

PRODUCT DESCRIPTION

MXBON® 24919 is allyl cyanoacrylate adhesive, and it is specially formulated for the assembly of difficult-to-bond materials and where heat resistance is required. It will highly polymerize with moisture in the air for a fast cure and meet the highest industrial standards. MXBON® 24919 product does not contain solvent and use in demanding applications where exceptional performance characteristics are required. They include resistance to most types of environmental exposures, moderate heat, aging and many different chemicals, as well as high strength and fatigue resistance. In order to withstand high temperature environments, MXBON® 24919 was designed with a secondary curing mechanism that is activated at temperatures higher than 150°C (302°F). When a thin layer of MXBON® 24919 applied between two surfaces comes into contact with atmospheric moisture, a rapid polymerization occurs producing the ultimate bond strength.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Base	Allyl 2-Cyanoacrylate
Appearance (uncured)	Transparent, yellowish to yellow colored liquid
Components	Single part – requires no mixing or heating
Specific Gravity @ 25°C	1.10
Cure	Moisture
Flash point	See SDS
Application	Bonding
Viscosity, Brookfield @25°C mPa · s (cP)	2 – 6 (ISO 3104/3105)
Full cure (hrs)	24
Shelf life	6 months unopened when stored at 2-8°C

*Keep in a cool area out of direct sunlight. Refrigeration to 2-8°C gives optimum storage stability. When stored in a refrigerator, allow the adhesive to gradually warm to room temperature prior to use. It will prevent condensation inside the bottle which can reduce shelf life. Containers should be tightly sealed when not in use. The shelf-life is 6 months from date of manufacture.

TYPICAL CURING PERFORMANCE

The rate of cure can be affected by temperature, humidity, the smoothness of the surface, the closeness of the surface and specific surfaces being bonded. Although full functional strength is developed in a relatively short time, curing continues for at least 24 hours before full chemical/solvent resistance is developed.

Cure Speed vs. Substrate

The rate of cure will depend on the substrate used. Acidic surfaces such as paper and leather may have longer cure times than most plastics and rubbers. Some plastic with very low surface free energies, such as polyethylene, polypropylene, PTFE and silicone rubber may require the use of a primer. The table below shows the fixture time achieved on different materials at 25°C/50% RH. This is defined as the time to develop shear strength of 0.12 N/mm² (1.2 kgf/cm²) and the strength keeps at least 10 seconds.

Bonding Identical Substrate	Fixture time , seconds
Mild steel	20 to 50
ABS (Acrylonitrile Butadiene Styrene)	10 to 20
PC(Polycarbonate)	20 to 40
NBR(Nitrile-Butadiene Rubber)	10 to 20

Cure Speed vs. Bond Gap

The rate of cure will depend on the bond line gap. A thinner bond line will give faster polymerization and a strong bond. Large bond gaps will result in a slower cure and lower bond strength.

Cartell Activator may be used to increase cure speed.

Cure Speed vs. Activator

Cartell Cyanoacrylate Activators may be used in conjunction with Cartell Cyanoacrylate Adhesive where cure speed needs to be accelerated. Cure speeds of less than 2 seconds can be obtained. The use of an activator may reduce the final bond strength. If bond strength is critical testing on the parts is recommended to measure the effect. When using the activator apply it to one side of the bond and the adhesive to the other.

TYPICAL PERFORMANCE OF CURED MATERIAL

Adhesive Properties

Cured for 24 hrs @ 25°C

Lap Shear Strength, ISO 4587/ASTM D1002/JIS K6850

Bonding Identical Substrate	kgf/cm ²	N/mm ²	psi
GBMS (Grit Blasted Mild Steel)	198.7	19.5	2824.3
Aluminum A5754	70.8	6.9	1006.3
ABS	88.1*	8.6*	1252.2*
NBR(Nitrile-Butadiene Rubber)	6.9*	0.7*	98.1*

*substrate failure

Important Notice: Strength results will vary depending on the level of surface preparation and gap.

Cured for 24 hrs @25°C

Physical Properties

Coefficient of Thermal Expansion, ISO 11359-2, mm/mm/K	8.0 × 10 ⁻⁵
Coefficient of Thermal Conductivity, ISO 8302, W/mK	0.10
Hardness, ISO 868, Shore D	80

TYPICAL ENVIRONMENTAL RESISTANCE

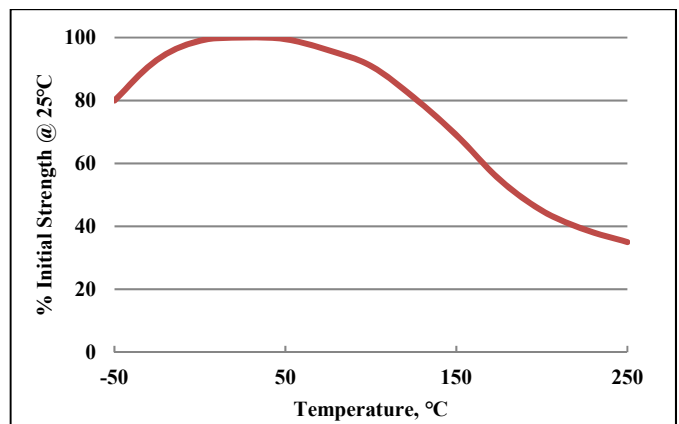
Cured for 24 hrs @ 25°C

Lap Shear Strength, ISO 4587/ASTM D1002/JIS K6850

GBMS (Grit Blasted Mild Steel)

Hot Strength

Tested at temperature



GENERAL INFORMATION

Additional information

This product is not recommended for use in contact with strong oxidizing materials and polar solvents although will withstand a solvent wash without any bond strength deterioration. Users are reminded that all materials, whether innocuous or not, should be handled in accordance with the principles of good industrial hygiene. Full information can be obtained from the Safety Data Sheet (SDS).

Directions for use:

- 1) Make sure the surfaces to be bonded are clean, dry and grease-free before applying the adhesive.
- 2) Dispense a drop or drops to one surface only.
- 3) Bring the components to together quickly and correctly aligned.
- 4) Apply sufficient pressure to ensure the adhesive spreads into a thin film.
- 5) Do not disturb or re-align until sufficient strength is achieved, normally in a few seconds.
- 6) Any surplus adhesive can be removed with solvent, such as nitromethane or acetone.
- 7) Because **MXBON® 24919** condenses by polymerization, sometimes blooming will occur on the surface of the container or the bonded materials. Should this happen, wipe surface well with acetone or nitromethane.
- 8) Product should be allowed to develop full strength before subjecting to any service loads (typically 24 to 72 hours after assembly, depending on bond gap, materials and ambient conditions).

Storage

Keep in a cool area out of direct sunlight. Refrigeration to 2-8°C gives optimum storage stability. When stored in a refrigerator, allow the adhesive to gradually warm to room temperature prior to use. It will prevent condensation inside the bottle which can reduce shelf life. Containers should be tightly sealed when not in use. Product 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. The shelf-life is 6 months from date of manufacture.

PRECAUTIONS

- 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 solvent such as acetone or nitromethane. 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 location and out of direct sunlight. For long-term storage, refrigeration(2-8°C)is recommended.
- 6) When take out the product form refrigerator, please allow adhesive to reach room temperature before opening bottle to prevent condensation inside the bottle which can reduce shelf life.

Important Notice:

Cartell Chemical Company Limited believes the information on the data sheets is reliable and accurate as is technical advice provided by the company. Cartell Chemical Company Limited makes no warranties (expressed or implied) regarding the accuracy of the information and assumes no liability regarding the handling and usage of this product. In every case we urge and recommend that purchasers before using any product in full-scale production make their own tests to determine to their own satisfaction whether the product is of acceptable quality and is suitable for their particular purpose under their own operating conditions. Cartell Chemical Company Limited further disclaims any liability for consequential or incremental damages of any kind including lost profits. No agency or representative or employee of this company is authorized to change this provision.