Anglo Adhesives & Services Ltd.

INDUSTRIAL ADHESIVE MANUFACTURERS - CONTRACT FILLING AND PACKAGING

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TECHNCIAL DATA SHEET

ANGLOSOL CEMENT 700 PART A & B

INTRODUCTION:

ANGLOSOL CEMENT 700 is a two part acrylic adhesive (cement) which hardens at room temperature by polymerisation. Component A is a mobile monomer / polymer syrup and Component B is a liquid catalyst solution.

ANGLOSOL CEMENT 700 has been developed especially for bonding / fabricating / cementing cast acrylic sheet (Perspex). It will bond cast acrylic materials (Perspex) to other materials such as wood. For further advise, please telephone the technical department at Anglo Adhesives & Services Ltd.
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The product is specifically used for outdoor external applications for sign making etc., The product can also be coloured if desired.

SAFETY:

Component A is flammable. There must be no smoking or naked flames in the area where ANGLOSOL CEMENT 700 is being used. Refer to Material Health & Safety data sheet for more information.

PART A	PART B
Polymer Base: Methyl Methacrylate	Peroxide
Cure Time: 24 – 48 hours	Cure Time: 24 – 48 hours
Coverage: 1m² per litre	Coverage: N/A
Specific Gravity: 1.2kg/Ltr	Specific Gravity: 1.2kg/Ltr
Viscosity: 4000 mPaS	Viscosity: Liquid
Solids: 100%	Solids: 5%
Cleaner / Thinner: Solvent M	Cleaner / Thinner: N/A
Shelf Life: 12 months	Shelf Life: 12 months
Storage: 5 – 30 °C	Storage: 5 – 30 °C
Nearest Alternative: Anglosol 1200	Nearest Alternative: N/A

METHOD OF USE:

IMPORTANT:

Before embarking on any work involving ANGLOSOL CEMENT 700 those carrying out the work should carefully study the Material Safety Data Sheet.

PREPARATION;

Temperature

ANGLOSOL CEMENT 700 COMPONENT A must be at room temperature ie. 16 – 20 °C (60 – 80 °F). If it has been stored below 15 °C (59 °F) it must be allowed to come to room temperature naturally, this could take several hours.

Mixing

Add 1 part of Component B to 20 parts Component A and stir thoroughly, but slowly to avoid air bubbles occurring (parts by weight or by volume can be used).

The cement will not polymerise (harden) properly if different proportions of the catalyst (Component B) are used. If only small quantities of the cement are needed, dispense one drop of Component B directly from its container for every one gram (1ml) of Component A. Always use the ANGLOSOL CEMENT 700 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 within 20 (twenty) minutes of adding the catalyst.

Hardening / Curing

Cementing operations should not be undertaken at temperatures below 15 °C (59 °F) as the setting time can be affected. Ideally the room temperature should be 20 °C +/- 5 °C (68 °F +/- 10°F).

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 it is left for 24 (twenty four) hours.

NOTE:
IF 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 (176 °F).

Thermoformed, highly stretched components – heat for 4 – 5 (four to five) hours At 70 °C (158 °F).

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 must 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 appear. This will not affect the mechanical properties of the cement.

Shelf Life

Component A of ANGLOSOL CEMENT 700 is suitable for at least 12 months when stored in its original container in a metal cabinet or other suitable store below 20 °C (68 °F).

Component B should be stored as above at 0 – 5 °C (32 – 41 °F). At lower temperatures (-10 °C, 14°F) 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 (68 °F) and shaking.

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

NOTE:
THIS ADHESIVE IS NOT RECOMMENDED FOR STRUCTURAL APPLICATIONS ON AIRCRAFT.

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