



# Anglo Adhesives & Services Ltd.

INDUSTRIAL ADHESIVE MANUFACTURERS - CONTRACT FILLING AND PACKAGING

Anglo House The Airfield Dalby Road Melton Mowbray Leicestershire LE13 0BL UK

Tel: +44(0)1664 480866 - Fax: +44(0)1664 480963

E-mail: sales@anglo-adhesives.co.uk Web: www.anglo-adhesives.co.uk



## TECHNICAL DATA SHEET

### ANGLO CAST-FIX

Clear  
Colourless  
Solvent Weld

Cure Time:-  
24 - 48 hours

Coverage:-  
>10m<sup>2</sup>  
Per Litre

Specific  
Gravity:-  
1.1kg/Litre

Viscosity:-  
50 - 100 mPaS

Solids:-  
<1.0%

Cleaner/  
Thinner:-  
Cleaner 5

Storage:-  
5 - 30 °C

Shelf Life:-  
>12 months

Nearest  
Alternative:-  
T12

#### INTRODUCTION:

ANGLO CAST-FIX is ready- mixed, colourless, solvent- based cement. It consists of a blend of specially formulated solvents including dichloromethane.

ANGLO CAST-FIX hardens as the solvent is absorbed or evaporates. The solvent softens the surfaces being joined so that they fuse, hardening as the solvent migrates into the body material. The cement has been specially developed to reduce the problems of rapid drying and 'skinning' common with solvent-based cements.

It is a versatile, one-part cement suitable for general fabrication work which does not need high bond strength.

ANGLO CAST-FIX is suitable for joining items made from 'Diakon' acrylic polymers as well as 'Perspex', but is especially suitable for bonding of acrylic sheet without stress crazing.

NB ANGLO CAST-FIX should not be used for outdoor Applications. It is not recommended for laminating 'Perspex' sheets as crazing will eventually occur.

## **METHOD OF USE**

**IMPORTANT:** Before embarking on any work involving ANGLO CAST-FIX, the Material Safety Data Sheet should be carefully studied by those carrying out the work.

Although ANGLO CAST-FIX was developed so that rapid evaporation and skinning are minimal, the following techniques will reduce these problems further.

## **LIMIT EXPOSURE TO AIR BEFORE APPLYING THE CEMENT**

Dispense the cement directly into the joint using a small flexible polyethylene bottle with a suitable nozzle or a hypodermic syringe with a shortened wide-bore needle. Use a dispenser which holds no more cement than is needed for the job. Prevent the nozzle or needle from becoming clogged by inserting a steel wire or pin whenever the dispenser is not being used.

## **REDUCE THE EVAPORATION THAT OCCURS BETWEEN APPLYING THE CEMENT AND ASSEMBLING THE PARTS**

Refrigerate the cement for at least 12 hours before use. A domestic refrigerator is suitable (temperature 5 - 10°C; 41 - 50°F). If this is not possible, an alternative is to cool the cement containers in cold water, although this is less effective.

The quantity of cement needed for the following day or shift should be placed in the refrigerator about 12 hours before use. Ready-filled dispensers should also be kept cool by returning them to the refrigerator after use.

**NB** Always re-cap the tin immediately after use.

## **HARDENING**

Joints can be hardened after about three hours at room temperature but should not be machined for at least twenty-four hours. Bonds reach their maximum strength after about three weeks at room temperature, but for most applications, one or two weeks should be adequate.

## **PROPERTIES OF JOINTS**

Joints made with ANGLO CAST-FIX are not as strong as those made with Tensol Cements Nos 3, 12 or 70.

The gap filling properties of the cement are limited which means that mating surfaces must be machined to close tolerances.

Do not use ANGLO CAST-FIX for laminating as the absorption of the solvent is likely to cause distortions and/or stress crazing.

ANGLO CAST-FIX is unsuitable for outdoor exposure.

## **MIGRATION OF PIGMENTS**

The solvent in ANGLO CAST-FIX may cause colorants to migrate from one piece of Perspex to the next. If colour is important, check for any migration by making a small test joint.

## **SHELF LIFE**

ANGLO CAST-FIX in an unopened container has a shelf life of over a year. The cement is usable as long as it remains colourless and of low viscosity.

Unopened containers do not need to be stored in a refrigerator.

Always replace the lid of the container immediately after use to prevent evaporation of the solvent.

**NOTE: THIS ADHESIVE IS NOT RECOMMENDED FOR STRUCTURAL APPLICATION ON AIRCRAFT**

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