



TECHNICAL INFORMATION

ANGLOSOL[®] CEMENT 70 PART A & B

INTRODUCTION

Anglosol[®] Cement 70 is a two-part acrylic adhesive (cement) that hardens at room temperature by polymerisation. Component A is a mobile monomer / polymer syrup and Component B is a liquid catalyst solution.

Anglosol[®] Cement 70 has been developed especially for bonding / fabricating / cementing cast acrylic sheet (Perspex). It will bond cast acrylic (Perspex) materials to other material, such as wood. For further advice, please contact the Technical Department at Anglo Adhesives Ltd.

The product is specifically used for outdoor / external applications e.g. sign making etc.

SAFETY

IMPORTANT:

Before embarking on any work involving **Anglosol[®] Cement 70**, the Safety Data Sheet should be carefully studied by those carrying out the work. Component A of **Anglosol[®] Cement 70** is flammable. So there must be no smoking or naked flames in the area where **Anglosol[®] Cement 70** is being used.

METHOD OF USE

Preparation:

Surfaces to be coated should be clean, dry and free from dust and grease.

Temperature:

Anglosol[®] Cement 70 Component A must be at room temperature i.e. 16 – 20°C. If it has been stored below 15°C it must be allowed to come to room temperature naturally. This can take several hours.

Mixing:

Add 1 part of Component B to 20 parts of Component A and stir thoroughly but slowly to avoid air bubbles occurring (parts by weight or volume can be used). The cement will not polymerise (harden) properly if different portions of the catalyst (Component B) are used. If only small volumes of the cement are needed, dispense one drop of Component B directly from its container for every one gram (1 ml) of Component A. Always use the **Anglosol[®] Cement 70** Mixing and Application kit.

Hardening begins as soon as the catalyst (Component B) is added. Use the mixed cement within 20 (twenty) minutes, otherwise the bond will be weakened.

After mixing, cover the vessel and leave it until the larger air bubbles have risen to the surface. Remember that the bubbles should be allowed to rise and the job completed in 20 (twenty) minutes of adding the catalyst.

Hardening / Curing:

Cementing operations should not be undertaken at temperatures below 15°C as the setting time can be affected. Ideally, the temperature should be 20 +/- 5°C.

Setting begins as soon as the catalyst is added and the cement should be hard within 1½ - 2 hours. After this time, the joint may be handled carefully. Light machining is possible after 4 hours but a better finish and stronger joint will be obtained if left for 24 (twenty-four) hours.

NOTE:

IF THE PART B HAS “YELLOWED” THE CURE TIME WILL BE EXTENDED.

PROPERTIES OF JOINTS

Once set, the cement continues to harden for some time – after several days the bond strength should be adequate for most applications. However, the strength of joints can be increased further by heat treatment.

Non-thermoformed components – heat for 3 – 4 (three to four) hours at 80°C.

Thermoformed, highly stretched components – heat for 4 – 5 (four to five) hours at 70°C.

Do not heat components until at least one hour after the cement has set.

Gap Filling:

Because of its low viscosity, the gap-filling properties of the cement are limited. Special masking techniques will be needed to keep the cement in place if large gaps are to be filled. In addition, the cement shrinks in volume by 20% as it hardens, so cavities need to be over-filled to allow for this.

COLOUR

Component A has a slight purple tinge and Component B is a light straw colour. After prolonged outdoor exposure (years) in warm climates, a slight yellowing of the hardened cement may occur. This will not affect the mechanical properties of the cement.

SHELF LIFE

Component A of **Anglosol[®] Cement 70** is suitable for at least 12 months when stored in its original container, in a metal cabinet or other suitable store at a temperature below 20°C.

Component B should be stored as above at a temperature between 0 – 5°C. At lower temperatures (- 10°C) the catalyst may crystallise out of solution. It is important that all solid deposits should be re-dissolved before the solution is used. This should be done by carefully warming to about 20°C and shaking.

If Component B becomes deeply coloured (yellow/orange), the hardening time should be tested by mixing a small amount of both components. Obtain a new bottle of Component B if the cement sets slowly.

COVERAGE

1 m²/L

NOTE:

THIS ADHESIVE IS NOT RECOMMENDED FOR STRUCTURAL APPLICATIONS ON AIRCRAFT.

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Typical Characteristics		
	Part A	Part B
Polymer Base	Methyl Methacrylate	Peroxide
Solids	100%	5%
Viscosity	1,500 mPa.s	Liquid
Specific Gravity	1.0 approx	1.0 approx
Cleaner	4224 Thinner	N/A
Storage	5-25°C	5-25°C
Shelf Life	12 Months	12 Months

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