



# Anglo Adhesives & Services Ltd.

INDUSTRIAL ADHESIVE MANUFACTURERS - CONTRACT FILLING AND PACKAGING

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## TECHNICAL DATA SHEET

### ANGLOSOL CEMENT 1200

#### INTRODUCTION:

ANGLOSOL CEMENT 1200 is a ready-mixed, colourless, solvent based cement. It consists of acrylic polymer and methyl methacrylate monomer dissolved in solvents.

ANGLOSOL CEMENT 1200 hardens as the solvent is absorbed or evaporates, depositing polymer in the joint. In addition 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 versatile, single part cement suitable for general fabrication work which does not need high bond strength, (usually for internal applications). ANGLOSOL CEMENT 1200 is suitable for joining items made from 'Diakon' acrylic polymers as well as cast acrylic (Perspex).

ANGLOSOL CEMENT 1200 should not be used for outdoor applications and cannot be used with Perspex ME, Perspex SW or Perspex AG grades. Nor is it recommended for laminating cast acrylic (Perspex) sheets as crazing will eventually occur.

#### METHOD OF USE:

**IMPORTANT:** Before embarking on any work involving ANGLOSOL CEMENT 1200 the Material Safety Data Sheet should be carefully studied by those carrying out the work.

Polymer Base:-  
Methyl  
Methacrylate

Initial Cure  
Time:- 2/3 hrs  
Full Cure:  
24-48 Hours

Coverage:-  
10m<sup>2</sup> per litre

Specific  
Gravity:-  
1.2kg/Ltr

Viscosity:-  
400mPaS

Solids:-  
50%

Cleaner/  
Thinner:-  
Solvent M

Shelf Life:-  
12 Months

Storage:-  
5 - 30 °C

Nearest  
Alternative:-  
Anglosol 700

Although ANGLOSOL CEMENT 1200 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. For precise application use Anglo's special Application Kits. 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 or 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 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.

To obtain maximum strength more quickly, leave the joint to harden at room temperature for at least twenty four hours and then heat for eight hours at 80 °C (176 °F).

#### PROPERTIES OF JOINTS

Joints made with ANGLOSOL CEMENT 1200 are not as strong as those made with ANGLOSOL CEMENT 700.

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

Do not use ANGLOSOL CEMENT 1200 for laminating as the absorption of the solvent is likely to cause distortions and / or stress crazing.

ANGLOSOL CEMENT 1200 IS UNSUITABLE FOR CERTAIN TYPES OF OUTDOOR EXPOSURE.

#### MIGRATIONS OF PIGMENTS

The solvent in ANGLOSOL CEMENT 1200 may cause soluble colourants to migrate from one piece of cast acrylic (or other plastic being used) to the next. If colour is important, check for any migration by making a small test joint.

#### SHELF LIFE

ANGLOSOL CEMENT 1200 in a un-opened container has a shelf life of 12 months. The cement is usable as long as it remains colourless and of low viscosity.

Un-opened 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 APPLICATIONS ON AIRCRAFT.

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