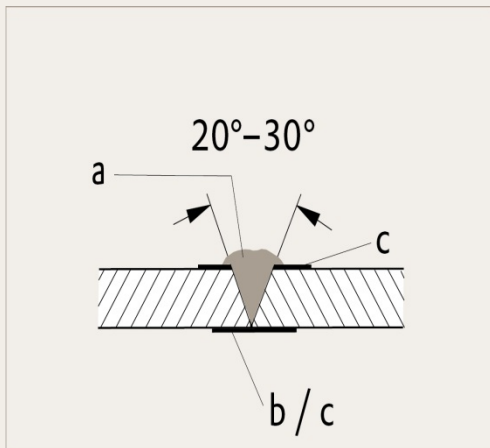


Technical Information

## ACRIFIX® 2R 0195

### 2-Component Polymerization Adhesive

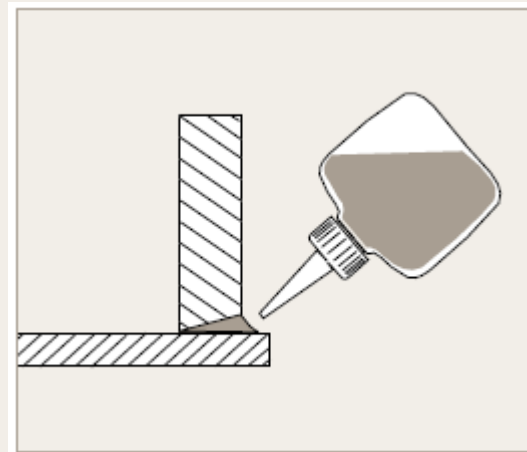


V-groove:

a = Adhesive

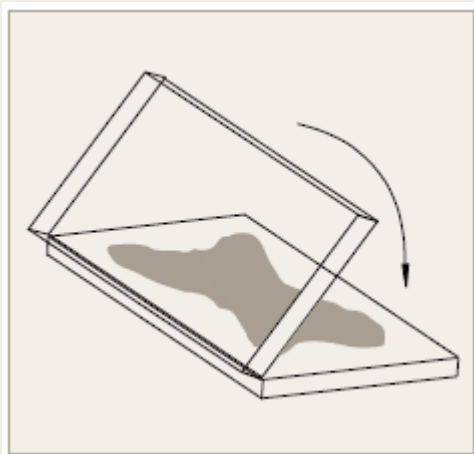
b = Adhesive tape with nonadhesive center strip

c = Adhesive polyester or PE-tape



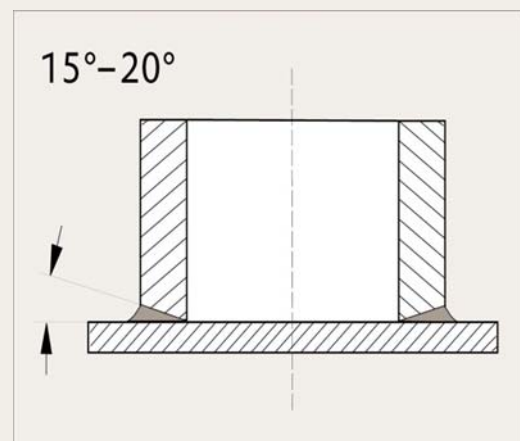
Angle joint:

Application of adhesive by PE glue dispenser



Area bonding:

Apply adhesive as a four-lobed dollop; fold down cover carefully from the edge.



Bonding a tube end

## Product and Use

### Type

2-Component polymerization adhesive.  
Viscous, thixotropic solution of an acrylic resin in methyl methacrylate, which polymerizes completely upon addition of ACRIFIX® CA 0020.

### Applications

Preferably used for bonding **satin** acrylic (PMMA), e.g. PLEXIGLAS® **Satinice SC** and **DC** with one another, but also for other materials such as ABS, CAB, PC, PS, PVC and wood.

The cured adhesive joint have a matt appearance.

### Storage/Transport

Store, tightly closed in a cool location.

UN 1133

### Working Instructions

#### Preparing the Parts to Be Bonded

Degrease the surfaces with ACRIFIX® TC 0030, isopropyl alcohol or petrol ether. Internally stressed parts must be annealed before bonding in order to avoid stress cracking. The annealing conditions depend on the type of material, the degree of forming and the thickness of the parts to be bonded. Parts made of extruded or injection molded acrylic should be annealed as a matter of principle. Typical annealing times (at 3mm material thickness) are 2 to 4 hours in an airflow oven at 70 to 80 °C – also for cast acrylic. For further details, consult our Guidelines for Workshop Practice „Joining PLEXIGLAS®“.

#### Preparing the Adhesive

ACRIFIX® 2R 0195 must be stirred before use! Mix ACRIFIX® 2R 0195 with max. 3 % ACRIFIX® CA 0020, avoiding entrapment as far as possible. In the covered container, any air bubbles may be allowed to rise to the surface of the adhesive, but they can also be removed in a vacuum desiccator (min. 200 mbar).

As soon as the ACRIFIX® 2R 0195 mixture becomes thick and noticeably warm (end of pot life), it should be discarded.

#### Bonding Technique

Fix the parts to be bonded in the desired position

and apply suitable adhesive tape to seal the joint and to protect surrounding areas if necessary (see drawings). Introduce ACRIFIX® 2R 0195 into the joint either directly from the mixing vessel or by means of a glue dispenser or disposable syringe, avoiding air entrapment as far as possible.

### Other Measures

Roughing with abrasive paper (grit 230 to 320) improves the adhesion to untreated surfaces of cast acrylic. Severely stressed bonds or bonds intended for outdoor exposure should be annealed for 2 to 4 hours at 70 to 80 °C **immediately** after curing.

ACRIFIX® 2R 0195 must not get into closed cavities, since the curing process is severely hampered in these places and stress cracking in the bonded parts may be the result.

For tube bonding, it recommended to gently blow air into the tube inner during adhesion.

ACRIFIX® 2R 0195 may be colored with ACRIFIX® CO 9073, CO W074, CO 3075, CO 5076, CO 1077, for example.

For more details see our Guideline “Joining, Ref. No. 311–3”.

### Properties of Bonds

#### Further treatment of bonded parts:

3 to 6 hours after curing

#### Tensile shear strength

(v = 5 mm/min; butt joint of PLEXIGLAS® **Satinice SC** or **DC** with itself):

non-annealed: 35–40 MPa

annealed (5 hrs at 80 °C): 40–45 MPa

### Appearance

Fine matte surface, slight yellowing possible, especially when using >3% ACRIFIX® CA 0020.

### Limitation of Liability

Our ACRIFIX® adhesives and other auxiliary agents 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:	pourable
Density (20 °C):	~ 1.02 g/cm <sup>3</sup>
Refractive index n <sub>D</sub> <sup>20</sup> :	~ 1.44
Color:	slightly purplish, milky
Flash point (DIN 53213):	~ 10 °C
Solids content:	~ 29 %
Storage temperature:	max 30°C
Storage stability:	2 years in original container at 20 °C
Packaging materials:	Aluminum and colored glass
Thinner:	ACRIFIX® TC 0030, max. 10 %
Cleaning agents for equipment:	ACRIFIX® TC 0030 or ethyl acetate
Curing / pot life (at 200 g adhesive, 20 °C) with: 3 % ACRIFIX® CA 0020:	~ 60 min / ~ 20 min

### Safety Measures and Health Protection

Labeling according to Regulation (EC) 1272/2008  
Danger: methylmethacrylate, thioglycolic acid 2-ethylhexyl ester



Highly flammable liquid and vapour. (H225)

Causes skin irritation. (H315)

May cause an allergic skin reaction. (H317)

May cause respiratory irritation. (H335)

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

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

Call a POISON CENTER or doctor/physician if you feel unwell. (P312)

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

IF INHALED: Remove victim to fresh air and keep at rest in a position comfortable for breathing. (P304+P340)

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

® = registered trademark PLEXIGLAS and ACRIFIX are registered trademarks of Evonik Röhm GmbH, Darmstadt, Germany. Evonik Röhm GmbH is certified to DIN EN ISO 9001 (Quality) and DIN EN ISO 14001 (Environment).

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.

This information and all further technical advice is based on our present knowledge and experience. However, it implies no liability or other legal responsibility on our part, also with regard to existing third party intellectual property rights, especially patent rights. In particular, no warranty, whether express or implied, or guarantee of product properties in the legal sense is intended or implied. We reserve the right to make any changes according to technological progress or further developments. The customer is not released from the obligation to conduct careful inspection and testing of incoming goods. Performance of the product described herein should be verified by testing, which should be carried out only by qualified experts in the sole responsibility of a customer. Reference to trade names used by other companies is neither a recommendation, nor does it imply that similar products could not be used.

### Evonik Performance Materials GmbH

Acrylic Polymers

Kirschenallee, 64293 Darmstadt, Germany

[info@plexiglas.net](mailto:info@plexiglas.net) [www.plexiglas.net](http://www.plexiglas.net) [www.evonik.com](http://www.evonik.com)

Ref.-No. 391-28 September 2015