



**DATA SHEET: ACHACE**

**Description:** ACHACE speeds the curing of cyanoacrylates where low humidity levels or surface acidity may exist. This product is used for fillet conditions or filling gaps between substrates.

**Physical Properties (@ 72°F/ 22°C):**

Liquid:	
Base compound:	Acetone
Color	colorless liquid
Viscosity (cP@68F)	1 cP
Specific gravity	0.715 (g/cc)
Flash point (TCC)	-4F
Shelf Life	18 months unopened
Percentage Volatiles (by weight)	100% @ 70F
Boiling Point	N/D
Odor	Pungent
Vapor Density	Heavier than air

**Instructions:**

Surfaces should be clean and dry  
Dispense cyanoacrylate to one surface only  
Apply ACH-ACE on surface as needed  
Can be pre-applied or post-applied to bond area.  
Let ACH-ACE evaporate if pre-applying.

**Note:**

Test surfaces first as adverse affects on plastics and other materials may occur.

**Curing Performance:**

Size of gap will affect set speed.  
Smaller gaps increase speed. May impair overall adhesive performance.

**Storage:**

Store unopened in cool, dry place out of direct sunlight.

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