



TDS

MXBON[®] 601

Cyanoacrylate Adhesive (Difficult to Bond Substrates)

PRODUCT SPECIFICATION

MXBON® 601

Cyanoacrylate Adhesive (Difficult to Bond Surfaces)

Description:

MXBON® 601 is a low to medium viscosity, fast curing, single component Cyanoacrylate Adhesive which can be used for Virtually any type of fastening job. MXBON® 601 is specially formulated for difficult to bond substrates. MXBON® 601 is less dependent on surface moisture for cure speed than other CA grades. When a thin layer of MXBON® 601 applied between two surfaces comes into contact with atmospheric moisture, a rapid polymerisation occurs producing the ultimate bond.

Physical Properties:

Liquid State		Cured State	
Base	Ethyl Cyanoacrylate	Colour	Clear
Colour	Clear	Specific Gravity (20°C)	1.1~1.3
Specific Gravity (20°)	1.053~1.060	Working Temp (°C)	-55°C - 80°C
Refraction Index (nD ²⁰)	1.439	Refractive Index (nD ²⁰)	1.49
Flash Point (°C)	>80°C	Dielectric Constant (at 10MHz)	3.5
Shelf Life	12 Months	Dielectric Loss (at 10MHz)	0.067
Boiling Point (°C)	149°C	Soluble in Acetone, Dimethyl formamide, Nitromethane, Dimethyl sulfoxide	
Viscosity (cP)	100-200		

Bond Strength:

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

Substrate	KG/CM ²	Substrate	KG/CM ²
Rigid PVC to Rigid PVC	40-60	SBR to SBR	5-10
ABS to ABS	5-10	Steel to Steel	150-190
Polycarbonate to Polycarbonate	80-120	Stainless Steel to Stainless Steel	150-180
Polystyrene to Polystyrene	30-45	Aluminum to Aluminum	140-170
Natural Rubber to Natural Rubber	5-9	Copper to Copper	130-150
Neoprene to Neoprene	5-9	Steel to Rigid PVC	50-60
NBR to NBR	3-5	Stainless to Neoprene	5-10
ABS to SBR	5-10		

Cure Speed:

Substrate	Seconds	Substrate	Seconds
ABS to ABS	4-8	NBR to NBR	2-5
Wood to Wood	50-60	Stainless steel to Stainless steel	50-70
ABS to Stainless steel	50-70	ABS to NBR	2-5
NBR to Stainless steel	50-70	Wood to ABS	20-30

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Directions For Use:

1. Make sure the surfaces to be bonded are clean and dry (preferable to solvent-wipe plastics, glass, 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® 601** if left uncapped, may deteriorate by contamination from moisture in the air.
5. Because **MXBON® 601** 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.

Handling & Storage

Storage: Keep products in the unopened container in a cool dry location. The product is best when stored at 2 to 8°C. temperatures less than 2°C can adversely affect product properties. Do not freeze. Keep container tightly closed until ready for use.

Handling: Material removed from containers may be contaminated during use. Do not pour back any product to the original Container. Misuse of product will void all warranties.

Precaution

1. Use with proper ventilation. Avoid contact with skin and eyes.
2. If contact with skin occurs, rinse with warm water or dissolve with appropriate debonder. Do not try to remove forcibly.
3. If adhesive gets into your 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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