



Evaluation Procedure of Fixture Speed for Dymax Activator-Curing Adhesives

The Dymax Quality Control procedure for fixture of Dymax activator-cure adhesives allows a determination to be made as to whether a given lot of adhesive or activator is performing to specification. Please contact Dymax Application Engineering if you need a copy of the product specification.

To perform the evaluation you will need glass microscope slides, the questionable lots of the adhesive and activator, and fresh activator and adhesive. The procedure should be practiced as many times as necessary for the tester to feel the cure beginning to take place. The initiation of polymerization or cure is detected by the resistance to movement with light finger pressure as described in Step #4 of the procedure.

When there is a question as to whether the adhesive or activator is causing an out-of-spec. fixture, the following four tests should be used:

1. Fresh adhesive and the fresh activator.
2. The questionable adhesive and the fresh activator.
3. Fresh adhesive and the questionable activator.
4. The questionable adhesive and activator.

If the adhesive fixtures within specification after completing the above tests, you have effectively eliminated the adhesive and activator as the source of the problem.

The procedure provides an easy and inexpensive method of assuring your activator and adhesive are within specification. Further, it can help eliminate time consuming delays and facilitate your troubleshooting investigations.

Suggested Method for Evaluation of Fixture for Activator-Cure Adhesives

Step 1: Using glass microscope slides, apply a thin film of activator to one end of a slide. To do this, remove the brush and wipe it on the inside lip of the glass vial. Lay the brush fibers on the end of the glass slide and wipe the slide once fully across.

Step 2: Apply a small bead of adhesive to the narrow end of another glass slide. The bead should be about 1/16".

Step 3: Join the adhesive and activator ends of the slides. Overlap the ends by 3/4" to 1". Squeeze the adhesive to a thin bond line. Hold immobilized for 5 seconds.

Step 4: Starting at a time of 5 seconds, attempt to move the end of one slide relative to the other every 5 seconds. Fixture time is when the slides resist movement with light finger pressure.



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