

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, additional adhesive cure time will be required due to the impervious nature of VERSATEX. VERSATEX Fill N' Fasten for laminating 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 on a small sample of VERSATEX to determine compatibility before being placed into use.

Please consult the manufacturer for recommended products for your 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

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Adhesives

| Manufacturer | Products | Application |
|--|---|--|
| <p>VERSATEX 400 Steel Street, Aliquippa, Pa 15001 www.versatex.com P. (724) 857-1111 F. (724) 857-1171</p> | <p>VERSATEX Fill N' Fasten</p> | <p>VERSATEX to Itself as well as most metals (galvanized and aluminum), most plastics, fiberglass, wood and wood composites. Consult VERSATEX regarding your specific application.</p> |
| <p>Extreme Adhesive 63 Epping Road, Raymond, NH 03077 www.extremeadhesives.com P. (800) 888-Glue (4583) P. (603) 895-4028 F. (603) 895-6236</p> | <p>Methyl methacrylates, and epoxies</p> | <p>VERSATEX to Itself as well as most metals (galvanized and aluminum), most plastics, fiberglass, wood and wood composites. Consult the manufacturer regarding your specific application.</p> |
| <p>IPS Corporation 202 Industrial Park Lane Collierville, TN 38017 www.ispcorp.com P. (901) 853-5001 F. (901) 853-5008 E. info@ispcorp.com</p> | <p>Weld-On 705, 717, 719 and 4052 (slow cure & low VOC). Two part systems include 810, 811(cart.) and 815(cart.).</p> | <p>VERSATEX to itself. Use Weld-On 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.</p> |
| <p>Trim Glue, Inc. www.TrimTight.com P. (877) 874-6458 F. (888) 329-4583</p> | <p>TrimTight cellular PVC cement. Ecofriendly, Low VOC, UV stable</p> | <p>VERSATEX to itself and other PVC products. Consult the manufacturer regarding your specific application.</p> |
| <p>T. Christy Enterprises, Inc. 655 East Ball Road, Anaheim, CA 92805 www.tchristy.com P. (800) 258-4583 F. (800) 468-4583</p> | <p>Red Hot White Vinyl Adhesive. 10.3 Fl. Oz tubes.</p> | <p>VERSATEX to itself and other PVC products. Available in a standard caulking tube making it ideal for use in the field. Consult the manufacturer regarding your specific application.</p> |
| <p>ICI - Macco Adhesives 15885 West Sprague Road Strongsville, OH 44136 www.liquidnails.com P. (800) 634-0015 F. (440) 297-7366</p> | <p>Liquid Nails Adhesive for Heavy Duty Construction & Remodeling (LN-901). Liquid Nails Adhesive for Sub-Floors & Decks (LN-602). Polyurethane Construction Adhesive Contact Cement.</p> | <p>Check Technical Data Sheets for product compatibility. Consult the manufacturer regarding your specific application.</p> |
| <p>Henkel Consumer Adhesives Mentor, Ohio 44060 www.stickwithpl.com P: (800) 624-7767</p> | <p>PL Ultimate Hybrid Sealant & Adhesive, PL Premium Polyurethane Construction Adhesive</p> | <p>VERSATEX to itself and other substrates. Consult the manufacturer regarding your specific application.</p> |

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Adhesives Continued

| Manufacturer | Products | Application |
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| Ambel Corporation 12040 Murphy Highway Clinton, MI 49286 www.excelglue.com P: (800) 779-3935 F: (734) 726-5093 | Excel One Liquid Polyurethane Adhesive, Excel Xpress Gel Polyurethane Adhesive and Excel Structan Polyurethane Adhesive. | VERSATEX to itself and various 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. |

Sealing and Filling

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

| Manufacturer | Products | Application |
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| VERSATEX 400 Steel Street, Aliquippa, Pa 15001 www.versatex.com P: (724) 857-1111 F: (724) 857-1171 | VERSATEX Fill N' Fasten | Fills nail holes and dents in VERSATEX. No painting is required but it can be painted custom colors. Available in white only. |
| NPC, Inc. 1208 South 8th Avenue Maywood, Illinois 60153 www.npcsealants.com P: (708) 681-1040 or (800) 654-1042 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 Baltimore, MD 21224 www.dap.com P: (410) 675-2100 F: (410) 534-2650 | Crack Shot High Performance Spackling Paste | Fills nail holes and dents in VERSATEX. Painting is required. |
| | Fast N' Final Spackling | Fills nail holes and dents in VERSATEX. Painting is required. |

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Sealing and Filling Continued

| Manufacturer | Products | Application |
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| <p>Siroflex, Inc. P.O. Box 26749 Greenville, NC 29616 www.siroflexinc.com P: (800) 359-6398 or (864) 458-9094 F: (864) 458-9092</p> | <p>Duo-Sil Urethane Acrylic Sealant & Adhesive. Non-Hazardous, Non-Flammable, available in over 100 in stock colors.</p> | <p>Seals and adheres to VERSATEX and various other substrates. Consult the manufacturer regarding your specific application.</p> |
| <p>Franklin International 2020 Bruck Street Columbus, Ohio 43207 www.titebond.com P: (800) 877-4583 F: (614) 445-1813</p> | <p>WeatherMaster Sealant</p> | <p>Seals VERSATEX and various other substrates including wood metal (aluminum & brass), and fiberboard. Follow the manufacturer's application recommendations. Available in over 200 colors.</p> |
| <p>Henkel Corporation Professional & Consumer Sealants Akron, Ohio www.henkel.com P: (800) 321-0253 F: (440) 037-7067</p> | <p>PL Ultimate Hybrid Sealant & Adhesivent</p> | <p>Seals and adheres to VERSATEX and various other substrates including wood and metal. Follow the manufacturer's application recommendations. Paintable.</p> |
| <p>OSI Sealant Construction Division 7405 Production Drive Mentor, Ohio 44060 www.osiproseries.com P: (800) 321-3578 or (440) 255-8900 F: (440) 974-8358</p> | <p>Quad Polymer H2U Acrylic Urethane Sealant</p> | <p>Seals to VERSATEX and various other substrates. Consult the manufacturer regarding your specific application.</p> |
| <p>Geocel Corporation P.O.Box 398 Elkhart, IN 46515 www.Geocelusa.com P: (800) 348-7615 F: (800) 348-7009</p> | <p>2300 Construction Tripolymer Sealant</p> | <p>Seals to VERSATEX and various other substrates. Consult the manufacturer regarding your specific application.</p> |

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.