

## Bonding KYDEX® Sheet to Metal

For information applicable to KYDEX® FST please refer to 300 series technical briefs.

### TB - 103B

#### Introduction

Due to its excellent chemical resistance, KYDEX® thermoplastic sheet can be more difficult to cement than other plastics. Herein we discuss how to cement KYDEX® sheet to itself and other plastics, Metals, and Wood. Strong bonds can be obtained for most applications using the methods shown below. KYDEX® sheet can also be joined to itself or to other materials using mechanical fasteners in place of adhesives.

#### Solvent Cementing

##### Preparation for Bonding:

For best bonding results, the substrates MUST be free from dirt, grease, and dust. To clean the surfaces wipe with a solvent such as isopropyl alcohol before you apply the adhesive. Remember that the bonding process works best if done in a temperature controlled environment of approximately 18° - 24°C (65° - 75°F).

Product Name	Phone	Web
Uralane 5774 (Huntsman)	1.800.817.8260	www.huntsman.com
Lord 406/19 & 661/6 (Lord)	1.877.275.5673	www.lordadhesives.com
Devcon Metal Welders I & II (Devcon)	1.800.933.8266	www.devcon.com
JDC B1132 foam tape (JDC Inc)	1.615.754.9797	www.jdcinc.com
Arlon 101 foam tape (Arlon)	1.800.854.0361	www.arlon-std.com

##### Recommended Primers:

3M™ Prep Solvent-70 Cleaner

3M™ Tape Primer 94

FOR ADDITIONAL INFORMATION: call 1-800-362-3550.

*Please Note: For bonding KYDEX® sheet to aluminum, all of the above listed adhesives may be used.*

Acrylic based adhesives such as Devcon's 'Metal Welder' or 'Metal Welder II' can be used to form very strong bonds with KYDEX® sheet. Both of the 'Welder' products are 2-part adhesives, which are available in cartridges. The Welders produce a strong bond, which cure in about 15 minutes. The adhesives are grey in color. Also, there is a 'Composite Welder' that is good for bonding one composite to another such as KYDEX® sheet to another plastic or metal. The 'Composite Welder' is blue/green in color. You may order the 'Welder' products from Devcon in the US by calling 1.800.933.8266, in Europe by calling 44.1.933.675.299 or on the web at [www.devcon.com](http://www.devcon.com). When using these adhesives, be sure to join your substrates immediately after applying the adhesive since they have a fast cure time.

##### Using Foam Tapes:

For application methods and cure times of the foam tape adhesives, please reference their respective manufacturer's technical data sheets. JDC B1132: 1.615.754.9797 [www.jdcinc.com](http://www.jdcinc.com)

##### Using Urethane Adhesives:

Uralane 5774 is a two part urethane adhesive. Please reference the manufacturer's technical briefs for recommended ratios and application methods.

#### KYDEX, LLC

ISO 9001 and 14001 Certified

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