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WHITE PAPER

X1-B8-7S
X2-B8-7S
X2-B8-7L

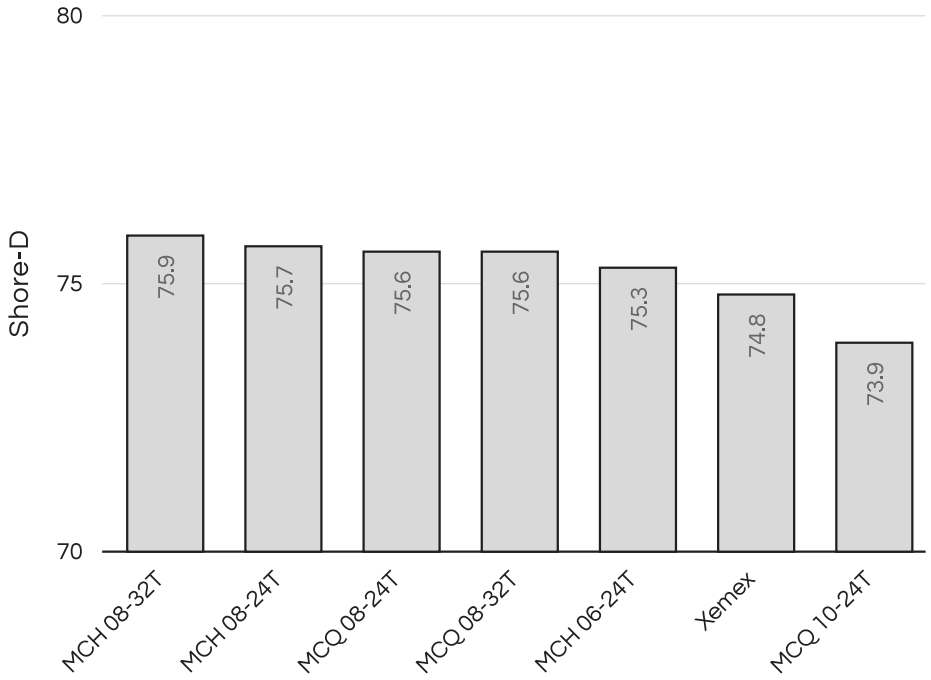
Experiment FB | June 18, 2021 | Rev. 3

Purpose To compare the mixing performance of the Xemex® Static Mixer with commercially available mixers.

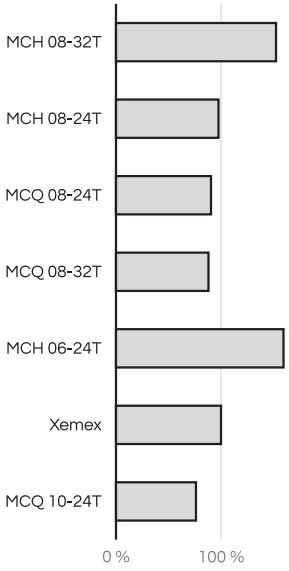
Experimental The 2-part formulation was dispensed using Re Mixer's automated cartridge dispenser, having preset flow rate and purge routines. After curing at room temperature for 24 hours, hardness was determined through a single-blind collection using Rex Gauge's RX-DD Series Durometer, and in accordance with ASTM D2240.

ITW Plexus® MA8110

Cured Hardness



Relative Pressure*



*Normalized from 1.0 mL/s constant flow rate data

Mixing Performance The hardness data suggests that Xemex yielded similar mixing performance for ITW Plexus® MA8110. With a retained volume of only 2.5 mL, Xemex matched mixers with 24 and 32 elements, which have retained volumes in the order of 5 to 10 mL. These results suggest that Xemex is a candidate to replace both helical and square mixers in applications using MA8110.

Back Pressure From this data, one should expect back pressures with Xemex to be comparable to MCQ 08-24T but lower than MCH 08-32T at equivalent flow rates.

Formulation	Type	Mix Ratio**	Mixed** (cP)	Part A**	Part B**	Working Time** (min)	Keywords
ITW Plexus® MA8110	Methacrylate	1:1	—	40,000 to 80,000	40,000 to 80,000	8 to 12	—

Laboratory Technician	Cured Time	Laboratory	Report Prepared by
Lukas Duddleston, MS	24 hours	23±2 °C | 35±5 % RH	Lukas Duddleston, MS

**As reported in ITW's Technical Data Sheet