


TECHNICAL DATA SHEET			
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PRODUCT	NovaWeld Sign Fix 11		

Description

NovaWeld SignFix 11 is a two component structural methacrylate adhesive, designed for the bonding of high strength metal and composite applications. Signfix 11 has been formulated from innovative technology, including our revolutionary adhesion system. This unique system enables the Signfix 11 to achieve the ultimate balance of mechanical strength and impact resistance whilst still remaining both simple and quick to use. Single component low viscosity light activated structural acrylic adhesive designed to bond cast acrylic sheet with a bond strength that should always outperform the substrate. This ultra high strength is achieved by using a bespoke blend of advanced acrylic polymers that will cure on demand when exposed to visible light.

Advantages and Benefits

NovaWeld SignFix 11 is very versatile, and can bond a wide variety of substrates without the need for surface primers or conditioners. Typical examples shown below:

- Bonding metal fasteners to moulded composite parts
- Bonding automotive carbon fibre body panels
- Bonding GRP in the marine industry

Instructions For Use

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.
5. Assemble components carefully and clamp if required.
6. Take care not to over-tighten – you need to leave some adhesive between the joint.
7. Remove any excess adhesive at this point, before the structural glue starts to cure.
8. Use a suitable cleaner such as NovaBond Surface Cleaner.
9. Allow the adhesive sufficient time to achieve handling strength (working time is 3-5 minutes depending on environmental conditions) before moving or unclamping.
10. Full cure and ultimate bond strength will take 24 hours to achieve.

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.

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Properties of Uncured Material

Resin	Methyl Methacrylate
Colour	Amber/Clear
Appearance	Translucent Liquid
Viscosity Brookfield T Bar	5000cps
Cure System	Exothermic
Open Time	2-3 Minutes @20 ⁰ C
Handling Strength	4-5 Minutes@ 20 ⁰ C

Performance of Cured Material

ASTM D1002 Lapshear	Up to 25 Nmm ²
ASTM D638 Tensile Strength	Up to 25 Nmm ²
Gap Fill	2mm
Temperature Range	-55°C to 125 ⁰ C

Packaging

50 Signfix 11 is available in 50ml Nylon cartridges for use with a dispensing gun.

Storage & Shelflife

NovaWeld SignFix 11 should be stored unopened in a cool dry location, out of direct sunlight. Stored correctly this grade can offer a 12 month shelf life from manufacture.

Health and Safety in Use

NovaWeld SignFix 11 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.

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