

# TECHNICAL DATA SHEET

## Indasol 800 – User guide

### Bonding Procedure

1. Aggressively abrade the sides of the return.
2. Aggressively abrade the acrylic substrate (where applicable).
3. One directionally clean both substrates with INDASOL Surface Cleaner
4. Remove cap from the INDASOL 800, dispense a small amount of the adhesive out to ensure both chambers are flowing.
5. Attach a nozzle and using an applicator gun dispense at least a nozzle's worth of adhesive to ensure the correct ratio of adhesive is mixed.
6. Gun the adhesive onto the metallic return, we would recommend using a bead size of 4.5mm up the return, and 5mm across the face of the Acrylic.
7. Keeping the nozzle pressed against the return, ensure to keep a steady, consistent 5mm bead around all edges, allowing the adhesive to pool a little in corners so that it may then withstand the expansion and contraction of the two different substrates.
8. Allow for 7-10 minutes handling time and approximately 24 hours to fully cure.\*\*

\*\*time may vary depending on temperature of surroundings.

**For larger letters we would always recommend using a secondary fixing, please speak to your account manager for further advice.**

### Amount of Adhesive

As a 90-degree joint between two substrates is a very unnatural joint design for an adhesive, it is imperative that the preparation is standardised, as per the above, but it is extremely important that a sufficient amount of adhesive is used to cope with the expansion and contraction of the dissimilar materials.

We would recommend using a bead size of 4.5mm up the return, and 5mm across the face of the Acrylic. Whilst Aesthetically it's important not to flood the adhesive onto the Acrylic face, its paramount that enough adhesive is present to cope with the stress of the joint.

With letters above 300mm we would always recommend a secondary fixing, as a fail-safe, should the environment that the letter is situated in, and the increased surface area, excessively expand and contract the two dissimilar materials.



### Rebating the Face

Where possible, to gain a stronger bond, rebate the acrylic face of the signage so that the adhesive will have more surface area to pool into.

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