

### Hardener for 2-component polymerization adhesives

#### Product and Use

##### Type

Hardener for 2-component polymerization adhesives based on methyl methacrylate. Clear, colorless to slightly yellowish liquid of low viscosity.

##### 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-No. 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.

##### Other:

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"

##### Limitation of Liability

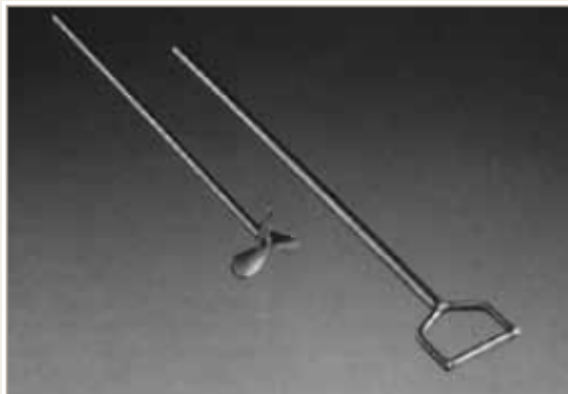
Our ACRIFIX® adhesives and other service products were developed exclusively for use with our PLEXIGLAS® products and are specially adjusted to the properties of these materials. Any recommendations and guidelines for workshop practice therefore refer exclusively to these products.

**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.



Propeller agitator and stirrer blade

### Safety Measures and Health Protection

#### Labeling according to Regulation (EC) 1272/2008

Warning: contains dibenzoyl peroxide; benzoyl peroxide, oxydipropyl dibenzoate



May cause an allergic skin reaction. (H317)

Suspected of damaging fertility or the unborn child if inhaled. (H361)

Very toxic to aquatic life. (H400)

Harmful to aquatic life with long lasting effects. (H412)

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

Avoid release to the environment. (P273)

Avoid breathing dust/fume/gas/mist/vapours/spray. (P261)

If skin irritation or rash occurs: Get medical advice/attention. (P333+P313)

IF IN CONTACT WITH SKIN: Wash with plenty of soap and water. (P302+P352)

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

### Typical Values

Properties	Values
Viscosity (Brookfield I/30/20 °C)	180 mPa · s
Density (20 °C):	~ 1.12 g/cm <sup>3</sup>
Refractive index n <sub>D</sub> <sup>20</sup> :	~ 1.53
Flash point DIN 51758:	n.a.
Solids content:	ca. 5 %
Storage stability:	9 months after filling, if correctly stored
Storage temperature:	max. 30 °C
Packaging materials:	aluminum, colored glass
Cleaning agents for equipment:	ethyl acetate
Storage temperature:	max. 30° C, min. 5°C

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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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Ref.-No. 391-24 September 2015