



ACRIFIX® Service Product

ACRIFIX® CO Colorants for coloring ACRIFIX® 2R polymerization adhesives

Product and Use

Type of the service product

Colored pasty compounds based on organic and inorganic pigments in phthalate plasticizer.

Applications

For coloring ACRIFIX® 2R polymerization adhesives, for the bonding of e.g. colored PLEXIGLAS® parts, or to fill in engravings etc.

Storage/Transport

At room temperature in a dry place. Not a dangerous chemical within the meaning of the shipping regulations.

Working Instructions

The colorant pastes must be stirred before use, e. g. with a wooden spatula. Colorant is normally added to ACRIFIX® 2R polymerization adhesives in a proportion of 1 % of the adhesive quantity, but other ratios are also possible. Stir colorant into ACRIFIX® 2R adhesive and mix homogeneously. The master batch thus obtained can either be mixed directly with the hardener ACRIFIX® CA 0020 and used as such, or mixed with other master batches or ACRIFIX® 2R adhesives on its own. This makes it possible to approximately match various PLEXIGLAS® colors (see Table „Typical Formulations“). In order to avoid deviations in color when performing extensive or repeated bonding jobs, it is advisable to color the required adhesive quantity all at once and to add the hardener ACRIFIX® CA 0020 to smaller quantities taken from the entire batch.

The addition of larger quantities of colorant, especially blue and red, may slow down the curing process. This can be made up by adding 0.5 to 1 % to the usual concentration of ACRIFIX® CA 0020 (3 to 6 % in e.g. ACRIFIX® 2R 0190).

More Information

In case of a higher content of curing agent, the color can change (yellow color), this is particularly visible in white colors.

For more details please see our Guideline "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.

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 formulations for colouring ACRIFIX® 2R adhesives

| Content in % of ACRIFIX® CO in ACRIFIX® 2R (= Masterbatch (MB)) | | | | | |
|---|------------------|------------------|----------------|-----------------|-------------------|
| PLEXIGLAS® GS Grade | Colourant | | | | |
| | Black CO 9073 | White CO W074 | Red CO 3075 | Blue CO 5076 | Yellow CO 1077 |
| White WH01 | - | 3 | - | - | - |
| White WH10 | - | 1 | - | - | - |
| White WH73 | - | 1 | - | - | - |
| Yellow 1H01 | - | - | - | - | 1 |
| Red 3H25 | - | 1 | 1 | - | - |
| Red 3H67 | - | - | 1 | - | 1 |
| Red 3H01 | - | - | 3 | - | - |
| Blue 5H48 | - | 1 | - | 4 | - |
| Black 9H01 | 2 | - | - | - | - |

| Mixing ratio masterbatch (MB) to ACRIFIX® 2R and ACRIFIX® CA 0020 in % | | | | | | | |
|--|------------------------------|-----------------------|---------------------|----------------------|----------------------|----------------|---------------------|
| PLEXIGLAS® GS Grade | Masterbatch with ACRIFIX® CO | | | | | Adhesive | Catalyst |
| | MB with Black 9073 | MB with White W074 | MB with Red 3075 | MB with Blue 5076 | Fk. mit Gelb 1077 | ACRIFIX® 2R | ACRIFIX® CA 0020 |
| White WH01 | - | 96 | - | - | - | - | 4 |
| White WH10 | - | 13,6 | - | - | - | 82,4 | 4 |
| White WH73 | - | 96 | - | - | - | - | 4 |
| Yellow 1H01 | - | - | - | - | 96 | - | 4 |
| Red 3H25 | - | 19,2 | 48 | - | - | 28,8 | 4 |
| Red 3H67 | - | - | 80,1 | - | 15,9 | - | 4 |
| Red 3H01 | - | - | 96 | - | - | - | 4 |
| Blue 5H48 | - | 16,8 | - | 22,6 | - | 56,6 | 4 |
| Black 9H01 | 96 | - | - | - | - | - | 4 |

The typical formulations can only approximately describe the colour matching and they may need to be determined precisely in preliminary trials.



Example calculation

250 g ACRIFIX® is to be coloured for bonding of PLEXIGLAS® WH10.

| Example calculation | | |
|--|--------|-------|
| Production: Masterbatch (MB) | | |
| Colourant white ACRIFIX® CO W074 | 1 % | 1 g |
| ACRIFIX® 2R 0190 | 99 % | 99 g |
| Masterbatch White CO W074 (1 %) | 100 % | 100 g |
| Production: ACRIFIX® 2R 0190 White WH10 coloured | | |
| Masterbatch White CO W074 (1 %) | 13,6 % | 34 g |
| ACRIFIX® 2R 0190 | 82,4 % | 206 g |
| ACRIFIX® CA 0020 | 4,0 % | 10 g |
| | 100 % | 250 g |

| Typical values | |
|-------------------------------|--|
| Properties | Values |
| Viscosity | pasty |
| Density (20 °C) | ~ 1 g/cm³ |
| Color or grade | ACRIFIX® CO 9073 (Black) ACRIFIX® CO W074 (White) ACRIFIX® CO 3075 (Red) ACRIFIX® CO 5076 (Blue) ACRIFIX® CO 1077 (Yellow) |
| Storage stability | unlimited in original container |
| Packaging material | PE-can |
| Cleaning agents for equipment | ACRIFIX® TC 0030, ethyl acetate, acetone |
| Storage temperature | max. 30°C |

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® = registered trademark

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