



MXBON®

PRODUCT SPECIFICATION

MXBON 606 - May 2008

Cyanoacrylate Adhesive

For EPDM

DESCRIPTION

MXBON 606 is a low viscosity, fast curing single component Cyanoacrylate Adhesive, specifically formulated for difficult to bond substrates, particularly suitable for bonding plastic or rubber (EPDM) parts, where very fast fixing is required. **MXBON 606** 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 606** 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 | Clear |
| Color | clear | Specific Gravity(20°C) | 1.05~1.2 |
| Specific Gravity(20°C) | 1.053~1.060 | Working temperature (°C) | -55 °C -80 °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 | 12 Months | Dielectric Loss(at 10MHz) | 0.067 |
| Boiling Point(°C) | 65/6mm Hg | Soluble in Acetone, Dimethyl formamide, nitromethane, Dimethyl sulfoxide | |
| Viscosity(cP)..... | | MXBON 606 | 10-30 |

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 606** if left uncapped, may deteriorate by contamination from moisture in the air.
5. Because **MXBON 606** 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 | | |

CURE SPEED

| MXBON 606 | Seconds | | Seconds |
|------------------------|----------------|------------------------------------|----------------|
| ABS to ABS | 4-6 | NBR to NBR | 3-5 |
| Wood to Wood | >60 | Stainless steel to Stainless steel | 45-55 |
| ABS to Stainless steel | 50-60 | ABS to NBR | 3-5 |
| NBR to Stainless steel | >60 | 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, refrigerate at 5 °C.

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