used with dispensing gun.

Health and Safety in Use

NovaWeld SignFix 12 is a methyl methacrylate and should not be used without consulting the MSDS, which contains full information regarding the use of this product, including Transport, Disposal, Toxicological, Exposure Controls, Accidental Release and First Aid measures essential to the safe use of this product.

Disclaimer

This information relates only to the specific material designated and may not be valid for such material used in combination with any other materials or in any process. Such information is, to the best of the company's knowledge and belief, accurate and reliable as of the date indicated. However, no warranty guarantee or representation is made to its accuracy, reliability or completeness. It is the user's responsibility to satisfy himself as to the suitability of such information for his own particular use.