

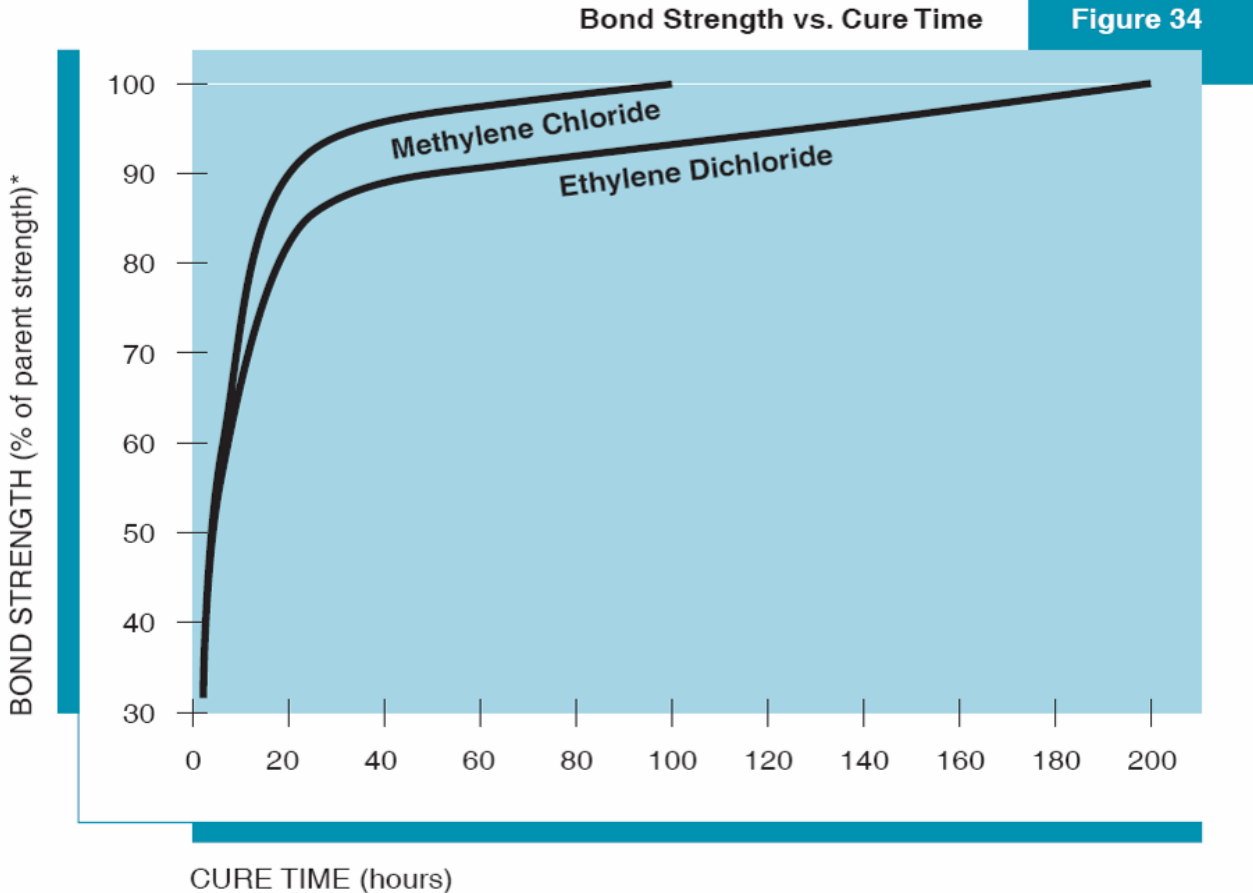
# Solvent Bonding Polycarbonate

Craig E. Nelson - Consultant Engineer

## Solvent Bonding - Polycarbonate

Like acrylics, polycarbonates can stress crack with certain types of solvents. Methylene chloride is a very fast solvent cement for polycarbonate. This solvent is recommended only for temperate climate zones and when bonding small areas. A mixture of 60% methylene chloride and 40% ethylene chloride is slower drying and the most common solvent cement used for polycarbonate parts. Ethylene chloride is recommended alone in very hot climates. These solvents may be bodied with 1-5% by weight polycarbonate resin where gap-filling characteristics are required. A joining pressure of 200 psi is generally recommended.

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Also: MDC (methylene dichloride). Add 10% glacial acetic for best joint appearance

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**Table 5** Solvent Bond Curing Schedule

<b>Sequential Holding Time</b>	<b>Part or Bond Temperature</b>
8 hr	73°F (23°C)
12 hr	100°F (40°C)
12 hr	150°F (65°C)
12 hr	200°F (93°C)
12 hr	225°F (110°C)

Table for Forced Curing of Polycarbonate