

## ACRIFIX® SO 0016

### Surface smoothing additive

#### Product and application

##### Description

Surface smoothing additive  
(clear, colorless, low-viscosity liquid)

##### Applications

To improve the surface smoothness of ACRIFIX® 2R 2016, particularly in the case of internal fillet joints and especially in showcase construction.

##### Processing instructions

ACRIFIX® SO 0016 can be dosed by volume with a measuring pipette or disposable syringe, or preferably with a dosing device (dispenser).

Caution: With volumetric dosing using pipettes or burettes residual liquid must be taken into account, particularly at lower ambient temperatures.

Dosing by mass is also possible using a commercial laboratory balance. **The proportion added to ACRIFIX® 2R 2016 must not exceed 5 %.**

ACRIFIX® SO 0016 is stirred into the adhesive manually, using a stirring rod made of glass, PLEXIGLAS®, or stainless steel (that must not contain copper). For larger amounts of adhesive (> 200 g) an electric or pneumatic stirrer motor should be used with a stainless steel propeller stirrer or preferably a stainless steel stirrer blade (see figure). Since this type of closed blade is not commercially available, it must be fabricated individually from stainless steel of about 3–5 mm thickness.

The stirring period is about 2–3 minutes; the adhesive batch should be free from streaks.

After the ACRIFIX® SO 0016 has been stirred in, the appropriate amount of ACRIFIX® CA 0020 curing agent can be added.

Further processing of the bonded parts is possible 3 to 6 hours after curing.

The bonded joint will attain its final strength only after about 24 hours, or upon annealing if this is carried out **immediately** after the adhesive is cured.

**With addition of ACRIFIX® SO 0016, the bonded joints are suitable for indoor use only and are not designed for contact with water. Being exposed to water the joint becomes white.**

With increasing ACRIFIX® SO 0016 content the yellowness of the joint may intensify.

For further details, see our Guidelines “Joining, Ref. No. 311–3”.

### Limitation of liability

Our ACRIFIX® adhesives and our other service products have been developed exclusively for our PLEXIGLAS® products and are specially adjusted to the properties of these materials. All recommendations and processing information 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.**

**Further information on safety measures, health protection, and disposal that is beyond the scope of this product description is available in our safety data sheet.**

Availability according to the current sales range.

### Tensile shear strength ( $v = 5 \text{ mm/min}$ ):

Material (to itself)	annealed	
	non-annealed	(5 hours at 80°C)
Cast acrylic:	35 to 39 MPa	45 to 50 MPa
Extruded acrylic:	34 to 38 MPa	40 to 48 MPa

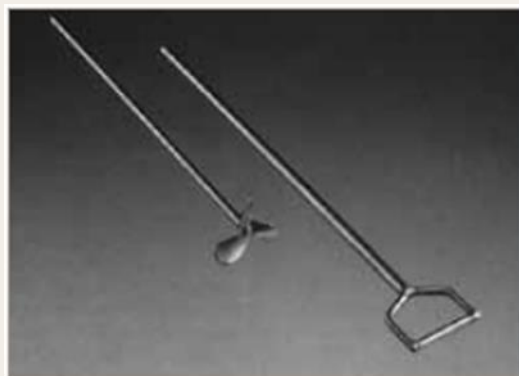
The strength values refer to addition of 5% ACRIFIX®SO 0016 to ACRIFIX®2R 2016

### Typical values

Property	Values
Viscosity (Brookfield, 25 °C)	32,7 mPa · s
Density (20°C):	~ 1,05 g/cm <sup>3</sup>
Refractive index $n_D^{20}$ :	~ 1.442
Flash point (ASTM D93):	217,9°C
Shelf life:	3 years from filling if correctly stored
Storage temperature:	max. 35°C
Packaging materials:	aluminum
Cleaning agent for equipment:	ethyl acetate

### Safety measures and health protection

**Labeling according to Regulation (EC) 1272/2008**  
**Not a dangerous substance or mixture under Regulation (EC) No. 1272/2008**



Propeller stirrer and stirrer blade

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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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