



ACRIFIX® Service Product

ACRIFIX® CA 0020

Hardener for 2-component polymerization adhesives

Product and Use

Type of service product

Hardener for 2-component polymerization adhesives based on methyl methacrylate.
Crystal clear, slightly yellow liquid, highly fluid.

Applications

Hardener (preferentially added at 3 %) for 2-component ACRIFIX® polymerization adhesives based on methyl methacrylate.

Storage/Transport

Keep container tightly closed in a cool, dark place.
UN 3082

Working Instructions

ACRIFIX® CA 0020 can be dosed according to volume by means of a graduated pipette, a burette, a disposable syringe or, best of all, by means of a dispenser. Attention: for volume-based dosage with pipettes/ burettes at cool ambient temperatures, please observe any tailings. However, it can also be dosed according to mass using commercially available laboratory scales.
The required amount of hardener at room temperature (18 to 25 °C) is 3 %. At lower ambient temperatures and for special adhesive compositions, the required amount of hardener may be up to 6 %.

ACRIFIX® CA 0020 is stirred into the adhesive by hand, using a stirring rod made of glass, PLEXIGLAS® or stainless steel (free from copper!).

If larger quantities of adhesive are used (> 200 g), an electrically or pneumatically operated agitator should be used. Stirring is performed by means of a stainless-steel propeller or, better still, with a stainless-steel stirrer blade (see picture). Since this type of blade is not commercially available, it must be made by the operator from approx. 5 mm thick stainless steel. The stirring period should be approx. 2-3 minutes, the adhesive mix should be free of streaks. Bonded parts can be further treated 3 to 6 hours after curing.

The bonds only acquire their final strength after about 24 hours or after **immediate** annealing as soon as the adhesive has cured.

More Information

Once the shelf life of ACRIFIX®CA 0020 has expired, the response time of the adhesive can deteriorate significantly.

For more details please see the Guideline "Joining, Ref. No.: 311-3".



Propeller agitator and stirrer blade



Limitation of Liability

Our ACRIFIX® adhesives and other service products were developed exclusively for use with our PLEXIGLAS® products and are specially adjusted to the properties of these materials. Any recommendations and guidelines for workshop practice therefore refer exclusively to these products.

Claims for damages, especially under product liability laws, are ruled out if made in connection with the use of products from other manufacturers.

Safety Measures and Health Protection

For further information on safety measures, the exclusion of health risks when handling adhesives and on their disposal, see our Safety Data Sheet.

Availability according to the current sales range.

Typical Values

Properties	Values
Viscosity; Brookfield II/6/20 °C	140 mPa • s
Density (20 °C)	~ 1.12 g/cm ³
Refractive index n _D ²⁰	~ 1.53
Color	Crystal clear, slightly yellow
Flash point	n.a.
Solids content	approx. 5 %
Storage stability	9 months after filling, if correctly stored
Storage temperature	max. 30 °C, min. 5 °C
Packaging materials	colored glass and aluminum
Cleaning agents for equipment	ethyl acetate

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® = registered trademark

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