

TECHNICAL DATA SHEET

INDASOL CEMENT 1212

Introduction:

INDASOL Cement 1212 is a ready mixed, colourless, solvent based cement. It consists of acrylic polymer and methyl methacrylate monomer dissolved in solvents.

INDASOL Cement 1212 hardens as the solvent is absorbed or evaporates, depositing polymer in the joint. In addition, the solvent softens the surface being joined so that they fuse, hardening as the solvent migrates into the body of the substrate. The cement has been specially developed to reduce the problems of rapid drying and 'skinning' which is common with solvent based cements.

INDASOL Cement 1212 is a versatile, single part cement suitable for general fabrication work which does not need high bond strength.

INDASOL Cement 1212 is suitable for joining items made from 'Diakon' acrylic polymers as well as cast acrylic (Perspex).

INDASOL Cement 1212 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.

Safety:

IMPORTANT: Before embarking on any work involving **INDASOL Cement 1212**, the Safety Data Sheet should be carefully studied by those carrying out the work.

Method of Use:

Although **INDASOL Cement 1212** 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 hypodermic syringe with a shortened wide-bore needle. For precise application use Indasol's special Application Kits.

Use a dispenser which holds no more cement than is needed for the job. Prevent the nozzle or needle becoming clogged by inserting a pin or wire into it whenever the dispenser is not being used.

Polymer Base
Methyl
Methacrylate

Solids
20% approx.

Viscosity
600 mPa.s
approx.

Specific Gravity
1.2 approx.

Cleaner
4224 Thinners

Storage
5 – 25°C

Shelf Life
12 Months

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). If this is not possible, an alternative is to cool the cement containers in cold water, although this is less effective. The quality 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

The initial cure takes about three hours at room temperature but the joint should not be machined for at least twenty-four hours. Full cure takes place within 48 hours but bonds reach their maximum strength after about three weeks at room temperature. Though 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.

Properties of Joints

Joints made with **INDASOL Cement 1212** are not as strong as those made with INDASOL CEMENT 7070.

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

Do not use **INDASOL Cement 1212** for laminating as the absorption of the solvent is likely to cause distortions and/or crazing.

INDASOL Cement 1212 IS UNSUITABLE FOR CERTAIN TYPES OF OUTDOOR EXPOSURE.

Migration of Pigments

The solvent in **INDASOL Cement 1212** 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

INDASOL Cement 1212 in an unopened container has a shelf life of 12 months. The cement is usable as long as it remains colourless and of low viscosity.

Unopened containers don't need to be stored in a refrigerator.

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

Coverage:

> 10 m²/L

Packaging:

For current pack sizes, please contact our Customer Service Department.

NOTE:

THIS ADHESIVE IS NOT RECOMMENDED FOR STRUCTURAL APPLICATIONS ON AIRCRAFT.

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