

TECHNICAL DATA SHEET



TDS No:	014	Issue No:	1
Issue Date:	14/01/14		
Revision Date:	14/07/16		
Page No:	1 of 4		

PRODUCT

Trimweld SignFix 7

IDENTIFICATION OF THE SUBSTRATE/PREPARATION & COMPANY

Product Name:	Trimweld SignFix 7	
Company:	Innova Solutions Limited	Tel: 01282 867390
	Lower Draught Gates Farm, Burnley Road	Fax: 01282 861077
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DESCRIPTION

Trimweld SignFix 7 is a new generation of 2 part 1:1 component mixing structural acrylic adhesives. It is fast setting when mixed via a static mix nozzle at room temperatures. Trimweld SignFix 7 demonstrates improved impact strength, peel shear and tensile resistance and exterior performance. Because it is a thixotropic, non-sag adhesive, the mixed material is ideal for all types of gap filling requirements on steel, aluminium, polycarbonates and general plastics. It is also very good for vertical surface bonding without running. Trimweld SignFix 7 exhibits excellent structural strength even without priming the surfaces. Owing to its macro molecular structure, the bonds formed show excellent durability and high peel strength even when filling large gaps and demonstrate excellent solvent and environmental resistance to moisture, hydro-carbon fuels, lubricants, cleaning chemicals and fluids.

TYPICAL USAGES OF Trimweld SIGNFIX 7

Structural bonding in the sign industry of most signmaking materials especially mild and stainless steels, aluminium, polycarbonate and acrylic sheets, composite panels and even stone and ceramics where high impact strengths are needed. The thixotropic nature of Trimweld SignFix 7 is ideal for bonding Bighead fasteners and other locators. Other applications include wind turbines, vehicle roofs, fibreglass, sports goods, automotive spoilers, vents, housings. The high temperature adhesive formulation allows for bonding metal parts prior to powder-coating and oven stoving cycles.

APPLICATION INSTRUCTIONS

- Always consult MSDS before using SignFix 7 for the first time.
- Carry out surface preparation where required.
- Remove cap, and attach mixer nozzle.
- Dispense sufficient adhesive to ensure equal mix.
- Apply adhesive to one surface and assemble components carefully, clamping if required.
- It is always easier to remove any excess adhesive prior to cure using a suitable cleaner. Allow the adhesive sufficient time to achieve handling strength before moving or unclamping

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



TDS No:	014	Issue No:	1
Issue Date:	14/01/14		
Revision Date:	14/07/16		
Page No:	2 of 4		

PRODUCT

Trimweld SignFix 7

CURING CYCLE

Once mixed at the 1:1 ratio the working time of the SignFix 7 is the period whereby the adhesive remains fluid and is easily transferable between two or more mating surfaces. Temperature, volume and substrate have a direct effect on the length of this period as the SignFix adhesive cures by an exothermic reaction. Higher temperatures and larger volumes speed the reaction causing a reduction in open and cure time. Lower temperatures and smaller volumes slow the reaction time extending both the open time and ultimate full cure time.

COMPATIBLE SUBSTRATES

Aluminium	Wood
Stainless steel	Granite
Mild steel	Marbl
UPVC	Urethanes
Polyesters	Vinyl esters
ABC	Glav / Zinc coated
Acrylic	Thermoset
FRP	Gelcoa
GRP	Epoxy laminate

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TECHNICAL DATA SHEET



TDS No:	014	Issue No:	1
Issue Date:	14/01/14		
Revision Date:	14/07/16		
Page No:	3 of 4		

PRODUCT

Trimweld SignFix 7

TYPICAL UNCURED PROPERTIES Trimweld SIGNFIX 7

Resin	Methyl Methacrylate
Colour	Yellow / White
Appearance	Thixotropic Gel
Viscosity brookfield t bar	400,000 to 600,000cps
Cure system c	Exothermic
Open time	7 minutes @ 20°C 10g mass
Handling strength	12 minutes @ 20°C 10g mass
SG Part A	0.96
SG Part B	0.91

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TECHNICAL DATA SHEET



TDS No:	014	Issue No:	1
Issue Date:	14/01/14		
Revision Date:	14/07/16		
Page No:	4 of 4		

PRODUCT

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TYPICAL CURED PROPERTIES Trimweld SIGNFIX 7

ASTM D1002 lapshear	Average over 16 tests
Aluminium	20.4Nmm2
Stainless steel	38.4Nmm2
Mild steel	38.4Nmm2
GRP	Substrate failure
ABS	Substrate failure
Acrylic	Substrate failure
ASTM D638 tensile	Up to 30 Nmm2
Gap fill	4mm
Standard temperature	-55°C to 120°C
Paint bake cycle	20 minutes @ 220°C
Aluminium lapshear following moist cataplastm 7 days @ 70°C	26.7 MPA
Peel Strength Aluminium	6KN/m
Shore hardness	75 shore D

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