Procedure for bonding to Glass with NovaBond SignFix Crystal 100

NovaBond SignFix Crystal 100 is a water clear 1.0mm thick, high performance extruded acrylic bonding tape. The tape exhibits excellent initial tack and ultimate bond strength on a variety of substrates including clear acrylics and glass. It will perform under the harshest environmental conditions where there is movement due to dissimilar expansion and contraction or environmental conditions.

When bonding lettering onto glass, ensure both the surface of the glass and the rear of the letter are cleaned with NovaBond Surface Cleaner. (If either the letter or glass are excessively soiled, clean well with soap & water and dry completely prior to cleaning with the NovaBond Surface Cleaner.)

We always recommend applying the tape to the lettering first and where possible, under shopfloor conditions where cleaning is easier, the ambient temperature is more controlled and the tape has a chance to bond well into the surface prior to fixing to the glass. You may find it easier to roll out the tape and apply the letter directly onto the exposed adhesive. Cut round the letter carefully with a sharp scalpel or knife and then turn the letter over and apply firm pressure by means of a NovaBond Roller to expel any trapped air bubbles.

When bonding to glass at temperatures below 10°C, there is a risk of condensation forming on the surface which will prevent bonding. If this is the case, apply gentle heat from a hot air gun or hair dryer in order to warm the surface to above 10°C taking care not to overheat and crack the glass. Glass can be a difficult surface to bond to as it is very flat and smooth but can trap impurities and moisture in the fine surface pores. For this reason we always recommend priming with 3M Silane Glass Primer allowing this to dry and act, either naturally, or by speeding up the process in cold temperatures by, again, applying warm air. This should only take a matter of minutes before it is possible to apply the lettering whilst the glass surface is still warm and condensation has not had chance to reform on the surface.

Start to remove the liner (around 50 – 75mm) and peel out to the side of the letter , line up the letter correctly, and then applying firm pressure, preferably from one side of the letter in one direction so as to avoid trapping any air bubbles, peel out the liner. Again it is better to use the roller to achieve uniform pressure over the whole of the letter to ensure 100% surface contact between the letter and the glass. It is probably worth making up some removeable markings to ensure that the letters are correctly aligned prior to fixing as the adhesive is not very forgiving and removal of a mis-aligned letter may result in damage. If the glass has cooled down in-between fixing other letters, re-apply gentle heat before fixing each letter.

On applying the letter with firm pressure, the resulting bond will achieve around 60 – 70% bond strength and this should be sufficient to support the weight of the lettering. The adhesive will continue to flow, however, reaching ultimate bond strength in 48 – 72 hours. If in doubt, apply some strong masking tape to support the letters until the NovaBond SignFix Crystal 100 has achieved ultimate bond strength.

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