

B. Paints, Sealants, Adhesives

Technical Bulletin B-3

Bonding & Filling Applications

Bonding

When bonding VERSATEX to itself or another PVC material, most standard PVC pipe cements perform well especially those that are solvent based. Care should be taken to assure the substrates are clean and dry. Also, cements with moderate to slow setup time are preferred. When bonding VERSATEX sheets to themselves to obtain a thicker product, longer adhesive cure time will be required. Extreme Adhesive PVC TrimWelder Laminating Grade is an ideal product for this application. Through independent testing VERSATEX has identified a few adhesives and sealants that provide outstanding PVC bond strength (see chart on the next (2) pages). Although most cyanoacrylates (super glues) are excellent for bonding VERSATEX to itself, they are prone to breakdown when subjected to a moist environment. Adhesive and sealant formulations vary with each manufacturer. Performance is dependent upon the application. Therefore, each adhesive and sealant should be tested in the field on a small sample of VERSATEX to determine compatibility before being placed into use.

Please consult the manufacturer for recommended products for your application.

B. Paints, Sealants, Adhesives

Technical Bulletin B-3

Bonding & Filling Applications

Adhesives

Manufacturer	Products	Application
Royal Adhesives & Sealants, LLC 61 Epping Road, Raymond, NH 03077 www.extremeadhesives.com P. (800) 888-Glue (4583) P. (603) 895-4028 F. (603) 895-6236	Methyl methacrylates, cyanoacrylates, epoxies, anaerobics, UV curing acrylics, Hotmelts and PVC cement	PVC TrimWelder - VERSATEX to Itself as well as most metals (galvanized and aluminum), most plastics, fiberglass, fiberglass mat gypsum sheathing, wood and wood composites. Consult the manufacturer regarding your specific application.
IPS Corporation 455 W. Victoria Street, Compton, CA 90220 www.ispcorp.com P. (800) 421-2677 F. (310) 742-0164 Tech Support: (877) 477-8327 E. info@ispcorp.com	Weld-On 705, 717, 719 and 4052 (slow cure & low VOC). Two part systems include 810, 811(cart.) and 815(cart.)	VERSATEX to itself. Use Weld-On 705 or 4052 when more working time is needed. 717 is a medium set while 719 is a slightly slower set. Both have a higher viscosity than 705.
Ze-VO Products Group, LLC 14 Eastern Park Road East Hartford, CT 06108 www.ze-vo.com P. (508) 879-3151	1-Part-Adhesive Cellular PVC Cement	For bonding VERSATEX to itself. Consult the manufacturer regarding your specific application.
Trim Glue, Inc. www.TrimTight.com P. (877) 874-6458 F. (888) 329-4583	TrimTight cellular PVC cement. Eco-Friendly, Low VOC, UV stable	VERSATEX to itself. Consult the manufacturer regarding your specific application.
T. Christy Enterprises, Inc. 655 East Ball Road, Anaheim, CA 92805 www.tchristy.com P. (800) 258-4583 F. (800) 468-4583	Red Hot White Vinyl Adhesive. 10.3 Fl. Oz Caulk tubes, 8 Oz tube, 1.5 Oz tube, 32 Oz can with dauber. Also available in clear	VERSATEX to itself. Available in a standard caulking tube making it ideal for use in the field. Consult the manufacturer regarding your specific application.
Liquid Nails, a product of PPG Arch Coatings 400 Bertha Lamme Drive, Cranberry Township, PA 16066 www.liquidnails.com P. (800) 634-0015 F. (440) 297-7366 E. liquidnails@ppg.com	Liquid Heavy Duty Construction Adhesive (LN-901 & 903), Liquid Nails Adhesive for Sub-Floors & Decks (LN-602 & 902), Polyurethane Construction Adhesive (LN-950)	Check Technical Data Sheets for product compatibility. Consult the manufacturer regarding your specific application. VERSATEX to wood or wood composite substrates.
Loctite® Brand - Consumer Products Henkel Corporation 26235 First Street, Westlake, OH 44145 www.stickwithpl.com P. (800) 624-7767	PL Premium Polyurethane Construction Adhesive. PL Premium FAST GRAB Polyurethane Construction Adhesive	VERSATEX to wood and other porous substrates. Consult the manufacturer regarding your specific application. Water in the form of a mist is required to activate a polyurethane adhesive when bonding VERSATEX.

B. Paints, Sealants, Adhesives

Technical Bulletin B-3

Bonding & Filling Applications

Adhesives, Continued

Manufacturer	Products	Application
Ambel Corporation 188 Cottonport Avenue, Cottonport, LA 71327 www.intscs.com P: (318) 876-2495 F: (318) 876-2213	Excel One Liquid Polyurethane Adhesive, Excel Xpress Gel Polyurethane Adhesive, Excel Structan Polyurethane Adhesive and Excel 50/50 Elastic Mastic Adhesive	VERSATEX to wood and other porous substrates. Consult the manufacturer regarding your specific application.
3M 3M Center Saint Paul, MN 55144 www.3m.com P: (888) 364-3577	Fastbond Scotch Weld 4475 Scotch Weld Polyurethane Adhesive	VERSATEX to various substrates including glass, plastic, wood and Formica. Consult the manufacturer regarding your specific application.
ITW Polymer Adhesives, North America 30 Endicott Street, Danvers, MA 01923 P: (855) 489-7262	Methyl Methacrylates	Devcon plastic welder white. Consult the manufacturer regarding your specific application.

Sealing and Fillers

For sealing, caulking and filling VERSATEX or just repairing a ding or a dent, there are options:

Manufacturer	Products	Application
NPC, Inc., a division of Nu-Pattie Corp 1208 South 8th Avenue Maywood, Illinois 60153 www.npcsealants.com P. (708) 681-1040 F. (708) 681-1424	#900 Solar Seal Terpolymer Sealant and Adhesive. #111 Trimboard White is a good color match to VERSATEX	Seals and adheres VERSATEX to itself and various substrates. Consult the manufacturer regarding your specific application. Available in over 200 standard colors & custom colors. Has a 20 yr. life expectancy. Paintable.
DAP, Inc. 2400 Boston Street, suite 200 Baltimore, MD 21224 www.dap.com P. (410) 675-2100 F. (410) 558-1068 Support. (888) 327-8477	Crack Shot High Performance Spackling Paste, Alex Plus Spackling	Fills nail holes and dents in VERSATEX. Painting is required.
Extreme Adhesive 63 Epping Road Raymond, NH 03077 www.extremeadhesives.com P. (800) 888-GLUE (4583) F. (603) 895-6236	PVC TrimWelder (slow cure, fast cure, laminating grade). PVC Nail Eraser, PVC Nail Sticks	Fills nail holes and dents in VERSATEX. Painting is required. Available in white only.

B. Paints, Sealants, Adhesives

Technical Bulletin B-3

Bonding & Filling Applications

Sealing and Filling, Continued

Manufacturer	Products	Application
Henkel Corporation One Henkel Way Rocky Hill, CT 06067 www.ositough.com P. (800) 624-7677	Quad, Quad Max, Polyurethane Based Solvent Adhesive and H2V Acrylic Urethane Sealant	Seals and adheres to VERSATEX and various other substrates including wood and metal. Follow the manufacturer's application recommendations. Paintable.
Siroflex, Inc. P.O. Box 26749 Greenville, NC 29616 www.siroflexinc.com P. (800) 359-6398 or (864) 458-9094 F. (864) 458-9092	Duo-Sil Ultra Hybrid Polymer Adhesive & Sealant, Duo-Sil Urethane Acrylic Sealant & Adhesive	Seals and adheres to VERSATEX and various other substrates. Consult the manufacturer regarding your specific application.
Franklin International 2020 Bruck Street Columbus, Ohio 43207 www.titebond.com P. (800) 877-4583 F. (614) 445-1813 Support. contechserv@franklininternational.com	WeatherMaster Sealant, WeatherMaster Ultimate MP Sealant	Seals VERSATEX and various other substrates including wood metal (aluminum & brass), and fiberboard. Follow the manufacturer's application recommendations. Available in over 200 colors.
Geocel Corporation P.O. Box 398 Elkhart, IN 46515 www.Geocelusa.com P. (800) 348-7615 F. (800) 348-7009	2300 Construction Tripolymer Sealant, 3900 Polyurethane Sealant	Seals to VERSATEX and various other substrates. Consult the manufacturer regarding your specific application.

Recommended Adhesive Tape Manufacturers:

Double sided adhesive tapes

Manufacturer Website:

3M: www.3m.com

Venture Tape: www.venturetape.com

Covalence Adhesives: www.covalenceadhesives.com

Scapa: www.scapa.com

As with any solvent based adhesive, sealant or filler, proper ventilation and a clean workspace are required to obtain adequate curing and provide a safe working environment for your employees. It is also recommended that you follow the manufacturer's storage and handling specifications. Discarding of unused adhesives or solvents may be subject to local, state or federal regulations.