

Technical Data Sheet

Anglosol Dichloromethane (DCM) (HIPSOL)

Introduction:

Anglosol DiChloroMethane is ready mixed, colourless, solvent based cement. It consists of a blend of specially formulated solvents including dichloromethane.

Anglosol DiChloroMethane hardens as the solvent is absorbed or evaporates. The solvent softens the surfaces being joined so that they fuse, hardening as the solvent migrates into the body material. The cement has been specially developed to reduce the problems of rapid drying and 'skinning' common with solvent based cements.

It is a versatile, one-part cement suitable for general fabrication work which does not need high bond strength. **Anglosol DiChloroMethane** is suitable for joining items made from 'Diakon' acrylic polymers as well as 'Perspex', but is especially suitable for bonding of acrylic sheet without stress crazing.

Anglosol DiChloroMethane should not be used for outdoor applications. It is not recommended for laminating Perspex sheets as crazing will eventually occur.

Safety:

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

Method of Use:

Although **Anglosol DiChloroMethane** 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. 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.

NB: Always re-cap the tin immediately after use.

Application Solvent Weld
Solids <1% approx
Viscosity 100 mPa.s approx.
Specific Gravity 1.2 approx.
Cleaner 4224 Thinners
Storage 5 – 25°C
Shelf Life 12 Months

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Hardening

The initial cure takes a few minutes 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.

Properties of Joints

Joints made with **Anglosol DiChloroMethane** are not as strong as those made with ANGLOSOL CEMENT 700 or ANGLOSOL 1200.

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

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

Anglosol DiChloroMethane IS UNSUITABLE FOR CERTAIN TYPES OF OUTDOOR EXPOSURE.

Migration of Pigments

The solvent in **Anglosol DiChloroMethane** 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

Anglosol DiChloroMethane 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.

Brick Knoll Park - Ashley Road
St Albans - Herts - AL1 5UG
T: 01727 863138
E: sales@stephen-webster.co.uk



stephen-webster.co.uk

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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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