CHANNEL BOND POLYCARBONATE BONDING AGENT™

Proprietary product. Use with our #49 Hypo Glue Applicator™.

Specifications

For use with polycarbonate and sign trim (CAB) in channel letters

High strength

Quick setting

One-part system



SKU	Quart	86945
	Gallon	86947
Working time	1-2 minutes	
Fixture time	5-15 minutes	
80% Strength	4 hours	
Applicator#	#49	
Shelf life unopened	2-12 months	
Shelf life opened (with top)	2-20 weeks*	
UL file	E516868	

* Avoid storing at high room temperatures. Not all components in this bonding agent evaporate at the same rate – if the product will not squirt out of the #49 applicator, it is not good anymore; do not use it. It is recommended to run a test batch if there are any doubts about its storage and condition.

How to apply on the following materials

Sign trim (cellulose acetate butyrate) to polycarbonate:

1. Fix sign trim around polycarbonate per your normal retention fixture method. Apply a uniform bead between the sign trim and polycarbonate by flexing the sign trim to allow **Channel Bond** to flow down in between materials. Bond should be strong after 10-15 minutes.
2. Apply a second uniform bead around the edge between the sign trim and polycarbonate material.
3. After 5-15 minutes, remove material from the retention fixture and add a third thin uniform bead around the front between the sign trim arrow profile and polycarbonate face (provided that there is no vinyl applied on the first surface).

Sign time (cellulose acetate butyrate) to acrylic:

1. Fix sign trim around acrylic per your normal retention fixture method. Apply a uniform bead of **Resin Bond** between the sign trim and acrylic.
2. Apply a second uniform bead with **Channel Bond** around the edge between the sign trim and acrylic material. After 5-15 minutes, remove material from the retention fixture.
3. Add a third thin uniform bead around the front between the sign trim narrow profile and the acrylic face when the material (width) exceeds 3 feet.

Polycarbonate to polycarbonate:

Apply a uniform bead to the bonding area. Hold parts together securely while bonding agent sets up. Bond should be strong after 15-60 minutes depending on the shape and size (area) to be bonded. Maximum strength after four hours.

Acrylic to polycarbonate:

Apply a uniform bead to the bonding area. Hold parts together securely while bonding agent sets up. Bond should be strong after 15-60 minutes depending on the shape and size (area) to be bonded.

*For modified acrylic (DR) to polycarbonate, see "**Acrylic to polycarbonate**". For modified acrylic (DR) to acrylic, see "**Acrylic to polycarbonate**".*

Bonds polycarbonate to polycarbonate, acrylic to polycarbonate, sign trim (CAB) to polycarbonate, modified acrylic (DR) to polycarbonate, and modified acrylic (DR) to acrylic.

Only ships via pallet/LTL.
*Use **#49 Hypo Glue Applicator** with **Channel Bond Polycarbonate Bonding Agent**.*

Application instructions for Channel Bond Polycarbonate Bonding Agent

Before use:

1. **Channel Bond** is a one-part bonding system. Use a **#49 Hypo Glue Applicator** (pink tip) bottle to apply.
2. Store in the original container when not in use. Keep lid tight. Store where the temperature is between 32° F to 80° F.
3. Read the health and safety information on the container before using.
4. Be sure surfaces to be bonded are clean and smooth.
4. The shelf life of this product when stored properly is 2-12 months.
5. Try a small test on extra/scrap material before going into production.

*Scan this QR code to see how to properly use our **Channel Bond Polycarbonate Bonding Agent** to bond polycarbonate to sign trim.*

EPA approved for industry applications. **LEARN MORE**

Bonding agents used to chemically weld acrylics or polycarbonates with methylene chloride do not have a technically or economically feasible safer alternative available. This application is uniquely different from adhesives which do have technically or economically feasible safer alternatives available. Commenters that described their use of methylene chloride indicated that they require low quantities of methylene chloride for its effect and stated that they are currently in compliance with the OSHA methylene chloride standard at 29 CFR 1910.1052 (Refs. 59, 60). Based on the information received, and the similarities across multiple uses of methylene chloride as a bonding agent—but not as an adhesive—EPA believes that the WCPP will address the unreasonable risk for use of methylene chloride as a bonding agent in general, and is therefore expanding its initial scope of this allowed use under the WCPP from mission-critical military and space vehicle applications to general industry.

Specifications subject to change without notice.

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Sent: Friday, July 18, 2025 12:57 PM

Subject: RE: Methylene Chloride Ban

Hello [redacted]

It was great speaking to you today over the phone and having the opportunity to offer some clarifications on the final rule for methylene chloride under TSCA section 6(a).

As a brief recap, we discussed that your company distributes methylene chloride to downstream users who then use it in chemical welding applications. After you described the condition of use to me, I referred you to the Unit IV.B.1.c.vi. of the final rule for a description of industrial or commercial use of methylene chloride as a bonding agent for solvent welding. That description is as follows:

This condition of use refers to the industrial or commercial use of methylene chloride or a solvent blend including methylene chloride to chemically bond polymer substrates including, but not limited to, acrylic or polycarbonate, creating an airtight, waterproof, and in some cases seamless joint.

After describing the use, you were able to confirm that this use is an accurate representation of your downstream customers. I notified you that the final rule does not prohibit this use of methylene chloride and that this use is authorized to continue under the Workplace Chemical Protection Program (WCPP)(§ 751.109(a)(9)).

As we discussed, distributors for this condition of use must comply with the downstream notification requirements in § 751.111. As a distributor, note the specific language required in § 751.111(d). To the extent that those downstream customers use methylene chloride as described by the excerpt from the final rule above in italics, they must comply with the requirements of the WCPP at § 751.109.

For additional compliance information, refer to the following:

- Methylene Chloride Compliance Guide (Unit IV, beginning on page 9 contains WCPP compliance information)
- Methylene Chloride Webinar
- Methylene Chloride Fact Sheet
- EPA's Methylene Chloride Risk Management webpage

For any follow up inquiries, feel free to send them to me or to MethyleneChlorideTSCA@EPA.gov

Very respectfully,

[redacted]

Environmental Protection Specialist

OCSPP|OPPT|ECRMD|RMB1

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