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## EVO-PLAS EXTRU-FIX USER GUIDE

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### DESCRIPTION

**Evo-Plas Extru-Fix** is a solvent based plastics weld cement consisting of a blend of solvents designed to minimise the risk of stress cracking in extruded plastics sheets . It is designed for general fabrication work with a range of sheet form plastics for interior use only .

### RECOMMENDED USE

**Evo-Plas Extru-Fix** is designed for the bonding of Cast Acrylic , Extruded Acrylic , Polycarbonate , High Impact Polystyrene and PETG sheet intended for interior use only .

**Evo-Plas Extru-Fix** must not be used with Perspex ME, SW or AG grades and is not suitable for laminating sheets face to face due to solvent entrapment in the join .

**Evo-Plas Extru-Fix** must not be used for exterior applications . It is designed for interior applications only .

### METHOD OF USE

Before using **Evo-Plas Extru-Fix** store the adhesive at 5 to 10°C for 12 hours to reduce solvent evaporation between applying the adhesive and assembling the parts. Dispense the adhesive from a small polythene bottle fitted with a wide bore hypodermic needle 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 1 hour then allowing them to cool slowly to room temperature .

**Evo-Plas Extru-Fix** has little gap filling ability so surfaces to be joined should be close fitting.

The solvent in **Evo-Plas Extru-Fix** may cause soluble colorants to migrate. If colour is important check for any migration by making 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.