

### PRODUCT DESCRIPTION

MXBON® 02770M is used to make polyolefin and other low energy substrates suitable for bonding with MXBON® cyanoacrylate adhesives. The primer is HIGHLY FLAMMABLE. MXBON® 02770M 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	0.68
Flash Point	See SDS
Vapor Pressure (hPa)	< 1
Viscosity (cP)	1.25
Drying time at 20 °C, seconds	30
On Part Life, hours	≤ 8
Shelf life	24 months

### ISO-10993

MXBON® 02770M has been tested to test protocols based on ISO 10993 biocompatibility standards, as a means to assist in the selection of products for use in the medical device industry.

### CURING PERFORMANCE

MXBON® 02770M 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

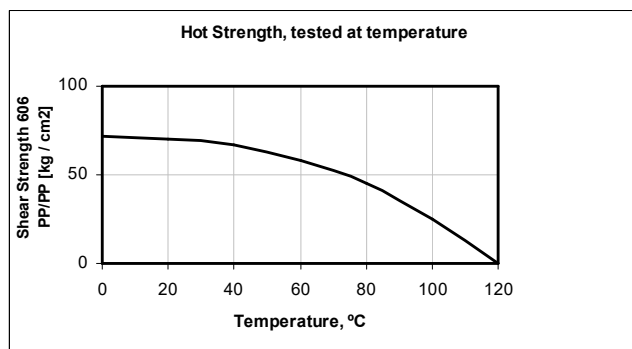
After 24 hours at 25°C.

Tensile Strength	
Polypropylene and MXBON 606	30 – 100 Kg/ cm <sup>2</sup>
Polypropylene and MXBON 703	20 – 70 Kg/ cm <sup>2</sup>
Polypropylene and MXBON 202	10 – 40 Kg/ cm <sup>2</sup>
Thermoplastic Rubber and MXBON 606	20 – 60 Kg/ cm <sup>2</sup>
PTFE and MXBON 606	10 – 60 Kg/ cm <sup>2</sup>

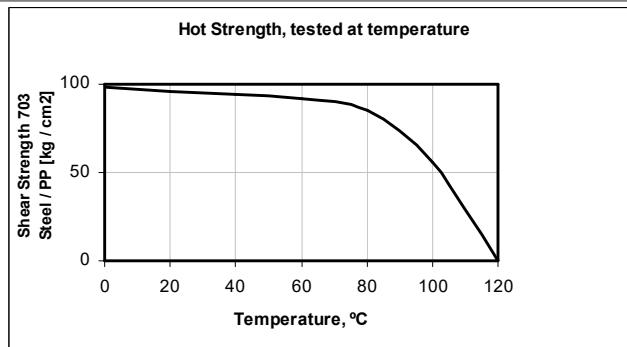
### TYPICAL ENVIRONMENTAL RESISTANCE

#### Hot Strength:

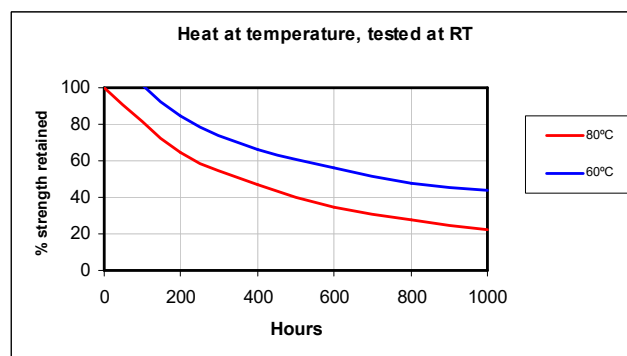
#### Polypropylene to Polypropylene



#### 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.

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