

# HART PLASTICS

# **CRYSTAL CLEAR SPECIAL ADHESIVE FOR BONDING RIGID PLASTIC**

# **MATERIALS**



#### PRODUCT DESCRIPTION

Crystal clear special adhesive for bonding rigid plastic materials like ABS, PVC, acrylic glass, polycarbonate, also in combination with wood, paper, metal, glass und ceramics.

#### FIELD OF APPLICATION

Suitable for PS, ABS, SAN, SB, ASA, PVC, PMMA, CN, CAB, PC also in combination with phenolic resins (Bakelite®), melamine resins (Resopal®), glass fiber and reinforced polyester. Not suitable for Styrofoam®, PE, PP, PA, POM, PTFE, silicone.

### **PROPERTIES**

- · usable for all common rigid plastics
- $\cdot$  temperature resistant from -30°C up to +90°C
- · resistant to oil, water, diluted acids and bases

# **PREPARATION**

**Personal safety:** The adhesive contains volatile, highly flammable solvents. Therefore, corresponding safety measures should be take reagrding processing and storage. When gluing ensure adequate ventilation.

**Surface requirements:** The surface must be dry, clean and free of dust and grease.

# **APPLICATION**

# **Directions for use:**

Apply a thin layer on one surface, then press immediately together the materials to be bonded.

**Stains/residue:** Remove fresh glue stains as soon as possible. Cured adhesive residue can only be removed mechanically.

#### **CURE TIMES\***

Final bonding strength after: approx. 24 hours

\* Curing time may vary depending on a.o. surface, product quantity used, humidity level and ambient temperature.

# **TECHNICAL PROPERTIES**

Water resistance: Very good

**Temperature resistance:** -30°C to approx. +90°C **Chemicals resistance:** detergents, oil and alcohol

# **TECHNICAL SPECIFICATIONS**

**Appearance:** colourless, clear solution **Chemical base:** acrylic ester/ PVC copolymer

Viscosity: approx. 20-25 mPa.s. Solid matter: approx. 19-22 % Density: approx. 0.9 g/cm<sup>3</sup>

**Specifications:** Consistency: low viscosity

Flash point [°C]: -19

#### STORAGE CONDITIONS

Store in tightly closed packaging in a dry, cool and frost-free place.

# PHYSIOLOGICAL PROPERTIES

The dried adhesive is inert, completely neutral and physiologically safe.

# **PACK SIZES**

30 g

Note: This information is the result of carefully executed tests. This Technical Data Sheet has been prepared to the best of our knowledge to provide you with advice when gluing. We cannot be held responsible for the results or any damage suffered, as the variety of factors involved (type and combination of materials and working method) are beyond our control. Users have to carry out their own checks and trials. Liability can only be accepted for the consistently high quality of our product.