



## ACRIFIX® TH 0032

Thinner for all 2-component Polymerization Adhesives curing with the aid of ACRIFIX® CA 0020

### Product and Use

#### Type of service product

Methyl methacrylate containing activator; colorless, transparent, thin-bodied

#### Applications

Thinner for all 2-component polymerization adhesives curing with the aid of ACRIFIX® CA 0020, e.g. ACRIFIX® 2R 0190. Preferentially used when over 10% thinner is added.

### Storage/Transport

Keep container tightly closed in a cool place.  
UN 1247

### Working Instructions

The viscosity of the adhesives is adjusted so as to allow their direct use in most cases. However, for certain applications it is helpful to dilute the adhesives beforehand, i.e. to reduce their viscosity:

- More rapid degassing because air bubbles rise to the surface quicker in diluted adhesive – advantageous for large quantities of adhesive composition.
- Better leveling, thinner adhesive layers and somewhat delayed skin formation – advantageous for bonding large surfaces (particularly of thin sheets).
- Better wetting out and degassing when embedding fiber mats and woven fabrics.
- More rapid filling of butt joints between thick blocks.

- Diluted adhesives enable shorter pot lives and polymerization times (at higher hardener concentration), because degassing and processing can be performed more quickly than with undiluted polymerization adhesives.

The viscosity required for a specific application must be determined by trial and error. In general, adhesives should be diluted as little as possible.

The hardener concentration (e.g. ACRIFIX® CA 0020) depends on the quantity of diluted adhesive.

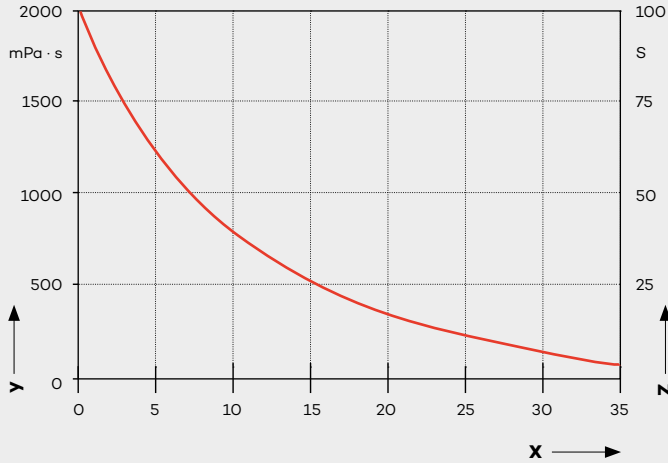
The influence of the thinner on viscosity and polymerization can be seen in the corresponding pictures.

#### More Information

ACRIFIX® TH 0032 is polymerizable on its own after adding 3 to 6% ACRIFIX® CA 0020. The polymers are clear and yellowish.

Polymerization shrinkage increases with higher thinning. In case of strong thinning, surface structures may occur after curing as well as a stronger yellow color. ACRIFIX TH 0032 is not suited for surface cleaning.

For more information see our Guideline "Joining, Ref. No. 311-3".



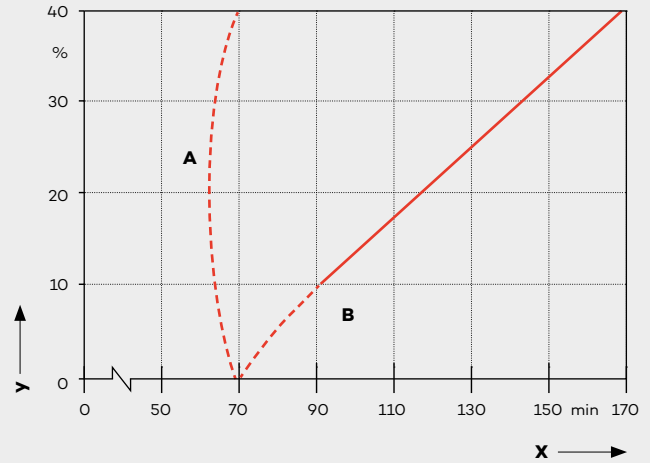
Viscosity of ACRIFIX® 2R 0190

X = Thinner concentration  
Y = Viscosity  
Z = Efflux time/6mm cup

### 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.



Influence of thinner concentration on polymerization time of ACRIFIX® 2R 0190 + 3% ACRIFIX® CA 0020 (on diluted adhesive)

X = Polymerization time  
Y = Thinner-concentrate  
A = ACRIFIX® TH 0032  
B = ACRIFIX® TC 0030

### 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 Values

Properties	Values
Viscosity; Brookfield A/60/20°C	~0,6 mPa · s
Density (20 °C)	~ 0,94 g/cm <sup>3</sup>
Refractive index n <sub>D</sub> <sup>20</sup>	~ 1,415
Color	clear, transparent
Flash point (DIN 51755)	~ + 10 °C
Explosion limits in air	2,1 to 12,5 Vol.%
Storage stability	2 years after filling, given correct storage
Storage temperature	max. 30°C
Packaging materials	aluminum, colored glass

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