

Industrial Plastics

Cementing Instructions for plexi solvent

Capillary Method: Before gluing acrylic do not flame or polish edges (to prevent crazing) and remove about 1" of masking (the paper or film on the sheet of plexi) from the edges of acrylic. Fit surfaces to be cemented snugly together without any gaps or voids. Use a clamp or weight to hold surfaces in direct contact under mild uniform pressure; if you don't have these items just apply firm even pressure with your hands to keep the edges flat and level. Apply the cement with the Hypo-Applicator allowing the cement to flow into the joint by capillary action. No matter how hard you are pushing the pieces together; the solvent will find its way into the glue joint.

The union will set in thirty to sixty seconds; however, a full cure does not occur for eight hours.

Solvent: The solvent is a chemical called methylene chloride which bonds acrylic and polystyrene. It will not adhere to your skin or other materials because it is not glue it's a solvent. Like any chemical you do not want to get any on you so be careful and it's always a good idea to wear gloves. The solvent is non flammable but you should use it in a well ventilated area and avoid prolonged breathing.

Hypo Applicator: Do not fill hypo-bottle more than half way. After filling half way, hold the bottle upright and squeeze slowly to expel air. Release pressure slowly while moving hypo-needle into position to glue the joint. This slow pressure release creates a slight vacuum and lessens the possibility of dripping glue which can mar or damage the surface of the acrylic. With the hypo-needle in place squeeze bottle gently and pull needle backwards along joint to be glued. Do not stop once you have started to apply the solvent or it will puddle and leave a frosted stain.

Do not PUSH hypo-needle along the joint because it plugs easily—it is always done in a pull technique.

Note: If you do not create the vacuum as indicated above, the solvent will drip out of the applicator onto the plexi and will leave a permanent stain that can only be removed by buffing. Practice the technique listed above before you try use the solvent the first couple of times till you get the hang of it.