



# TECHNICAL DATA SHEET

## SC-101 Thickened Acrylic Cement

FOR CEMENTING		ADVANTAGES	
Acrylic (All Grades) Dissimilar Materials: <ul style="list-style-type: none"><li>• Styrene</li><li>• Butyrate</li><li>• PVC</li><li>• ABS</li><li>• Polycarbonate</li></ul>		<ul style="list-style-type: none"><li>• Extended working time</li><li>• Good outdoor weather-ability</li><li>• Industrial strength</li><li>• Great Joint Strength</li></ul>	
<b>SETTING TIME</b>	10 minutes	<b>VISCOSITY</b>	Medium

### GENERAL DESCRIPTION

Caseway SC-101 is a clear, thickened solvent cement for bonding acrylic to itself and other plastics such as styrene, butyrate, PVC, ABS, and polycarbonate. It dries slower than SC-125 and SC-94 permitting longer working time (4 – 6 minutes) depending on the joint and materials used. Used for various applications such as sign, displays, models, small parts, large parts, and more. The solvent in the thickened cement swells both surfaces to be cemented to permit the formation of the bond. The solvent then evaporates or dissipates through the materials leaving a clear joint with good weather resistance. Typical setting time is 10 minutes, but may be longer depending on joint type, temperature, and humidity.

### DIRECTIONS FOR USE

**Preparation:** The surfaces to be joined should be clean and fit accurately without forcing. Apply to a good saw cut, machine finish, sanded, molded, or extruded surface. Unproper sanding, scraping, or machining may cause stress (crazing). Crazing is a network of fine cracks running on, or slightly under, the surface of plastic materials. The tendency to craze is greatly increased when the stressed material is exposed to a solvent or to solvent vapors. Edges to be cemented should not be polished since polishing usually rounds corners and creates crazing.

**Application:** Apply SC-101 to one or both surfaces using a syringe, dropper, brush, or polyethylene squeeze bottle. If applying to one part, the two surfaces should be in contact for a few seconds to allow the surfaces to soften. If applying to both parts, they must be brought firmly together immediately. Press parts firmly together with a pressure of 1 to 10 psi. Uneven pressure may cause weak joint strength. The pieces should be assembled quickly before the cement on the surfaces of the “cushion” evaporates.

Parts with longer setting time such as large parts or parts with load requirements can be clamped or assembled in a jig. The clamps or jigs should keep the two parts firmly together with a pressure of 1 to 10 psi, but should not force them out of shape. If the part is flexed or forced out of shape, local areas will be stressed and may cause crazing when brought in contact with the cement. Avoid uneven pressure.

**Cure:** Joints are usually cured for handling in 10 minutes. Large areas are more difficult to bond without bubbles and may require 8 or more hours to dry. Typical joints will reach 60 – 85% strength within 24 to 48 hours and continue to increase over weeks.

\*It is the responsibility of the user to test the material compatibility and method used to apply this product before actual application.

## PRELIMINARY ANNEALING

Preliminary annealing before cementing will help eliminate or reduce stresses present in machined or saw-cut areas, which may result in crazing during application of cement. Annealing should be done less than 24 hours before cementing, if possible.

## AVAILABILITY

Available in ¼ pint (4 fl oz), pint (16 fl oz), quart (32 fl oz), gallon (128 fl oz), 5 gallon (640 fl oz), and 55-gallon drum.

## STORAGE

Industrial 3-D cement contains a solvent that will evaporate over time. Tightly cap and seal the container as best as possible. Store in the original containers in a cool, dark area away from hot surfaces, heat, sparks, flames and other sources of ignition. Store locked up in an area not accessible to children.

## SAFETY

This product is flammable and considered a hazardous material. Do not handle until all safety precautions have been read and understood. Read the product label & safety data sheet (SDS) for information on proper handling, health risks, firefighting methods, spill procedures, emergency contact information, precautionary information, disposal information & more. Safety data sheets are available at [www.casewayproducts.com](http://www.casewayproducts.com) or by emailing [support@casewayproducts.com](mailto:support@casewayproducts.com)

Wear protective gloves, protective clothing, eye protection, face protection. This product should never be used in a poorly ventilated (confined) area and without a suitable respiratory mask. This product is intended for use by experienced individuals only.

\* The information, suggestions, technical data, and advice provided on this sheet are based on test results, knowledge, and experience believed to be accurate and reliable. However, all information, suggestions, technical data, and advice are not to be considered a warranty and Caseway Industrial Products, Inc. assumes no liability for any direct, indirect punitive, incidental, special consequential damages, to property or life.