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München

Kunststoffverarbeitung

Kunststoffhandel



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Tips for repairing little crazing in a Plexiglas glazing

(For the below mentioned activities we do not assume any kind of responsibility!)

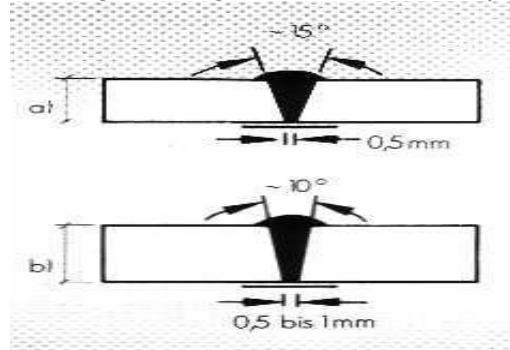
First of all the crazing needs to be secured. For this purpose, with a drill of 1-2 mm drill holes at the end of the crazing.

To this regard please note:

- the drill must be suitable for Plexiglas (drill point angle 30°)
- the extreme point of the crazing must be in the centre of the drilling hole

The next step is to mill a V-shaped gap at the position of the crazing (cf. figure). Fix an appropriate scotch at the bottom side and both extremes of the bonding gap.

IMPORTANT! The V-shaped gap must be clean of milling residues, in order to avoid cracks in the bonding. You might need to clean/scrape the V-shaped gap with a scraper.



Due to repairing, a slight optical disturbance will appear in the corresponding area. Also, due to the surface tension, micro crazings may appear in the bonding area.

Now, using an appropriate dosing device (e.g. tube, injection syringe), fill the gap with enough glue Acrifix 192 to build a toric glue excess avoiding bubbles. Let the bonding harden in light conditions for about 12 hours (avoid sunshine, for tension may cause crazings or cracks).

Once the glue is hard you grind it:

IMPORTANT! Grind wet with grinding roller or eccentric grinder (the finer the grit the less time you will need for polishing!)

1. phase: abrasive paper grit 800
- 2nd phase: grit 1500; 2400; 3200; up to 6000.

Remove remaining bits of scotch tape and polish the bonded area with polisher I and II.

Please make sure to take your time for this procedure!

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