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Aetna Plastics
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CHEMGRIP Cement Instructions for Safe Handling and Use

Use in accordance with Norton Material Safety Data Sheet.

(1) Use CHEMGRIP (Part “A”) Epoxy Resin only with CHEMGRIP (Part “B”) Epoxy Curing Agent. (2) Prepare all bonding surfaces by thoroughly cleaning, degreasing and drying them. For plastic surfaces, remove mold release, if any. (3) Mix equal amounts of CHEMGRIP Part “A” (red colored) and CHEMGRIP Part “B” (amber colored) in a shallow mixing vessel. Mix until color is uniform. Mix slowly to avoid entrapping of air. Pot life of a one-quart mixture will be about 45 minutes at room temperature (77°F). (4) Cover mixed material to reduce loss of volatile ingredients. (5) Apply CHEMGRIP mixture to surfaces with spatula, trowel, paint roller, brush, etc. Apply enough to leave about 4-6 mils of adhesive between the surfaces to be bonded. If one surface is porous, more adhesive must be applied to fill the voids and yet produce a final glue line thickness of 4-6 mils. (6) Mate surfaces without delay to cure at room temperature. Pressure other than that needed to keep surfaces in contact during curing is unnecessary. Assemblies can be handled in approximately 8-14 hours. CHEMGRIP develops 85% of its maximum strength in 24-48 hours. The bond advances in strength for about 1 week. Faster curing can be achieved by using heat as follows: 150°F for 120 minutes; 200°F for 45 minutes; 250°F for 30 minutes; 300°F (maximum cure temperature) for 10 minutes.

PRECAUTIONS: DURING APPLICATION, WEAR PROTECTIVE GLOVES, GOGGLES, AND SUITABLE PROTECTIVE CLOTHING. CONTAINS REGULATED CHEMICALS (SEE MATERIAL SAFETY DATA SHEET) WHICH MAY CAUSE SKIN AND EYE IRRITATION, HEADACHES, AND NAUSEA. MAY BE HARMFUL IF INGESTED, USE IN WELL VENTILATED AREA OR USE APPROVED RESPIRATORY EQUIPMENT. IF PERSON IS AFFECTED BY VAPORS, MOVE PERSON TO FRESH AIR. IF CONTACT OCCURS WITH SKIN OR EYES, FLUSH WITH PLENTIFUL AMOUNTS OF WATER FOR UP TO FIFTEEN (15) MINUTES AND SEEK MEDICAL ATTENTION. SEE APPROPRIATE NORTON MATERIAL SAFETY DATA SHEET FOR ADDITIONAL MEDICAL, DISPOSAL AND HANDLING INFORMATION.

WARNING: TOXIC, KEEP OUT OF REACH OF CHILDREN



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CHEMGRIP Treating Agent Instructions for Safe Handling and Use

Use in accordance with Norton Material Safety Data Sheet for CHEMGRIP Treating Agent.

PREPERATION: Remove all dirt, grease and impurities with acetone or methanol (highly flammable). Do not use chlorinated solvents. Allow surface to dry completely. If not, the solvent may react with the sodium in the CHEMGRIP Treating Agent. Failure to clean parts properly may cause a light etch and consequent reduction in peel-strength of the bond. Mask any areas not to be bonded using ordinary masking tape. Shake CHEMGRIP Treating Agent thoroughly before using. Always work rapidly as exposure to air renders the solution inactive.

APPLICATION: SUBMERSION: A polyethylene bag is a convenient method to treat small parts. Put the part to be treated in the bag. Squeeze out as much air as possible and tie the bag tightly against the part. Add a small amount of CHEMGRIP Treating Agent above the tie. Make a second tie above the liquid. Remove the first tie, allowing the liquid to completely coat the part for 15 to 60 seconds (until surface changes to dark brown or black). Dispose of the spent solution in accordance with instructions under "DISPOSAL". **DIPPING:** Small parts can be treated in a glass, polyethylene, steel, monel, or nickel vessel. Do not use zinc or aluminum containers. Pour enough CHEMGRIP Treating Agent into the vessel and immerse the object for 15-60 seconds (until the surface changes to dark brown or black). Dispose of spent solution in accordance with instructions under "DISPOSAL". **POURING:** Larger flat surfaces may be treated by pouring CHEMGRIP Treating Agent on the area for 15-60 seconds (until surface changes to dark brown or black). Dispose of spend solution in accordance with instructions under "DISPOSAL".

FINAL CLEANING: Remove residual CHEMGRIP Treating Agent by immersing part in n-butyl alcohol or acetone. Remove masking (if applicable). Rinse with hot water and detergent. Air-dry or rinse in solvent for rapid drying. The etched part is now ready to be bonded (CHEMGRIP Cement is specially formulated for bonding treated PTFE).

PRECAUTIONS: INFLAMMABLE LIQUID (FLASH POINT 134°F T.O.C.). KEEP AWAY FROM OPEN FLAME OR VERY HOT SURFACES. DO NOT EXPOSE UNNEUTRALIZED SOLUTION TO WATER. Use only dry soda ash or inert extinguishing agents such as DRY common salt or DRY sand to extinguish a treating fire. Do not use carbon tetrachloride (pyrene), carbon dioxide soda extinguishers, or water.

Use with adequate ventilation. Avoid prolonged or repeated breathing of vapors. Avoid contact with skin, eyes and clothing. Wear protective vinyl gloves and eyeglasses when using treating agent. If contact occurs with skin or eyes, flush area of contact with plentiful amount of cold water for at least fifteen (15) minutes and SEEK MEDICAL ATTENTION IMMEDIATELY. Remove affected clothing.

If spillage of treating solution occurs, neutralize it with dry soda ash. Absorb residual liquid on inert material. Secure in appropriate disposal container.

DISPOSAL: Dispose of in accordance with Federal, State and Local regulations.

WARNING: POISON, KEEP OUT OF REACH OF CHILDREN, DO NOT ADD WATER

Disclaimer: The information contained in this document is for information purposes only. **Aetna Plastics Corp.** is not liable for any damages resulting from use of this guide.