



ACRIFIX® Service Product

ACRIFIX® MO 0070

Reaction moderator for 2-component polymerization adhesives

Product and Use

Type of service product

Reaction moderator for 2-component polymerization adhesives, preferentially ACRIFIX® 2R 0190. Clear, purplish, highly fluid liquid with a citrus-like odor added to polymerization adhesives in order to dampen the polymerization reaction.

Applications

To avoid bubble formation (due to shrinkage or over-heating) as a result of excessive heat generation in **thick layers** of polymerization adhesives. Recommended for hollow seams, prevents bubble formation at top of hollow seams.

For commercial use only.

Storage/Transport

Keep container tightly closed in a cool place. Not classified as dangerous in the meaning of transport regulations

Working Instructions

When applying adhesive layers of approx. 3 mm upward and when bonding large surfaces, bubbles often form as a result of too rapid polymerization. In such cases, ACRIFIX® MO 0070 can be used to slow down polymerization and thus prevent bubble formation due to shrinkage and over-heating.

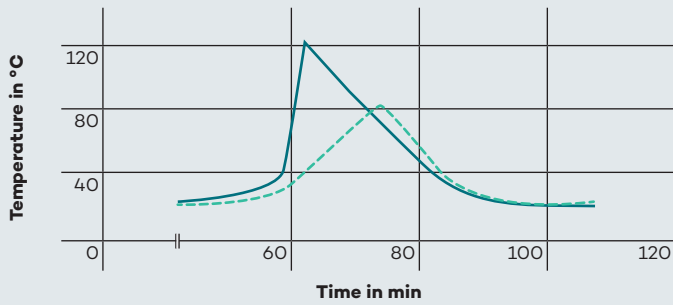
The temperature of the parts to be bonded, of the adhesive and the ambient temperature must not drop below 20 °C. Stir ACRIFIX® MO 0070 into the polymerization adhesive before adding the hardener (ACRIFIX® CA 0020). The added quantity should be kept as small as possible and should not exceed 0.3 %.

If necessary, the minimum concentration should be determined in prior tests. Weigh the amount of product to be added to the adhesive composition or, in view of the small quantity, count the number of drops you add (40 drops with supplied pipette correspond to about 1 g). The figures show the influence of ACRIFIX® MO 0070 on the polymerization of ACRIFIX® 2R 0190. At rising concentrations of ACRIFIX® MO 0070, the cured adhesive becomes increasingly yellow and bond strength decreases. Bond strength can be slightly improved by annealing (for about two hours at approx. 70 to 80 °C) as soon as the adhesive has cured. The higher the temperature and the longer the annealing period, the more pronounced yellowing becomes. Heating must be performed gradually (10 °C per hour at most) to avoid bubble formation.

For more details see our Guidelines "Joining, Ref. No.: 311-3"

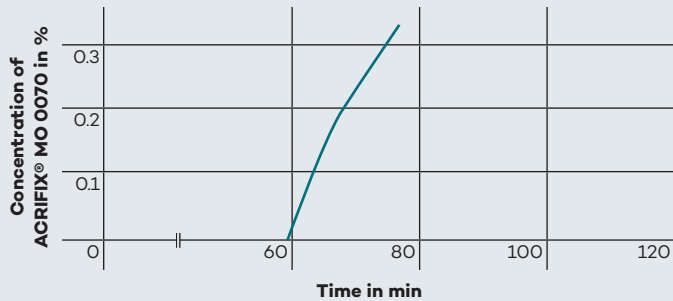


Influence on the polymerization temperature profile of ACRIFIX® 2R 0190



- ACRIFIX® 2R 0190 + 3 % ACRIFIX® CA 0020
- ACRIFIX® 2R 0190 + 0,3 % ACRIFIX® MO 0070 + 3 % ACRIFIX® CA 0020

Influence on the polymerization time of ACRIFIX® 2R 0190



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, Brookefield, A/60/20°C	~ 17 mPa • s
Density (20 °C)	~ 1.03 g/cm ³
Color	dark purple, clear (harmless color changing may occur during storage)
Flash point ASTM D93	78 °C
Storage stability	unlimited in original container
Storage temperature	max. 30°C
Packaging materials	colored glass, aluminum
Cleaning agents for equipment	ACRIFIX® TC 0030, ethyl acetate
Concentration employed	0.05 to 0.3 %, preferably 0.1% in ACRIFIX® 2R 0190 at 3 to 4 % ACRIFIX® CA 0020 (conduct prior tests with other polymerization adhesives)

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® = registered trademark

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