



# MXBON®

## PRODUCT SPECIFICATION

### MXBON 302 - May 2008

### Cyanoacrylate Adhesive

### For Low Blooming and Low Odor type

#### DESCRIPTION

MXBON 302 is a low blooming and low odor type cyanoacrylate adhesive. A whitening phenomenon of the bonding area is eliminated. MXBON 302 is which can be used for bonding a variety of metals, plastics, etc.

#### PHYSICAL PROPERTIES

Liquid State		Cured State	
Base	Ethoxyethyl Cyanoacrylate	Color	Yellowish Clear
Color	clear	Specific Gravity(20°C)	1.17
Specific Gravity(20°C)	1.069	Softening Point( °C)	-55°C-65°C
Refractive Index ( n <sub>D</sub> <sup>20</sup> )	1.439	Refractive Index( n <sub>D</sub> <sup>20</sup> )	1.48
Flash Point (°C)	>80°C	Dielectric Constant(at 10MHz)	3.5
Shelf Life	6 Months	Dielectric Loss(at 10MHz)	0.067
Boiling Point(°C)	80-100/6mm Hg	Soluble in Acetone, Dimethyl formamide, nitromethane, Dimethyl sulfoxide	
Viscosity(cP).....		MXBON 302.....	40-80

#### DIRECTIONS FOR USE

1. Make sure the surfaces to be bonded are clean and dry(preferable to solvent-wipe plastics glass, and rubber, and to acid-treat metals).
2. Dispense a drop or drops to one surface only. Apply only enough to leave a thin film after compression.
3. Press parts together and hold firmly for a few seconds. Good contact is essential. An adequate bond develops in less than one minute.(Maximum strength is achieved in 24 to 48 hours).
4. Wipe off excess adhesive from the top of the container and recap MXBON 302 if left uncapped, may deteriorate by contamination from moisture in the air.
5. Because MXBON 302 polymerises on contact with moisture surfaces, sometimes whitening will occur on the surface of the container or the bonded materials. Should this happen, wipe surfaces well with debonder.

## BOND STRENGTH

(TENSILE SHEAR STRENGTH, CURED FOR 24 HOURS AT 20-25°C)

	KG/CM <sup>2</sup>		KG/CM <sup>2</sup>
Rigid PVC to Rigid PVC	25-35	SBR to SBR	5-10
ABS to ABS	50-70	Steel to Steel	140-180
Polycarbonate to Polycarbonate	80-120	Stainless steel to Stainless steel	70-100
Polystyrene to Polystyrene	80-120	Aluminum to Aluminum	70-100
Natural rubber to Natural rubber	5-9	Copper to Copper	20-35
*Neoprene to Neoprene	5-9	Steel to Rigid PVC	5-10
NBR to NBR.....	5-9	Stainless steel to Neoprene	5-10
ABS to SBR.....	5-10		

## CURE SPEED

MXBON 302	Seconds		Seconds
ABS to ABS	50-60	NBR to NBR	20-30
Wood to Wood	>60	Stainless steel to Stainless steel	>60
ABS to Stainless steel	45-55	ABS to NBR	25-35
NBR to Stainless steel	45-55	Wood to ABS	>60

## PRECAUTION

1. Use with proper ventilation. Avoid contact with skin and eyes.
2. If contact with skin occurs, rinse with warm water or dissolve gradually with appropriate debonder. Do not try to remove forcibly.
3. If adhesive gets into eye, keep eye open and rinse thoroughly. Seek medical attention immediately.
4. Keep well out of reach of children.
5. Keep adhesive in a cool, dry place 20-25°C. For long term storage, refrigeration (5°C) is recommended.

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