

PRODUCT DESCRIPTION

MXBON® 017649 is designed to accelerate the cure process for MXBON® anaerobic products.

MXBON® 017649 offers the following characteristics:

Chemistry	Activator
Appearance	Transparent, green liquid
Base chemical	Copper salt
Solvent	Acetone and Heptane
Viscosity	Low
Drying time (Seconds)	≤ 100
On Part Life (Days)	≤ 14
Application	Cure acceleration of MXBON® anaerobic products

TYPICAL PROPERTIES

Specific Gravity @ 25 °C	0.74
Viscosity @ 25 °C	< 2 cPs
Flash Point	See SDS
Fixture Time	< 60 s

Fixture time and cure speed achieved depends on the adhesive used, bond gap and whether one to side has been activated:

- Fixture time ISO 4587, (seconds) single side activation.
- Mild Steel (grit blasted) using MXBON® 31326 < 60 s

GENERAL INFORMATION

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be use 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.

Use always in a ventilated well area.

Storage & Handling precaution

Keep activator 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.

Directions for use

For assembly

1. Spray brush on the activator on both mating surfaces to be bonded. For small gaps, treatment of only one surface may be adequate. Contaminated surfaces may need repeated treatment or special degreasing prior to activation to remove any dissolvable contamination. Porous surfaces may have needed treatment with activator.
2. Allow the solvent time to evaporate under good ventilation until the surfaces are completely dry (around 100 seconds).
3. After activation, parts should be bonded within 14 days. Contamination of the surface before bonding should be prevented.
4. Apply the MXBON Anaerobic product to one or both surfaces and assemble parts immediately.
5. Where possible, move surfaces in relation to each other for a few seconds on assembly to properly distribute the adhesive and for maximum activation.
6. Secure the assembly and await fixturing before any further handling.

Note

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