



Technical Datasheet

HOLDIT AC113

Revised Date: June 2011

Description

HOLDIT AC113 is used for the Fast curing of Cyanoacrylates, depositing a correct balance of neutralising ions on the surface, stimulating attraction for the adhesive and preparing the surface for bonding. Excellerator can be used to speed cure by brushing or spraying onto the surface, applying drop wise, the superglue and then over spraying to cure fillets such as on a wire tacking jobs.

Applications

HOLDIT AC113 is primarily designed as a plastics compatible accelerator or for post curing outside the bond line. Excellerator© prevents absorption of the lower viscosity superglues into porous items. Excellerator© helps bridge gaps which decreases polymerisation time. The slower AC113 product does all the same jobs but at less speed of cure. Fast drying Excellerator© Grades are a blend of flammable solvents. Care must be taken to avoid naked flames. AC113 has the ability to reduce odours and blooming but excessive deposits will increase blooming due to rapid polymerisation.

Instructions for Use

Ensure parts are clean, dry and free from oil and grease.

Product is normally hand applied by brush from the bottle, or sprayed by pump action to allow a "mist" to form on bond surface.

Storage

Store in a cool area out of direct sunlight. See safety instructions on the flammable grade A151.
Shelf Life: 12 months @ 20°C in unopened amber bottle.

Presentation

Aerosol Can 200mls.

Product Features

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|-------------------|---|
| AC113 | Blend of Solvents 70:30 Heptane / Acetone |
| Colour | Slightly Off White/Amber |
| Viscosity @ 25°C | <10 cps |
| Cure Speed | V Fast, usual <10 secs |
| Specific Gravity | 0.87 |
| Gap Fill | Thick Superglues |
| A151 Flash Point | -17°C |
| Temperature Range | -5°C to + 25°C |

Cured Performance

Performance is dependent on the adhesive viscosity and choice of Activator. Low viscosity being faster to set and higher viscosity <10 seconds, gels dependent on techniques <30 seconds. Xa113-2 is a super fast grade usually <10 seconds.

Health & Safety in Use

Observe good housekeeping practices. Read Health & Safety Sheets.
AC113 is flammable.

Conversions

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$
 $\text{N/mm} \times 5.71 = \text{lb/in}$
 $\text{MPa} \times 145 = \text{psi}$
 $\text{N/mm}^2 \times 145 = \text{psi}$
 $\text{N} \times 0.225 = \text{lb}$
 $\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$
 $\text{N}\cdot\text{mm} \times 0.738 = \text{lb}\cdot\text{ft}$
 $\text{mPa}\cdot\text{s} = \text{cP}$