

Usage Guide for Clifton STAR Accelerator ACC 4009

The combination of Clifton STAR Adhesive LA 4009 and Clifton STAR Accelerator is an excellent two-part adhesive for PVC- and urethane-coated materials. It cures to a high strength, heat- and chemical-resistant bond.

Mixing Proportions

Ounces of Clifton STAR Adhesive – Item # 38709.01	Milliliters of Accelerator – Item # 38712.01*	Approx. Drops of Accelerator**
2	1.0	25
4	2.0	50
8	3.75	95
16 (pint)	7.5	190
32 (quart)	15	375
128 (gallon)	60 (whole container)	1500

The correct mixing ratio is 2 ounces (60 milliliters) of Accelerator to one gallon (128 ounces) of adhesive. We've made measuring small quantities of the Accelerator easy with the included disposable transfer pipette. The stem of the pipette is marked in 0.25-milliliter graduations (see figure below). Closely follow the above mixing guidelines; more Accelerator is not better!

Measure out only the amount of adhesive you will use within an 8-hour period. Add the right amount (from the table above) of Accelerator and mix thoroughly. To prevent solvent evaporation, keep the mixture covered when not in use. After 8 hours, mixed adhesive that you haven't used should be discarded.

To aid in mixing the adhesive and Accelerator, it's handy to have a measuring device for the adhesive. We use Leaktite Multi-Mix 1-pint cups (Check at paint and hardware stores, or Google for suppliers). They have volume marks in ounces and milliliters and are disposable.

* The formula used to create this column is:

$$\text{Milliliters of Accelerator} = (\text{Ounces of Adhesive} \times 60) / 128$$

** If you don't have the graduated pipette, you can use a regular eyedropper (found at most pharmacies) to dispense the Accelerator. There are approximately 25 "drops" in a milliliter. (See chart above)

