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Reliobond 1100 and 1167 2 Part Adhesive for Bonding Flexible Vinyl to Glass

Description:

Reliobond 1100 and 1167 is a 2 part, solvent based, clear, acrylic adhesive for bonding flexible vinyl to glass. This adhesive system is primarily used in the manufacture of convertible automotive tops.

Physical Properties:

	Reliobond 1100	Reliobond 1167
Color:	Clear	Clear/Yellow
Application Method	Roll, Brush, Dip, Flood	
Viscosity:	10-20 seconds (#2 Zahn Cup)	
% Non-volatile (solids):	14-16%	8-10%
Density (calculated):	7.15 #/gal, 0.857 g/mL	7.03 #/gal, 0.843 g/mL
Mix Ratio	20 parts by volume	1 part by volume

Adhesive Preparation:

Mix 20 parts of Reliobond 1100 with 1 part of Reliobond 1167 volume.

Adhesive Application:

Isopropyl alcohol can be used to clean the surface of the glass and/or vinyl if necessary. Avoid handling bond areas with bare hands as oils on your hands can cause bond failures.

Mixed adhesive is typically applied to the glass surface by felt tipped applicator. Apply enough wet adhesive to achieve a 0.5-1.0 mil dry coating.

Bonding:

All volatile solvent must be dried from the adhesive before the bonding operation. Adhesive can be dried at room temperature for 30 minutes to 1 hour or force dried in an oven.

After drying the vinyl can be mated to the glass surface and heat applied to form the bond. The bondline (interface between adhesive and vinyl) must reach 350°F. This can be measured by inserting a thermocouple wire into a test part between the adhesive and vinyl during the sealing operation. Harder vinyl compounds may require slightly more temperature to create the bond. Once the bond has reached 350°F the heat can be removed and the part allowed to cool. While the bond will be very strong once the part has cooled, full bond strength will be reached in 24-48 hours once the activator and resin have had a chance to completely cure.

Cleaning:

Reliobond 1100/1167 can be cleaned using methyl ethyl ketone or acetone. Other solvents like toluene will be somewhat effective, but MEK or acetone are the most effective cleaners.

Storage:

Reliobond 1100 and 1167 can be stored in sealed containers for up to 12 months from the date of manufacture. Store below 90°F for best stability and safety.