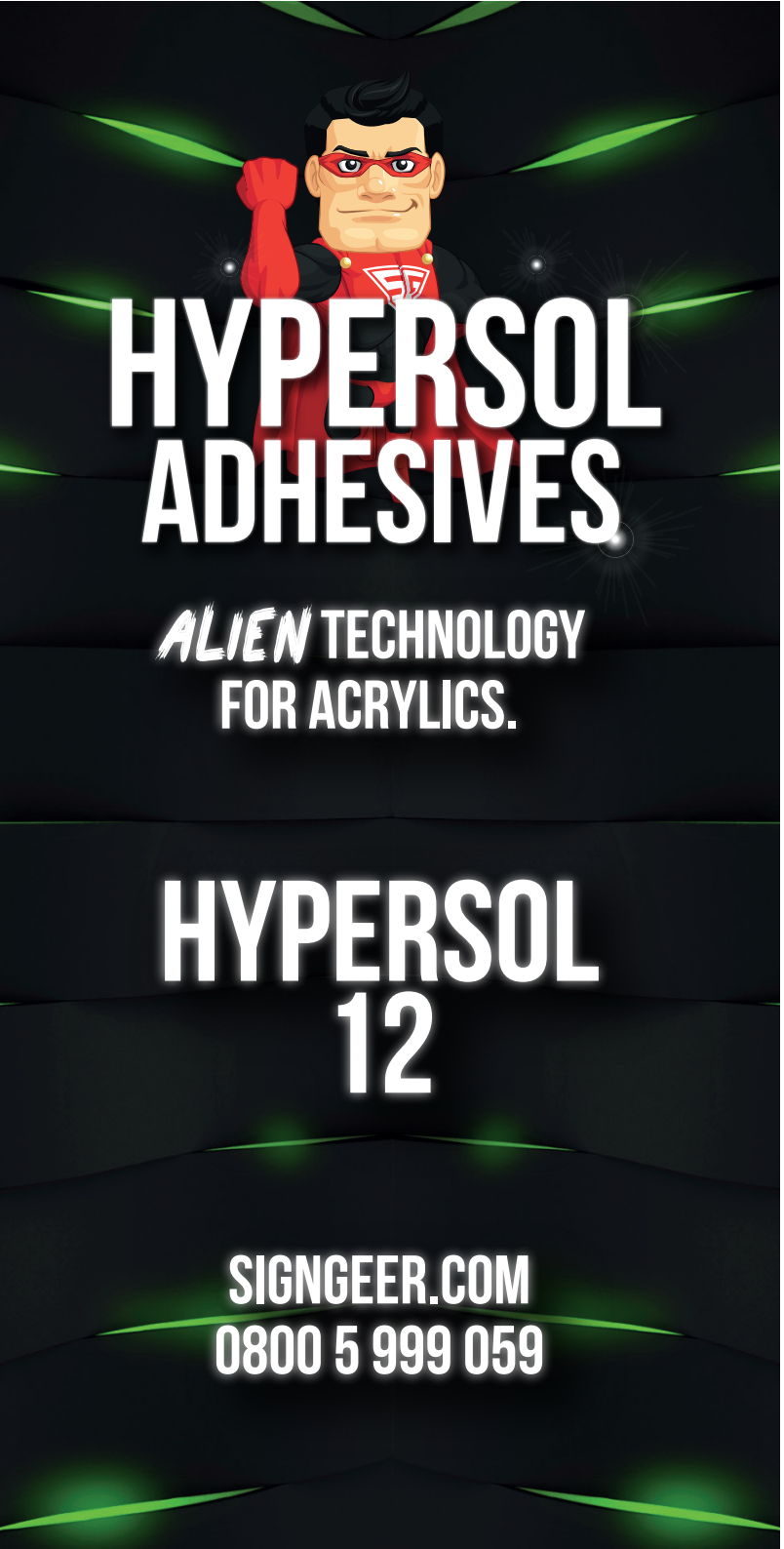

APPLICATION GUIDE

Before using Hypersol 12 store the adhesive at 5 to 10°C for 12 hours to reduce solvent evaporation betweenapplying the adhesive and assembling the parts.

Surfaces must be clean, dry and dust free.

Application

Dispense the adhesive from a suitable bottle or wide tip syringe that has also been refrigerated.

Surfaces to be bonded should be clean, dry and dust free. If necessary they can be cleaned with petroleum ether or white spirit then washed with water. Extruded or machined parts should be annealed before bonding to prevent stress cracking.

Annealing is carried out by heating the parts to 80 to 85°C for hour then allowing them to cool slowly to room temperature.

Hypersol 12 has limited gap filling ability so surfaces to be joined should be close fitting. The solvent in Hypersol 12 may cause soluble colorants to migrate. If colour is important check for any migration by bonding a small test joint first.

Dispense the refrigerated cement directly into the joint using a suitable dispenser. It is best to do this in one smooth motion to avoid any bubbles or voids in the bondline. Joints will be set sufficiently to be handled after 3 hours but must not be machined for at least 24 hours after bonding. Maximum bond strength is reached in 3 weeks at room temperature but, for most applications, 1 to 2 weeks should be adequate.

To obtain the maximum strength more rapidly the bond can be left for 24 hours then post cured for 8 hours at 80°C.