



ACRIFIX® 1S 0109

1-Component Solvent Adhesive

Product and Use

Type of Adhesive

1-Component solvent adhesive.
Highly viscous, transparent clear, physically curing.

Applications

Special adhesive for use in signage (Adhesion of letters). Preferentially used for bonding uncross-linked PLEXIGLAS® grades and injection moldings made from PLEXIGLAS® molding compound. The joint cross-section should not be too large.

ACRIFIX® 1S 0109 is not suitable for area bonding. ACRIFIX® 1S 0109 is sufficiently gap-filling, quickly forms a skin and shows no capillary action. It allows rapid subsequent treatment of the bonded items and provides high ultimate strength.

For commercial use only.

Storage/Transport

Keep container tightly closed in a cool place.
UN 1593

Working Instructions

The parts to be bonded do not need to fit perfectly, since ACRIFIX® 1S 0109 is sufficiently gap-filling. The parts to be bonded must be grease free. Cleaning with petroleum ether or isopropyl alcohol is recommended. For ease of processing, fill a small quantity of ACRIFIX® 1S 0109 into a glue dispenser, e. g. small polyethylene bottle with nozzle. The air bubbles produced disappear again after a short time. Place the parts to be bonded in the required position (not pressed together), then continuously apply ACRIFIX® 1S 0109 by means of the nozzle. The adhesive stops flowing after 1 to 2 minutes, enabling the parts to be further bonded in a different position.

More Information

Whitening around the adhesive joint is due to water condensing from the air (especially if the room temperature is low). The larger the cross-section of the joint, the more likely bubble formation is. It is recommended to let the joint air for one day before subsequently applying ACRIFIX® 2R 0190.

For more details please see our Guideline "Joining PLEXIGLAS®", Ref. No. 311-3

Properties of Bonds

Initial bond

PLEXIGLAS® with itself: ~ 5 to 10 sec

Subsequent treatment of bonded items

Although the parts fixed in relation to each other can be moved after only 1 to 2 minutes without changing the joint, the bonds only acquire good strength after about one hour. Subsequent treatment of bonded parts should not be performed until at least 10 to 12 hours later.

Strenght of Bonds

The bonds only acquire their final strength after about 24 hours or after immediate annealing as soon as the adhesive has cured.

Tensile shear strength ($v = 5 \text{ mm/min}$)

Material (to itself)	Non annealed	annealed (5 h at 80 °C)
PLEXIGLAS® GS OF00	19 - 29 MPa	30 - 40 MPa
PLEXIGLAS® XT OA000	17 - 27 MPa	20 - 30 MPa

Annealing increases the strength and also improves the weather resistance.

Appearance of Bonds

- Colorless, clear.
- Bubble formation possible,
- Bleeding of colorants.
in colored bonded items possible.

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.

Safety Measures and Health Protection

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; Brookfield II/6/20 °C:	3000 - 3400 mPa • s
Density (20 °C)	~ 1.3 g/cm ³
Refractive index n _D ²⁰	~ 1.44
Color	Transparent clear
Flash point; DIN 53213	no flash point
Solids content	12 - 15%
Storage stability	2 years after filling, if correctly stored
Storage temperature	max. 30 °C
Packaging materials	Colored glass and aluminum
Thinner	Dichloromethane
Curing	Physically, through evaporation and absorption in the bonded articles
Cleaning agent for equipment	Ethyl acetate

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® = registered trademark

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Certified to DIN EN ISO 9001 (Quality) and DIN EN ISO 14001 (Environment)

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