



## REXOLITE® ADHESIVE 12517 COMPOSITION

Styrene Monomer CAS 100 42-5  
Divinyl Benzene CAS 1321 74-0

---

24-Hour Emergency Assistance  
Call 1-800-424-9300

---

### DESCRIPTION:

Rexolite Adhesive 12517 has been developed especially for bonding Rexolite to itself. It is recommended in microwave systems where the adhesive must have good dielectric properties. Rexolite adhesive 12517 is a Rexolite resin of suitable viscosity for application by either brush or spatula. When properly formed and cured, the final joint exhibits the physical and electrical properties of Rexolite Rods and Sheets.

## INSTRUCTIONS FOR USE:

### SURFACE PREPARATION:

The areas to be cemented should be flat and true so that no air will be trapped when the surfaces are joined. A smooth machined surface has been found to be most satisfactory. The surface must be clean and any grease or oil present should be washed off with dish detergent and water. Avoid soaking with Aromatic or Chlorinated Hydrocarbons to prevent swelling.

### APPLICATION & CURE:

A primary coat of Rexolite Adhesive 12517 should be applied to both surfaces. This prime coat is allowed to set 5 to 10 minutes and is followed by a fresh application of adhesive just before mating the surfaces. By slightly softening the surfaces, the prime coat promotes better mating of parts and elimination of air pockets. After about one-half minute, pressures in the range of 10 psi may be applied provided of course, that these pressures are not too great for the particular design. Excessive pressures tend to cause stress-crazing in the joint or distortion of the assembly during the curing period.

Pressure should be applied uniformly, and it must be adequate to close any pockets in the joint and force out any air bubbles. In general, a number of small clamps is preferred to a single large one.

When properly clamped, excess adhesive can be wiped off and the assembly cured. Cure of small areas is accomplished by placing the clamped assembly in a 175°F (80°C) circulating oven for two hours. If surface is more than a few square inches or total plastic mass is more than a few pounds, cure must be lengthened to allow mass to reach a uniform internal temperature.

It is recommended that you request specific instructions for use of this adhesive on large area surfaces.

Some assemblies may be safely unclamped immediately upon removal from the oven, but any machining operation must wait until the assemblies cool to room temperature. White spaces in the joint result from incomplete adhesion of the surface and indicate inferior physical properties of the joints. If properly made, the cemented joint will be perfectly clear, and will have the same physical and electrical properties as Rexolite.

### NOTICE:

Rexolite Adhesive 12517 will slowly gel under the action of either heat or sunlight. Shelf Life of ½ pint can : 2 to 3 weeks at 25°C; 3 to 4 months Refrigerated.

These instructions are based on procedure successfully followed in our laboratories and by our customers. Since operating conditions in the user's plant are beyond our control, C-Lec Plastics, Inc. assumes no responsibility for any liabilities resulting from the use of its product, and makes no warranty.

Revised 8/1/03