



## Mitre Bonding System

### Code 726

Mitre Bonding System is a super strength bonding system that bonds MDF, soft woods, most plastics, rubber, wood to wood and many other substrates.

### PACKAGING:

1 x 12 Mitre Bonding System  
Each system contains  
1 x 50gm High Viscosity Superglue and 1 x 200ml Activator

### USES

A handy kit for use in the trade, ideal for bonding wood mitres, rubbers, plastics and ceramics. Activator accelerates the curing speed of Superglue cyanoacrylate adhesive particularly on porous, acidic or difficult to bond surfaces or when ambient temperatures are low.

### PREPARATION

Ensure surfaces are clean and dry. Test the activator on a small part of PVCU in an area that cannot be seen.

### APPLICATION

Apply the Activator before applying the Superglue.  
Hold the activator can approximately 20 cms away from surface before spraying. Do not spray for longer than 1 second, and spray onto one substrate only, and allow solvent to evaporate. Apply the superglue to the other substrate and bring together holding for approximately 10 seconds. Curing time is almost instant so exercise care when aligning.

### FINISHING

Take precautions not to spray activator near unused superglue as this will cause the adhesive to cure. Ensure surfaces are close fitting. This product is not suitable for permanent glass bonding, or applications where the joint may be immersed in water. It is the user's responsibility to dispose of all packaging correctly.

### TECHNICAL DATA - ACTIVATOR

### LIMITATIONS

When applying protect from UV rays and do not expose to temperatures exceeding +50°C. Excessive use may discolour PVCu surfaces. Do not spray onto naked flame or incandescent material.

### HEALTH AND SAFETY

**WARNING: EXTREMELY FLAMMABLE  
IRRITANT  
DANGEROUS FOR THE ENVIRONMENT  
Irritating to skin**

Very toxic to aquatic organisms, may cause long-term adverse effects in the aquatic environment. Vapours may cause drowsiness and dizziness.  
Caution - Pressurised container, protect from sunlight and do not expose to temperatures exceeding 50°C. Do not pierce or burn even after use.  
Do not spray on a naked flame or any incandescent material.  
Keep away from all sources of ignition – No Smoking.  
Ensure lighting and electrical equipment are not a source of ignition.  
Keep out of reach of children.  
Dispose of empty packaging correctly.

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# TECHNICAL DATA



<b>TECHNICAL DATA SHEET</b>	<b>ACTIVATOR</b>
<b>GENERAL CHARACTERISTICS</b>	
Appearance	Colourless
Flash Point	-17°C
Shelf Life	12 months
Storage	Store in a cool, well ventilated area. Keep container tightly closed.
Cure Speed	Very fast, usually less than 10 seconds
Viscosity	< 10 cps
Specific Gravity	0.87
Maximum Operating Temperature	-5°C to +25°C
Solvent	Blend Of Solvents 70:30 Heptane/Acetone

## TECHNICAL DATA - SUPERGLUE

<b>TYPICAL BONDING TIMES</b>	
Plastics	5 – 60 seconds depending on substrates
Rubbers	2 – 20 seconds depending on substrates
Metals (degreased)	10 - 60 seconds depending on substrates

## RELATIVE HUMIDITY CONDITIONS

Where possible the working environment should have a relative humidity of 50% +.

## LIMITATIONS

<b>PERFORMANCE DATA, TYPICAL VALUES</b>		
Steel/steel substrate values		
Tensile strength	(ASTM D2095)	28-32 N/mm <sup>2</sup> (3600-4400 lbf/in <sup>2</sup> )
Tensile shear strength	(ASTM D1002)	15-20 N/mm <sup>2</sup> (2300-2700 lb/in <sup>2</sup> )
Impact strength	(ASTM 950)	1.8-2.0 N/mm <sup>2</sup> (8-9 lb/in <sup>2</sup> )

## PHYSICAL PROPERTIES OF LIQUID ADHESIVE

Monomer	Ethyl cyanoacrylate
Appearance	Colourless
Specific Gravity	1.06
Viscosity @ +25°C (Brookfield)	1500 cPs
Flash point (Cleveland open cup)	>85°C
Shelf life (stored below 25°C)	12 months minimum
Cure Speed With Activator	<5 seconds
Cure Speed Without Activator	15-20 seconds
Gap Fill	0.25
Maximum Operating Temperatures	-60°C to +90°C

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PHYSICAL PROPERTIES OF CURED ADHESIVE	
Refractive index (ND20)	1.46
Hardness (Rockwell)	85
Specific resistance OHM/cm	$8 \times 10^{12}$
Dielectric constant @ 1MHZ	3.44
Softening point	+150°C

### CAUTION

Contains Cyanoacrylate – DANGER - Bonds skin and eyes within seconds.  
Keep out of reach of children.

### IRRITANT

Irritating to eyes, respiratory system and skin.  
Do not breath vapour.  
Avoid contact with skin and eyes.  
In case of contact with eyes, rinse immediately with plenty of water and seek medical advice.

### IMPORTANT STORAGE INSTRUCTIONS

Store in original sealed upright container between +3°C and +20°C in a dry area out of direct sunlight.  
The lower the temperature the longer the ultimate shelf life, but allow product to reach room temperature before use.

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