

ACRIFIX® AC 0032

Activator for curing 5–component polymerization adhesive ACRIFIX® 5R 0194

Product and Use

Type

Activator for curing 5–component polymerization adhesive ACRIFIX® 5R 0194.

Clear, slightly greenish solution for completing the polymerization reaction of ACRIFIX® 5R 0194 (upon addition of ACRIFIX® PR 0031, ACRIFIX® CL 0033 and ACRIFIX® CA 0030).

Applications

Preferably used for clear butt joints and for large–area laminates of thick PLEXIGLAS® GS blocks in the aquarium construction sector.

The cured joints are virtually colorless and contain extremely low proportions of residual solvent after annealing.

Storage/Transport

Keep container tightly closed in a cool, dry place.
UN 1760

Working Instructions

Weigh ACRIFIX® CA 0030 and ACRIFIX® PR 0031 separately and add to ACRIFIX® 5R 0194 one after the other. Add ACRIFIX® AC 0032 last. Stir the adhesive composition after adding each individual component until no more striation is visible. The recommended mixing ratio of the additional components ACRIFIX® CA 0030, ACRIFIX® PR 0031, ACRIFIX® CL 0033 and ACRIFIX® AC 0032 must be strictly observed.

Please note: ACRIFIX® CA 0030 and ACRIFIX® AC 0032 must not enter into contact with each other in their concentrated form, since they may react explosively.

In the covered container, entrapped air bubbles will rise to the surface of the adhesive, but they can also be eliminated in a vacuum desiccator (min. 200 mbar). As soon as the adhesive becomes thick and noticeably warm (end of pot life), it should no longer be used.

For further details, consult the Product Description leaflet for ACRIFIX® 5R 0194 and our Guidelines for Workshop Practice „Joining PLEXIGLAS®“.

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.

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, 20 °C):	~ 40 mPa · s
Density (20 °C):	~ 1.04 g/cm ³
Refractive index n _D ²⁰ :	~ 1.44
Color	clear, slightly greenish
Flash point (ASTM D93):	~ 109 °C
Storage stability:	1 year after filling, given correct storage
Packaging materials:	glass and polyethylene
Cleaning agents for equipment:	acetone, ethyl acetate
Storage temperature: max.	30°C

Curing

System:	5-component polymerization adhesive
Recommended mixing ratio:	95.7 parts ACRIFIX® 5R 0194 0.5 parts ACRIFIX® CA 0030 0.3 parts ACRIFIX® PR 0031 3.0 parts ACRIFIX® AC 0032 0.5 parts ACRIFIX® CL 0033 Dilution with up to 20 % ACRIFIX® TC 0030 is possible.
Curing time (at 200 g adhesive, 20 °C):	60 to 80 min
Pot life (at 200 g adhesive, 20 °C):	20 to 30 min

Safety Measures and Health Protection

Labeling according to Regulation (EC) 1272/2008

Danger: contains monobutyl phosphite



Causes severe skin burns and eye damage. (H314)

Wear protective gloves/protective clothing/eye protection/ face protection. (P280)

IN CASE OF CONTACT WITH EYES: Rinse cautiously with water for several minutes. Remove contact lenses, if present and easy to do. Continue rinsing. (P305+P351+P338)

IF ON SKIN (or hair): Remove/take off immediately all contaminated clothing. Rinse skin with water/shower. (P303+P361+P353)

IF SWALLOWED: Rinse mouth. Do NOT induce vomiting. (P301+P330+P331)

Immediately call a POISON CENTER or doctor/physician. (P310)

Dispose of contents according to local disposal regulations. (P501)

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Evonik is a worldwide manufacturer of PMMA products sold under the PLEXIGLAS® trademark on the European, Asian, African and Australian continents and under the ACRYLITE® trademark in the Americas.

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