

ACRIFIX® 1S 0117 Pure Solvent Cement

Product and Use

ACRIFIX® 1S 0117 solvent acrylic cement is a clear, fluid adhesive free of dichloromethane (methylene chloride) and was developed utilizing a patented formula to provide an alternative to types of cement containing dichloromethane.

Applications

Preferably used for making T-joints and bonding narrow areas of all kinds of acrylic (PMMA) to itself, (i.e. ACRYLITE® acrylic products or parts made from ACRYLITE® molding compounds), as well as to other thermoplastics such as ABS, PS, and PVC.

Bonds produced from ACRIFIX® 1S 0117 solvent cement are strong and clear and firm up within a short time. Rapid further treatment is possible and in addition, ACRIFIX® 1S 0117 is not gap-filling. The cement does not cause crazing or blushing (whitening) when used as recommended under normal conditions. Conduct prior tests if necessary when using this product.

Typical Values of Properties

- **Viscosity (Brookfield II/12/68°F/20°C):** 0.8 cp
- **Density/68°F/20°C:** ~ 0.98 g/cm³
- **Refractive index nD:** ~ 1.38
- **Color:** clear
- **Flash point (Closed Cup):** < 39°F / 4°C
- **Solids content:** ≤ 1%
- **Storage stability:** 2 years in the original container, if stored properly. Maximum 86°F / 30°C
- **Packaging material:** Glass and aluminum vials varnished on the inside
- **Curing:** Physically by evaporation and absorption in the jointed parts

Safety Measures and Health Protection

Irritating to eyes, respiratory system, and skin. Sensitization by skin contact possible. Keep away from any source of ignition. Wear suitable protective gloves to avoid contact with skin. Avoid eye contact.

In operations where eye or face contact could occur, wear eye protection such as chemical splash-proof goggles or a face shield. In the event of contact with eyes, rinse immediately with plenty of water, and consult a doctor.

Contains flammable liquid and vapor which can be harmful if inhaled. Keep away from heat, sparks, and flame. Avoid breathing vapor. Keep the container closed. Use adequate ventilation

Bonding Technique

Fix the parts to be bonded in the desired position. Introduce ACRIFIX® 1S 0117 into the joint either from a glue dispenser or disposable syringe, and avoid bubble formation. It can be used for making T-joints and bonding narrow areas of ACRYLITE® extruded and ACRYLITE® Resist sheet. It can be utilized in the same applications as dichloromethane based cement as long as proper precautions are observed. It will not fill gaps caused by unfinished edges. It is recommended that edges be either scraped or milled to produce a flat level cementing surface. The technique is always an issue, but in general, bubble-free joints are more readily obtained using this cement than other commercial solvent cement due to the fact that it is less viscous and flows better upon application. The resulting bond will be firm in a relatively short period of time depending on the substrate and will have high ultimate strength.

Note: For best results, work on a flat and level surface. ACRYLITE® extruded and ACRYLITE® Resist, sheet each behave differently when used with this cement; therefore, application instructions are slightly different for each:

ACRYLITE® premium sheet: Utilize the capillary method with 0.004" shims for sheet thickness greater than or equal to 0.236", and 0.002" shims for sheet less than 0.236" in thickness. Remove shims based upon timing listed in the table. Best results are achieved by using the shim sizes and shim removal times as recommended. When removing the shims, be careful not to take them out too abruptly. Due to the fact that the tack time is slow, it is possible to move the part with the slightest force.

ACRIFIX® 1S 0117 Pure Solvent Cement



After 1.5 to 2 minutes from the time of application of cement, apply a pressure of 1.0 to 2.0 psi for 2 to 3 minutes. To obtain greater strength, apply a weight of 1.0 to 2.0 pounds per square inch of bonded surface area for 30 to 45 minutes for a sheet of thickness less than 0.236”.

Apply the weight for 15 to 30 minutes for sheet thickness greater than 0.236”. The finished piece can be further processed after 2.5 to 3.5 hours and will increase in bond strength over the next few weeks.

ACRYLITE® Resist sheet: Utilize the capillary method with 0.004” shims for sheet thickness greater than or equal to 0.236”, and 0.002” shims for sheet less than 0.236” in thickness. Remove shims based upon timing listed in table.

Apply a weight of 1.2 to 2.0 pounds per square inch of bonded surface area for 15 to 30 minutes which will ensure greater ultimate adhesion. The piece can be processed after 2 to 3 hours and will increase in bond strength over the next few weeks.

Other Fabrication Tips

Some typical tack times are listed below.

The quality of a bond depends largely on the careful preparation of the surface to be joined and the bonding techniques utilized. Tack time varies with the substrate being used.

	0.118”	0.236”
ACRYLITE® extruded sheet	60 to 90 sec.	10 to 15 sec.
ACRYLITE® Resist 65 sheet	10 to 15 sec.	5 to 10 sec.

Tack time here is defined as the amount of time it takes before a butt joint, 6 inches in length, can be picked up by the bonded end and will not separate itself from the surface of the other piece. In general, particularly for thinner materials, tack times are longer for ACRYLITE® Resist sheet when using this cement compared to other commercial solvent cement on the market. ACRIFIX® 1S 0117 cement has similar tack times for ACRYLITE® Resist sheet.

The table below provides helpful hints on how to get the best possible bonds.

ACRYLITE® extruded and ACRYLITE® Resist sheet each behaves differently when used with this cement; therefore, application, instructions are slightly different for each.

	ACRYLITE® Resist	ACRYLITE® Extruded
SHIMS SIZE	Less than 0.236” sheet 0.002”	Less than 0.236” sheet 0.002”
	Greater than or equal to 0.236” sheet 0.004”	Greater than or equal to 0.236” sheet 0.004”
REMOVE SHIMS	Less than 0.236”, 5 to 10 sec.	Less than .236”, 30 to 60 sec.
	Greater than or equal to 0.236”, < 5 sec.	Greater than or equal to 0.236”, < 10 to 20 sec.
TIME BEFORE PRESSURE	45 to 60 sec.	1.5 to 2 min.
AMOUNT OF PRESSURE	5 to 15 psi	1.0 to 2.0 psi
DURATION OF PRESSURE	2 to 3 min.	2 to 3 min.
AMOUNT OF WEIGHT	1.0 to 2.0 pounds per square inch of bonded surface - the same for all three materials	
DURATION OF WEIGHT		
min	Less than 0.236” 15 to 30 min.	Less than 0.236” 30 to 45 min.
min	Greater than or equal to 0.236” 15 to 30 min.	Greater than or equal to 0.236” 15 to 30 min.
TIME BEFORE PROCESSING	2 to 3 hours	2.5 to 3.5 hours



Appearance:

Clear

Shipping:

ACRIFIX® 1S 0117 solvent cement is shipped in 1 gal., 1 pt. and 4 oz. quantities. It is classified as an Adhesive, Flammable Liquid, UN 1133.

Limitation of Liability

Our ACRIFIX® adhesives and other auxiliary agents were developed exclusively for use with our ACRYLITE® acrylic sheet products and are specially adjusted to the properties of these materials. Any recommendations and guidelines for workshop practice, therefore, refer exclusively to these products.

Seller's liability shall be limited to the purchase price of the product supplied (or to have been supplied) here-under in respect of which damages are claimed. All technical or other advice by seller, whether or not at buyer's request, with respect to the product, its processing, further manufacture, other use or resale or otherwise, is given gratis by seller and seller shall not be liable for, and buyer assumes all risk of, such advice and the results thereof.

SELLER SHALL IN NO EVENT BE LIABLE FOR ANY INDIRECT, SPECIAL, CONSEQUENTIAL, INCIDENTAL OR OTHER DAMAGES, AND REGARDLESS WHETHER THE CLAIM IS BASED ON WARRANTY, CONTRACT, TORT, STRICT LIABILITY, NEGLIGENCE OR OTHERWISE.

Upon satisfactory proof of claim by the buyer, and as buyer's exclusive remedy, the seller will, within a reasonable time, supply the buyer with a replacement product of the same or equivalent type, free of charge, freight prepaid or, at seller's option, refund the purchase price for the product upon return of the product or other delivered material, or the unused portion thereof. Buyer charges for replacements and returns for credit will not be allowed unless authorized by the seller in writing.

For further information on safety measures, the exclusion of health risks when handling adhesives and at their disposal, see our Safety Data Sheet

Roehm America LLC
Acrylic Products

1796 Main Street
Sanford, ME 04073
USA

www.acrylite.co
www.roehm.com

1-855-202-7467
info@acrylite.co

Röhm GmbH and its affiliates are 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, including with regard to existing third party intellectual property rights, especially patent rights. In particular, no warranty, whether expressed 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 technical 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 should be used.