



PRODUCT SPECIFICATION

MXBON 680 - May 2008

Cyanoacrylate Adhesive

For RUBBER TOUGHENED

DESCRIPTION

MXBON 680 is a black ethyl cyanoacrylate, with higher peel and shock resistance than other grades. **MXBON 680** has a longer setting time than regular Cyanoacrylate adhesive which allows enough time for users to put materials together after application. It has been specially formulated to achieve the strongest possible bond between well-mated, non-porous surfaces, such as rubber, metals, plastics, etc. **MXBON 680** is a one-component, solvent-free system and does not require the use of a catalyst, heat or clamps. When a thin layer of **MXBON 680** applied between two surfaces comes into contact with atmospheric moisture, a rapid polymerization occurs producing the ultimate bond.

PHYSICAL PROPERTIES

Liquid State		Cured State	
Base	Ethyl Cyanoacrylate	Color	Black
Color	Black	Specific Gravity(20°C)	1.1~1.3
Specific Gravity(20°C)	1.053~1.060	Working Temperature(°C)	-50°C - 125°C
Refractive Index (n _D ²⁰)	1.439	Refractive Index(n _D ²⁰)	1.490
Flash Point (°C)	>80°C	Dielectric Constant(at 10MHz)	3.5
Shelf Life	6 Months	Dielectric Loss(at 10MHz)	0.067
Boiling Point(°C)	65/6mm Hg	Soluble in Acetone, Dimethyl formamide, nitromethane, Dimethyl sulfoxide	
Viscosity(cP).....		MXBON 680	500-1000

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 680** if left uncapped, may deteriorate by contamination from moisture in the air.
5. Because **MXBON 680** 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 ²		KG/CM ²
Rigid PVC to Rigid PVC	40-60	SBR to SBR	5-10
ABS to ABS	50-70	Steel to Steel	190-210
Polycarbonate to Polycarbonate	80-120	Stainless steel to Stainless steel	160-180
Polystyrene to Polystyrene	30-45	Aluminum to Aluminum	170-190
Natural rubber to Natural rubber	5-9	Copper to Copper	150-170
*Neoprene to Neoprene	5-9	Steel to Rigid PVC	50-60
NBR to NBR.....	5-9	Stainless steel to Neoprene	5-10
ABS to SBR.....	5-10		

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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