

ACRIFIX® MO 0070

Reaction moderator for 2-component polymerization adhesives

Product and Use

Type

Reaction moderator for 2-component polymerization adhesives, preferentially ACRIFIX® 2R 0190. Clear, purplish liquid with a citrus-like odor added to polymerization adhesives in order to dampen the polymerization reaction.

Applications

To avoid bubble formation (due to shrinkage or overheating) as a result of excessive heat generation **in thick layers** of polymerization adhesives.

Recommended for hollow seams, prevents bubble formation at top of hollow seams.

Storage/Transport

Keep container tightly closed in a cool place. Not classified as dangerous in the meaning of transport regulations

Working Instructions

When applying adhesive layers of approx. 3 mm upward and when bonding large surfaces, bubbles often form as a result of too rapid polymerization. In such cases, ACRIFIX® MO 0070 can be used to slow down polymerization and thus prevent bubble formation due to shrinkage and overheating. The temperature of the parts to be bonded, of the adhesive and the ambient temperature must **not drop below 20 °C**. Stir ACRIFIX® MO 0070 into the polymerization adhesive **before** adding the hardener (ACRIFIX® CA 0020). The added quantity should be kept as small as possible and **should not exceed 0.3 %**. If necessary, the minimum concentration should be determined in prior tests. Weigh the amount of

product to be added to the adhesive composition or, in view of the small quantity, count the number of drops you add (40 drops with supplied pipette correspond to about 1 g). The figures show the influence of ACRIFIX® MO 0070 on the polymerization of ACRIFIX® 2R 0190. At rising concentrations of ACRIFIX® MO 0070, the cured adhesive becomes increasingly yellow and bond strength decreases.

Bond strength can be slightly improved by **annealing** (for about two hours at approx. 60 to 80 °C) **as soon as the adhesive has cured**. The higher the temperature and the longer the annealing period, the more pronounced yellowing becomes. Heating must be performed gradually (10 °C per hour at most) to avoid bubble formation.

Notes:

ACRIFIX® 2R 1200, ACRIFIX®2R 1074 and ACRIFIX®2R1900 do not require the addition of ACRIFIX®MO 0070.

For more details see our Guidelines "Joining, Ref. No.: 311-3"

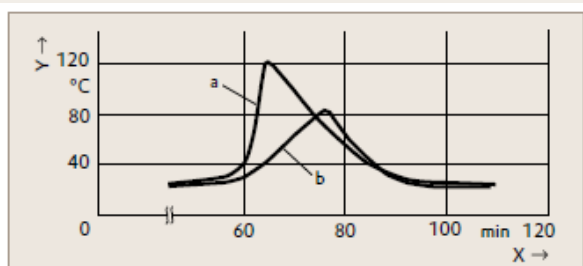
Limitation of Liability

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.



Influence on the polymerization temperature profile of ACRIFIX® 2R 0190:

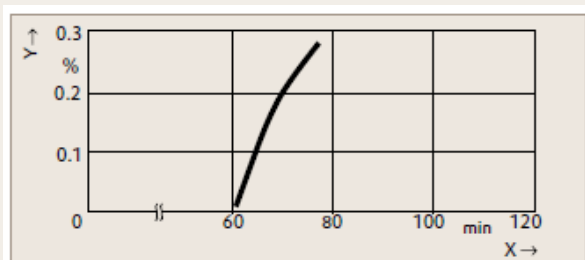
A = ACRIFIX® 2R 0190 + 3 % ACRIFIX® CA 0020

B = ACRIFIX® 2R 0190 + 0.3 % ACRIFIX®

MO 0070 + 3 % ACRIFIX® CA 0020

Y = Temperature

X = Time



Influence on the polymerization time of ACRIFIX® 2R 0190:

Y = Concentration of ACRIFIX® MO 0070

X = Time

Safety Measures and Health Protection

Labeling according to Regulation (EC) 1272/2008

Warning, contains p-Mentha-1,4-diene



Causes skin irritation. (H315)

Causes serious eye irritation. (H319)

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

IF ON SKIN : Wash with plenty of soap and water. (P302+P352)

IF IN EYES: Rinse cautiously with water for several minutes. Remove contact lenses, if present and easy to do. Continue rinsing. (P305+P351+P338)

Dispose of contents according to local disposal regulations. (P501)

Typical Values

Properties	Values
Viscosity, Brookefield, A/6/20°C:	~17 mPa·s
Density (20 °C):	~ 1.03 g/cm ³
Color:	dark purple, clear (harmless color changing may occur during storage)
Flash point ASTM D93	78 °C
Storage stability:	unlimited in original container
Packaging materials:	aluminum, colored glass (protected against light)
Cleaning agents for equipment:	ACRIFIX® TC 0030, ethyl acetate
Concentration employed:	0.05 to 0.3 %, preferably 0.1% in ACRIFIX® 2R 0190 at 3 to 4 % ACRIFIX® CA 0020 (conduct prior tests with other polymerization adhesives)
Storage temperature:	max. 30°

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Evonik is 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.

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