FM 1696
ISO 9001

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EVO-PLAS EXTRU-FIX
EVO-PLAS RANGE – SOLVENT BASED CEMENT

EVO-PLAS EXTRU-FIX is a ready mixed, colourless, solvent based cement consisting of a blend of specially formulated solvents including dichloromethane and nitrothane.

EVO-PLAS EXTRU-FIX hardens as the solvent evaporates or is absorbed. The solvent softens the surfaces being bonded so that they fuse together, hardening as the solvent migrates to the body material.

EVO-PLAS EXTRU-FIX has been especially developed to reduce the problems of rapid drying and skinning common with other solvent based cements.

RECOMMENDED USE

EVO-PLAS EXTRU-FIX is a versatile single component cement suitable for general fabrication work that does not require a high bond strength. **EVO-PLAS EXTRU-FIX** is suitable for jointing items made of "Diakron" acrylic polymers as well as "Perspex", it is especially suitable for bonding extruded acrylic sheet without stress crazing.

EVO-PLAS EXTRU-FIX should not be used for outdoor applications and cannot be used with "Perspex" ME, SW or AG grades, nor should it be used for laminating "Perspex" sheet, as crazing will eventually occur.

EVO-PLAS EXTRU-FIX IS NOT RECOMMENDED FOR STRUCTURAL APPLICATIONS ON AIRCRAFT.

BONDING INSTRUCTIONS

SURFACE PREPARATION

- Substrates to be bonded should be perfectly clean, dry and free from dust and grease.

APPLICATION / BONDING

- Although **EVO-PLAS EXTRU-FIX** was developed so that rapid evaporation and skinning are minimal, the following techniques will reduce problems further.

- LIMIT EXPOSURE TO AIR BEFORE APPLYING CEMENT.

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

- REDUCE THE EVAPORATION THAT OCCURS BETWEEN APPLYING THE CEMENT & ASSEMBLING THE PARTS.

  - Refrigerate the cement for at least 12 hours before use. A domestic refrigerator is suitable (5 - 10°C). 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 approx. 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 container immediately after use.

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- Joints will be hardened after about 3 hours at room temperature but should not be machined for at least 24 hours. Bonds reach their maximum strength after approx. 3 weeks at room temperature, but for most applications 1 - 2 weeks should be adequate.

- Joints made with **EVO-PLAS EXTRU-FIX** are not as strong as those made with **TENSOL 70 cement.**

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

- The solvent in **EVO-PLAS EXTRU-FIX** may cause soluble 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.

TYPICAL CHARACTERISTICS

Physical Form:	Very low viscosity liquid
Colour:	Clear
Solvent:	Speciality solvent blend
Viscosity:	Approx. 75mPas
Solids Content:	<1%
Specific Gravity:	Approx. 1.1
Flammability:	Non flammable

PACKAGING

2 x 5 litres (code No. 135529), 8 x 2.5 litres (code No. 135512), 12 x 500ml (code No. 135505).

STORAGE

Store in a clean dry area in the temperature range 5 and 30°C.

SHELF LIFE

At least 12 months in its original container stored under the above conditions.

MATERIAL SAFETY DATA

For further information refer to the relevant Health and Safety Data Sheet.