

**PRODUCT DESCRIPTION**

MXBON® 31319 is a one component acrylic-based adhesive that offers structural bonding solutions for materials such as glass, metal, ceramics and plastics. Typical applications include bonding of rear-view mirrors onto glass.

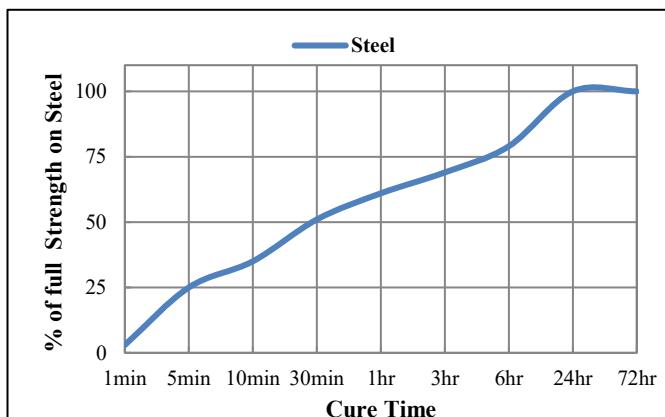
Technology	Acrylic
Chemical Type	Modified acrylic ester
Appearance (uncured)	Clear light amber liquid
Components	One component – requires no mixing
Viscosity	Medium
Cure	Anaerobic with activator
Application	Bonding

**TYPICAL PROPERTIES OF UNCURED MATERIAL**

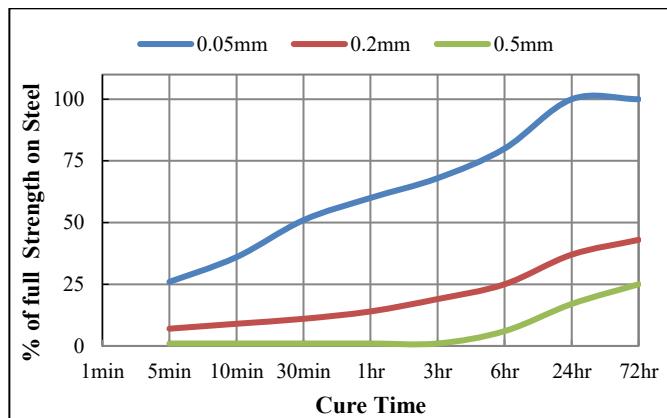
Specific Gravity @ 25 °C	1.1
Flash Point -	See SDS
<b>Viscosity, Brookfield - RVT, 25 °C, mPa·s (cP)</b>	
Spindle 3, 20 rpm	1,500 to 4,000
Shelf life	24 months unopened when stored at 8 to 21°C

**TYPICAL CURING PERFORMANCE****Cure Speed vs. Substrate**

The rate of cure will depend on the substrate used. The graph below shows the breakaway strength developed with time on grit blasted steel lap shears compared to different materials and tested according to ISO 4587. (Activator 017649 applied to one surface).

**Cure Speed vs. Bond Gap**

The rate of cure will depend on the bondline gap. The graph below shows the breakaway strength developed with time on grit blasted steel lap shears compared to different materials and tested according to ISO 4587. (Activator 017649 applied to one surface).

**TYPICAL PERFORMANCE OF CURED MATERIAL****Physical Properties**

Coefficient of Thermal Expansion, ISO 11359-2, mm/mm/K	$1 \times 10^{-4}$
Coefficient of Thermal Conductivity, ISO 8302, W/mK	0.1
Specific Heat, kJ/(kg·K)	0.3

**TYPICAL PERFORMANCE OF CURED MATERIAL****Adhesive Properties**

Cured for 1 hour @ 25 °C, Activator 017649 on 2 side  
Lap Shear Strength, ISO 4587/ASTM D1002/JIS K6850  
GBMS (Grit Blasted Mild Steel)

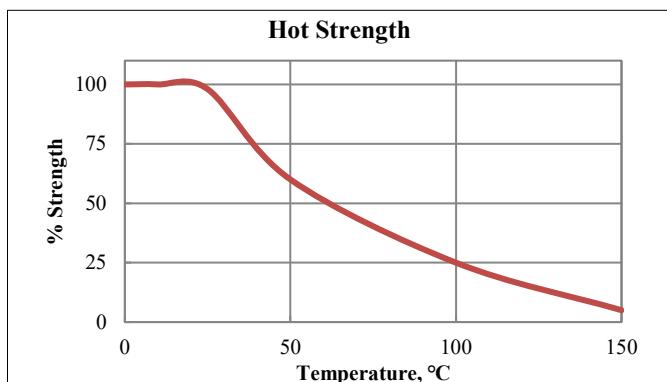
Bond Gap	N/mm <sup>2</sup>	psi
0 mm gap	$\geq 10.2$	$\geq 1479.4$
Cured for 24 hrs @ 25 °C, Activator 017649 on 2 side		
Lap Shear Strength, ISO 4587/ASTM D1002/JIS K6850		
GBMS (Grit Blasted Mild Steel)		
Bond Gap	N/mm <sup>2</sup>	psi
0.25 mm gap	$\geq 4.5$	$\geq 652.7$

**TYPICAL ENVIRONMENTAL RESISTANCE**

Cured for 1 week @ 25°C, Activator 017649 on 1 side  
Lap Shear Strength, ISO 4587/ASTM D1002/JIS K6850  
GBMS (Grit Blasted Mild Steel)

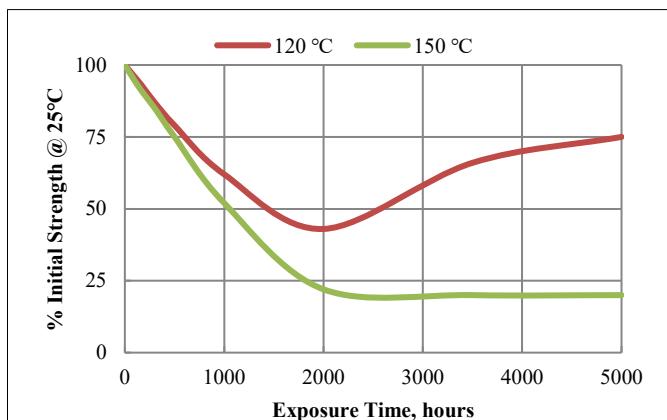
## Heat Strength

Tested at temperature



## Heat Aging

Aged at temperature indicated and tested @ 25 °C



## Chemical/Solvent Resistance

Aged under conditions indicated and tested @ 25 °C

		% of initial strength
Environment	°C	720 h
Motor oil	87	30
Gasoline	87	80
Humidity, 100% RH	50	35
Water/glycol 50/50	150	20

## GENERAL INFORMATION

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be used with chlorine or other strong oxidizing materials. Where washing systems are used to clean the surfaces before bonding, it is important to check the compatibility of the washing solution with the adhesive. In some cases, these solutions can affect the cure and performance of the adhesive. This product is not recommended for use on certain plastics. Users are recommended to confirm compatibility of the product with such substrates.

## Storage & Handling precaution

Keep adhesive in a cool and dry place. The storage temperature is recommended at 8 °C to 21 °C. For details, consult the Safety Data Sheet, (SDS). Shelf life is two years from the date of manufacture in the original container under the optimal conditions.

1. Avoid contact with skin and eyes.
2. If contact with skin, rinse with water.
3. If adhesive gets into eye, keep eye open and rinse with water thoroughly. Seek medical attention immediately.
4. Keep the material out of children's reach.

## Note

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