


TECHNICAL DATA SHEET

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PRODUCT	NovaBond SignFix XS110 HT			

Product Description

Specifically targeting bonding of bare metals prior to powder coating processes, NovaBond SignFix XS110 HT is a heavy duty acrylic pressure sensitive adhesive capable of operating at the high temperatures of 200°C+



NovaBond SignFix XS110 HT is the double-sided, heat resistant tape you can rely on for the most demanding, performance critical tasks.

On textured or uneven surfaces, powder coating, temperatures of up to 260°C*, exposed to full sunlight or chemicals, NovaBond SignFix XS110 HT stays strong.

Applications


- **Manufacturing:**
 - Use on bare metals **prior** to powder coating and oven-stoving.
- **Signage:**
 - Virtually impervious to UV, temperature, ageing or chemicals.
 - Ideal for durable, long-lasting signs in the harshest environments.

Features & benefits

- Accepts powder coat
- Can replace spot welds or mechanical fasteners
- Ultra high sheer and high cohesion – ensuring the tape (and bond) remain strong under stress
- Resists vibration, impact or shock
- Good solvent resistance
- Interior or exterior application
- Suitable for plasticised PVC but not low surface energy plastics ([use NovaBond LSE 110B](#))
- 1.1mm thickness Grey/Black tape with red filmic liner

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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How to apply NovaBond SignFix XS110 HT acrylic tape

The surfaces to be bonded should be dry, dust and grease free and thoroughly clean .
Avoid touching the exposed adhesive surface of the tape as this impairs the performance.


The adhesive used on these tapes are pressure sensitive, so always ensure sufficient pressure is applied to the tape evenly over the whole surface to ensure the best bonding results.

1. Abrade (roughen) the surface to provide a 'key' to which the tape can bond, increasing the bond strength by as much as 35%
2. Clean with [NovaBond Surface Cleaner](#)
3. Prime the surface using [NovaBond Surface Primer](#)
4. Independent tests at Loughborough University show that using the correct primer can increase final bond strength by up to 50%. Remove the blue silicon liner.
5. Align the parts to be bonded.
6. With firm pressure, apply NovaBond SignFix XS110 HT to one of the surfaces to be bonded.
7. Using a [NovaBond roller](#) will allow the double sided acrylic tape to wet out and reach ultimate bond strength more quickly.
8. Apply firm pressure to the bond with the NovaBond roller.
9. Ultimate bond strength will be achieved in 72 hours.

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Product Specification

Property	Specification
Colour	Black
Thickness	1.10mm
Carrier	Acrylic layer
Liner	Red PE film
90° Peel Adhesion according to AFERA 5001	Steel 32N/25mm
Static Shear Strength (to stainless steel)	1500g @ 23°C : 500g @ 93°C
Dynamic Shear (@200mm/min)	62N/cm ² (after 2 hours) : 67N/cm ² (after 24 hours)
Operating Temperatures	Short term (mins/hrs) 230°C : Long term (days+) 120°C
Application temperature	Minimum 15°C (ideally between 21°C and 40°C)
Temperature resistance according to ISTM D3654 method	From -40°C to +150°C (long term) 260°C+ (short term) Area of 6.25 ² with 1kg load @ 150°C for 10,000 minutes
Solvent Resistance	Good
UV Resistance	Excellent
Standard roll dimensions	12, 19 & 25mm widths x 33m rolls

Storage

This product should be stored in ambient temperatures of around 20°C, avoiding wide temperature fluctuations and direct sunlight.

The storage environment should have a relative humidity of approx. 50%. In ideal storage conditions, the shelf life for this material should be approx. 12 months from the delivery date. Within this period, no major deterioration or alteration of the products performance characteristic will occur.

The values presented in this document have been determined by standard test methods and are average values that should not be used for specification purposes without conducting tests on materials to be bonded.

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