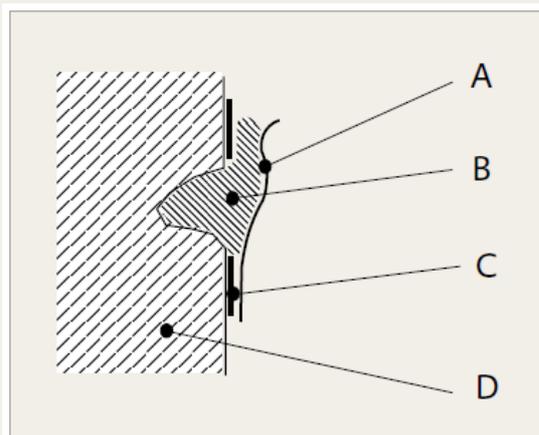


ACRIFIX® 2R 0150

2-Component Polymerization Adhesive



- A = Polyester or cellophane film
- B = ACRIFIX® 2R 0150
- C = Adhesive tape
- D = Acrylic glass – sanitary ware item

Product and Use

Type

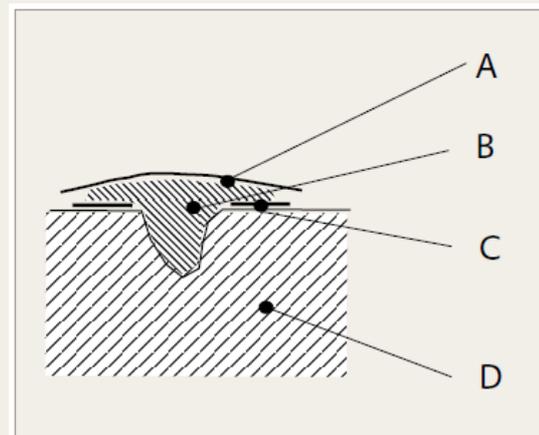
2-Component polymerization adhesive. ACRIFIX® 2R 0150 is a colored structural viscose compound on an acrylic base, which cures upon addition of benzoyl peroxide powder.

Applications

ACRIFIX® 2R 0150 is employed for repairing surface damage to sanitary ware items made from acrylic glass.

Storage/Transport

Keep in the original container, in a cool and dry place.
UN 1133



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Working Instructions

Preparation of the site to be repaired

The site to be repaired should be treated with a milling cutter so as to permit good application of ACRIFIX® 2R 0150 and to avoid air pockets that might impede curing. For cleaning the repair site, we recommend ACRIFIX®TC 0030 or isopropyl alcohol (drugstore). The surrounding area should be protected by means of adhesive tape to prevent it from swelling due to ACRIFIX® 2R 0150.

Preparing ACRIFIX® 2R 0150

The contents of the capsule enclosed in the indented lid are added to the ACRIFIX® 2R 0150 acrylic polymer compound in the aluminum can. Separate the two halves of the capsule by twisting gently. Mixing is performed in such a way that as few air bubbles as possible get into ACRIFIX®

2R 0150. Stir for about 2 minutes with a stirring rod made from PLEXIGLAS® or stainless steel (no non-ferrous metal!). The thin-bodied ACRIFIX® 2R 0150 compound can be used straight afterwards or left to stand for about 10 to 15 min. It achieves a viscose structure and can also be applied to vertical surfaces, if necessary with the help of a makeshift bag made from polyester film (see figures).

Repair method

Repair sites with damage going right through to the GRP or other backing should first be thinly coated with ACRIFIX® 2R 0150 compound and aired for 5 to 10 min so as to obtain a coherent film. This avoids the inclusion of air cavities in the repair site. ACRIFIX® 2R 0150 is applied by gentle dabbing beyond the damaged site, so that no air bubbles can get into it. These would lead to the formation of pinholes / air pockets, usually calling for a second repair process.

After applying the ACRIFIX® 2R 0150 compound, the repair site is covered with polyester or cellophane film to enhance curing of the surface. If applied generously enough, ACRIFIX® 2R 0150, after being covered with film, should spread to about 5 mm beyond the repair site (see figures). Any remaining ACRIFIX® 2R 0150 compound is left to cure in the container and is disposed of as household or commercial waste. The curing period is 1 hour at 20 to 25 °C. It can be reduced by blowing gently and carefully with a hairdryer, but make sure that the repair site does not become hot (max. 40 °C). This measure is particularly recommended at ambient temperatures of less than 15 °C. Should the repaired site be lower than the surrounding area (due to natural shrinkage), the repair process must be repeated, i.e. a fresh mixture of ACRIFIX® 2R 0150 must be applied.

Final treatment

After curing, the ACRIFIX® 2R 0150 compound protruding beyond the repair site is best removed by means of a miniature drill and a suitable milling cutter or scraper, and by sanding the repair site with 400- to 1000-grit wet abrasive paper. The use of Micro Mesh®, a range of high-quality abrasive paper that provides excellent results, can

also be recommended. Thereafter, the repaired surface is high-gloss polished with a soft woolen cloth (e.g. glove-lining fabric) to which some "Acrylglas POLIER + REPAIR Paste" (acrylic polishing and repair paste) has been applied. If polishing is performed with a buffing wheel, ensure that the surface does not get too hot, because this can provoke stress in the material that might lead to cracking of the surface. Matte sanitary ware surfaces need not be polished after sanding with 600-grit abrasive paper.

Miscellaneous

The color of ACRIFIX® 2R 0150 is as close as possible to the original sanitary ware shade. However, due to the different manufacturing conditions for sanitary ware and ACRIFIX® 2R 0150, there may be fluctuations in color, particularly with white sanitary ware shades. The color of cured ACRIFIX® 2R 0150 may also change slightly, especially if unskillfully cured.

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:	viscose structure
Density (20 °C):	~ 1.02 g/cm ³
Refractive index n _D ²⁰ :	~ 1.44
Color:	on request
Flash point DIN 53213:	~ 10 °C
Solids content:	26 ± 1 %
Storage stability:	4 years after filling, if correctly Stored
Storage temperature: max. 30°	
Packaging materials:	Aluminum can
Cleaning agents for equipment:	ACRIFIX® TC 0030 or ethyl acetate
Curing time/pot life (20 °C):	60 min. 25 min. (after mixing contents of 15g aluminum can and hardener capsule)

Safety Measures and Health Protection

Labeling according to Regulation (EC) 1272/2008

Danger, contains methyl methacrylate.



Highly flammable liquid and vapour. (H225)

Causes skin irritation. (H315)

May cause an allergic skin reaction. (H317)

May cause respiratory irritation (H335).

Keep away from heat/ sparks/open flames/hot surfaces. — No smoking. (P210)

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

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

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

Dispose of contents/container in accordance with local regulation. (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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