

ACRIFIX® TC 0030

Thinner and cleaner for all polymerization adhesives

Product and Use

Type

Methyl methacrylate; clear, thin-bodied

Applications

Thinner and cleaner for all polymerization adhesives.

Storage/Transport

Keep container tightly closed in a cool place.

UN 1247

Working Instructions

The viscosity of the adhesives is adjusted so as to allow their direct use in most cases. However, for certain applications it is helpful to dilute the adhesives beforehand, i.e. to reduce their viscosity:

- More rapid degassing because air bubbles rise to the surface quicker in diluted adhesive – advantageous for large quantities of adhesive composition.
- Better leveling, thinner adhesive layers and somewhat delayed skin formation – advantageous for bonding large surfaces (particularly of thin sheets).
- Better wetting out and degassing when embedding fiber mats and woven fabrics.
- More rapid filling of butt joints between thick blocks.
- Diluted adhesives enable shorter pot lives and polymerization times (at higher hardener concentration), because degassing and processing can be performed more quickly than with undiluted polymerization adhesives. The viscosity

required for a specific application must be determined by trial and error. In general, adhesives should be diluted as little as possible; the maximal addition of ACRIFIX®TC 0030 should be 10%; for thinners of >10%, ACRIFIX®TH 0032 should be used for ACRIFIX®2R adhesives.

The hardener concentration (e.g. ACRIFIX® CA 0020) depends on the quantity of diluted adhesive.

The influence of the thinner on viscosity and polymerization can be seen in the corresponding pictures.

Other Measures

ACRIFIX® TC 0030 is well-suited **for degreasing PLEXIGLAS® surfaces prior to bonding**. These are best wiped down with a piece of washed glove lining fabric or uncolored kitchen roll towel soaked with ACRIFIX® TC 0030.

Polymerization shrinkage increases with higher thinning. In case of strong thinning, surface structures may occur after curing.

Avoid cleaning of PLEXIGLAS® Resist versions with ACRIFIX® – risk of wipe marks; rather clean with petrol ether or isopropanol.

For more information see our 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.

Typical Values of Properties

Properties	Values
Viscosity; Brookf., II/6/20 °C	~0.6 mPa · s
Density (20 °C):	~0.94 g/cm ³
Refractive index n _D ²⁰ :	~ 1.415
Color	clear and colorless
Boiling point	~ + 100 °C
Flash point; DIN 51755	~ + 10 °C
Explosion limits in air	2.1 to 12.5 Vol.%
Storage stability:	2 years after filling, given correct storage
Storage temperature:	Max. 30 °C
Packaging materials:	aluminum and colored glass

Safety Measures and Health Protection

Labeling according to (EC) 1272/2008

Reach No.: 01-2119452498-28-0000

Danger, contains methyl methacrylate



Highly flammable liquid and vapour. (H225)

Causes skin irritation. (H315)

May cause an allergic skin reaction. (317)

May cause respiratory irritation. (H335)

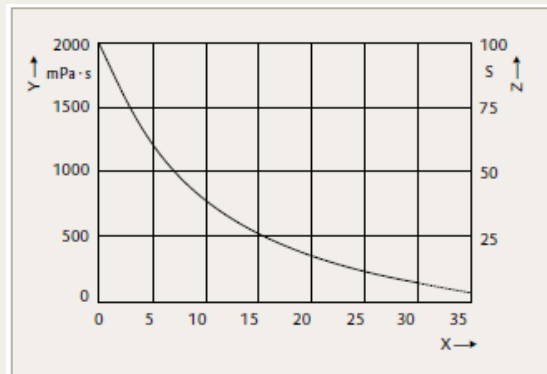
Keep away from heat/ sparks/open flames/hot surfaces. — No smoking. (P210)

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

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

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

Dispose of contents in accordance with local regulation. (P501)

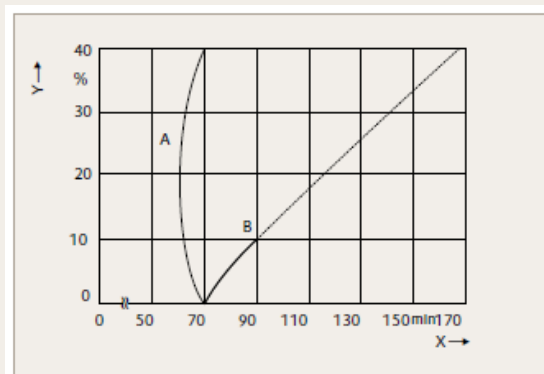


Viscosity of ACRIFIX® 2R 0190

X = Thinner concentration

Y = Viscosity

Z = Efflux time/6mm cup



Influence of thinner concentration on polymerization time of ACRIFIX® 2R 0190 + 3% ACRIFIX® CA 0020 (on diluted adhesive)

X = Polymerization time

Y = Thinner-concentrate

A = ACRIFIX® TH 0032

B = ACRIFIX® TC 0030

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Evonik Röhm GmbH is certified to DIN EN ISO 9001 (Quality) and DIN EN ISO 14001 (Environment).

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