

### MXBON® 02770A

#### PRODUCT DESCRIPTION

MXBON® 02770A is used to make polyolefin and other low energy substrates suitable for bonding with MXBON® cyanoacrylate adhesives. The primer is HIGHLY FLAMMABLE. MXBON® 02770A is only recommended for use with difficult to bond substrates, including polyethylene, polypropylene, PTFE and thermoplastic rubber materials. It is not recommended where high peel strength is required.

#### TYPICAL PROPERTIES OF UNCURED MATERIAL

Base	n-Heptane
Color	Transparent to slightly hazy, amber liquid
Specific Gravity @ 25°C	0.698
Flash Point	See SDS
Drying time @20° C, seconds	30
On part life, hours	8
Shelf life	24 months

#### CURING PERFORMANCE

MXBON® 02770A also behaves as an activator and accelerates the cure speed of cyanoacrylate adhesive. Fixturing time on the most primed substrate is less than 5 seconds. But it should be allowed for adhesive to develop maximum bond strength after 24 hr at room temperature.

#### TYPICAL ADHESIVE PERFORMANCE

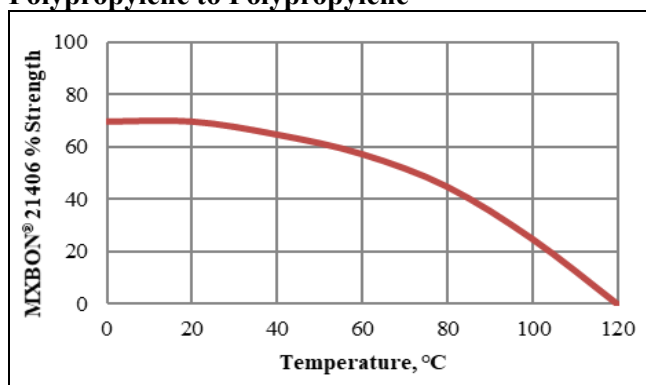
After 24 hours at 25°C.

Tensile Strength	
Polypropylene and MXBON® 21406	30 – 100 Kg/ cm <sup>2</sup>
Polypropylene and MXBON® 23496	20 – 70 Kg/ cm <sup>2</sup>
Polypropylene and MXBON® 22460	10 – 40 Kg/ cm <sup>2</sup>
Thermoplastic Rubber and MXBON® 21406	20 – 60 Kg/ cm <sup>2</sup>
PTFE and MXBON® 21406	10 – 60 Kg/ cm <sup>2</sup>

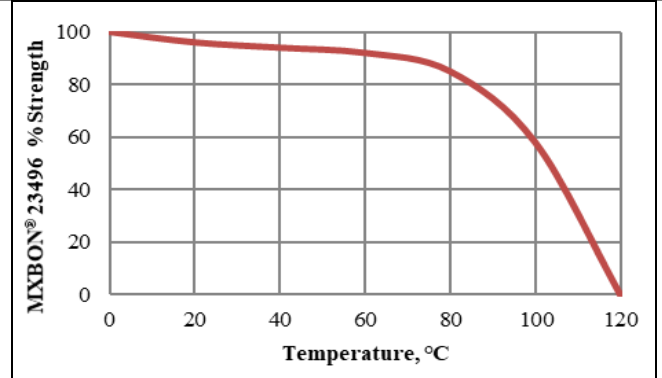
#### TYPICAL ENVIRONMENTAL RESISTANCE

##### Hot Strength:

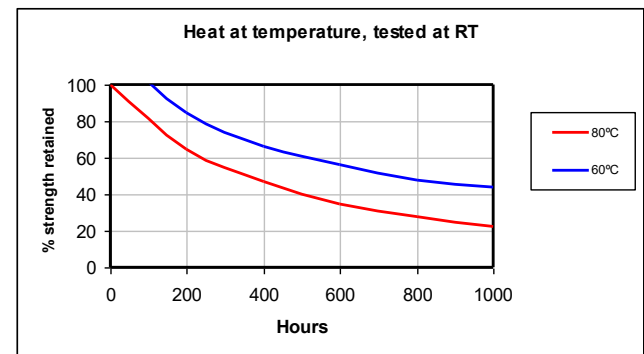
##### Polypropylene to Polypropylene



##### Mild Steel to Polypropylene



#### Heat Aging:



#### DIRECTIONS FOR USE

- Under no circumstances should the primer and the adhesive be mixed together. Use only in a well ventilated area.
- Primer may be applied by spraying, brushing or dipping. Apply MXBON® Cyanoacrylate Adhesives on to the parts to be bonded.
- Assemble parts to be bonded.

#### PRECAUTIONS

- Primer must be handled in the applicable manner to highly flammable materials, and in compliance with local regulations. Do not store near oxidizing materials.
- The solvent can affect some plastics and coatings. It is recommended that all surfaces be checked for compatibility before use.
- The primer is light sensitive and the container should be stored in the dark when not in use.
- Keep well out of reach of children.
- Keep in a cool, dry place 8-21°C.

#### Disclaimer:

The data contained herein are furnished for informational purposes only and are believed to be reliable. However, Cartell Chemical Company Limited does not assume responsibility for any results obtained by persons over whose methods Cartell Chemical Company Limited has no control. It is the user's responsibility to determine the suitability of Cartell Chemical's products or any production methods mentioned herein for a particular purpose, and to adopt such precautions as may be advisable for the protection of property and persons against any hazards that may be involved in the handling and use of any Cartell Chemical Company Ltd's products. Cartell Chemical Company Limited specifically disclaims all warranties express or implied, including warranties of salability and suitability for a particular purpose arising from sale or use of Cartell Chemical Company Ltd's products. Cartell Chemical further disclaims any liability for consequential or incremental damages of any kind including lost profits.