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TECHNICAL DATA SHEET ergo.[®] 1471

solvent-free accelerator for anaerobic adhesives

Description

This very low viscous accelerator is based on methacrylic monomers and does not contain organic solvents. It accelerates the curing process of anaerobic glues and is recommended whenever curing within seconds is required, or if inactive materials or too big gaps avoid normal curing. In order to cure excess of glue totally, it may also be used on top of the gap or squeeze-out.

Chemical base : methacrylic monomer

Viscosity* at 25°C

based largely on DIN EN ISO 3219

cone MK-75, shear rate $D=3000s^{-1}$: 7 - 17 mPa•s

Density at 25°C : 1,04 - 1,08 g/cm³

Colour : light blue-green

Flashpoint : > 100° C

Shelf life : 1 year, if stored below +28°C

Curing with anaerobic adhesive

Activity* of a 1:1 mixture

acc. to internal norm PA407 : 10 – 20 seconds

Initial strength on M10 bolts : depending on the glue ~ 10 – 20 seconds

Instruction for use together with anaerobic adhesives

Pre-applied activator

Apply **ergo.[®] 1471** on one surface and the adhesive on the other. Join the parts immediately (activator must remain liquid, do not try to dry) and fix them for at least 20 seconds.

Store the parts, until functional or final strength is achieved.

Post-applied activator

Apply the adhesive, join the parts and drop the activator on the gap or squeeze-out.. Excess adhesive will be cured totally

Warning ! Never mix bigger amount of adhesive and activator directly !

WARRANTY INFORMATION - PLEASE READ CAREFULLY

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