



SIGNABOND®

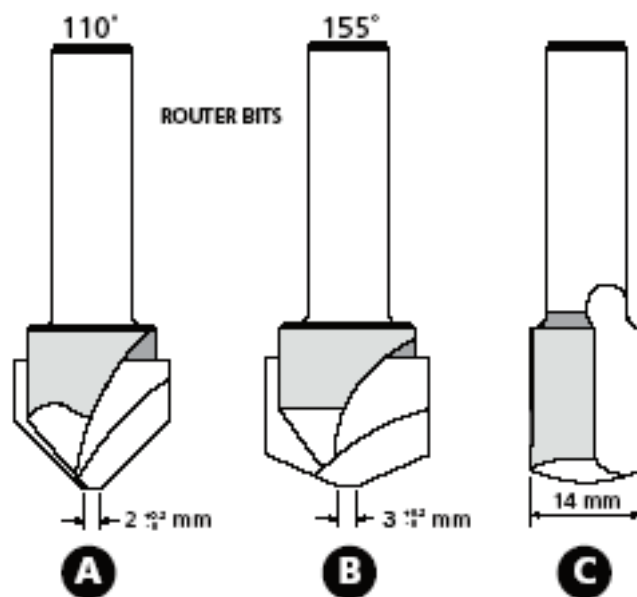
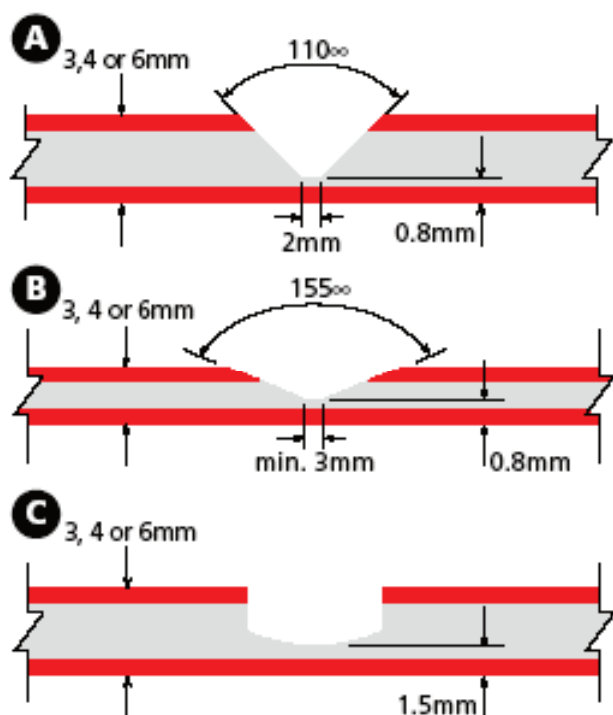
Aluminum Composite Sign Panels

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Applicable for Signabond Lite, V.3 and V.5 products

Observe the following recommendations in 'U' or 'V' cut processing:

The 'U' or 'V' cut bottom should not reach to the back of the aluminum. Leave about 0.008 - 0.016" of polyethylene core.



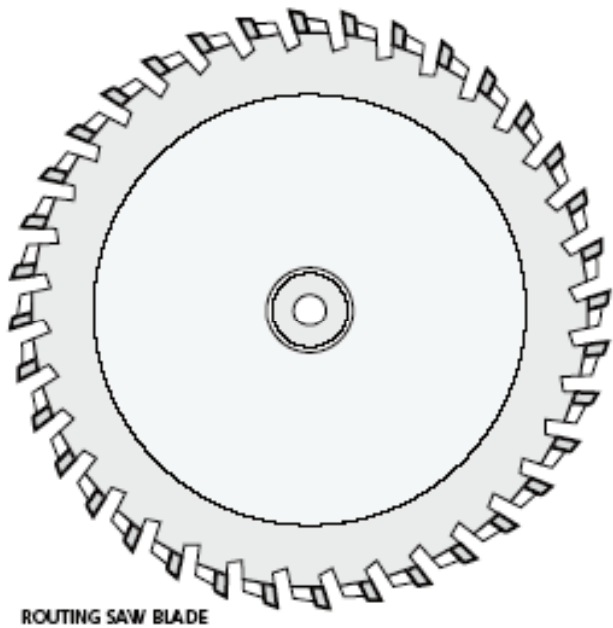
Router and Trimmer Tools

Use the bit as shown in the drawings below, which corresponds to the cut diagrams above.

Number of teeth	2 - 4
Rotation speed	20,000 - 30,000 rpm
Feeding speed	10 - 16 ft/min.
Material	Carbide

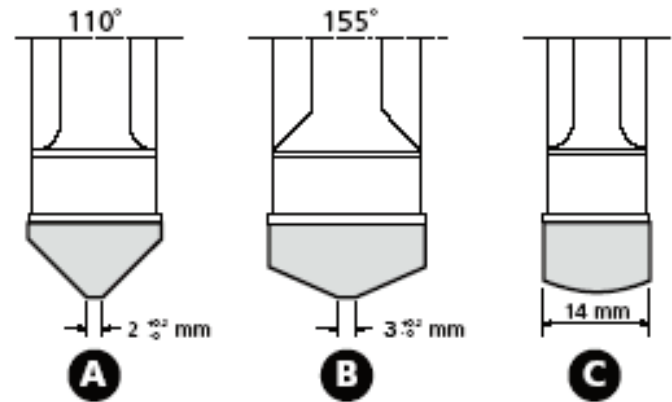
Saw/Milling Cutters

Carbide Tip Saw Example	
Outside diameter	12" 0
Number of teeth	36 (saw) 8 (grooving)
Rotation speed	3,000 - 5,000 rpm (variable motor)
Feeding speed	16 ft/min.



Observe the following recommendations in ‘V’ or ‘U’ cut processing:

The ‘V’ or ‘U’ cut bottom should not reach to the back of the aluminum. Leave about 0.008 - 0.016” of polyethylene core.



Bending

SIGNABOND® should be processed on a flat surface, void of irregularities, to insure consistency in the depth of the ‘V’ or ‘U’ grooving. This will insure a smooth clean edge when bent.

If available, a plate or break press should be used to bend processed SIGNABOND®. When this is not possible a simple bending jig made of wood or metal is recommended.

WhenSIGNABOND® is processed with a ‘V’ groove and bent at 90°, the finished panel dimension will increase by approximately 1/8”. This should be factored into the panel dimensions before final fabrication. It is advisable to do a preliminary test to insure the proper adjustment necessary.

