

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
Vapor Pressure (hPa)	< 1
Viscosity (cP)	1.25
Drying time at 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 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

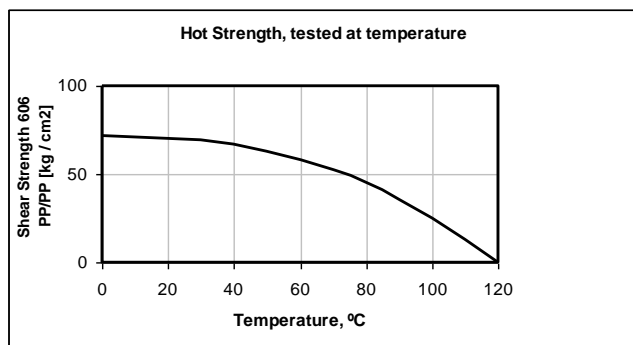
After 24 hours at 25°C.

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

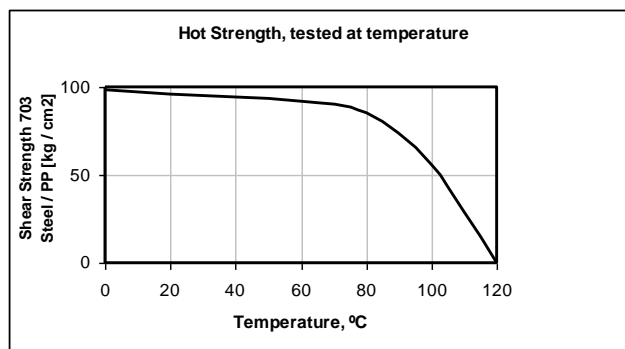
TYPICAL ENVIRONMENTAL RESISTANCE

Hot Strength:

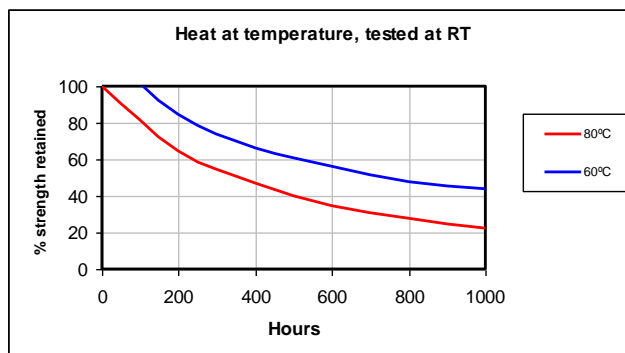
Polypropylene to Polypropylene



Mild Steel to Polypropylene



Heat Aging:



DIRECTIONS FOR USE

1. Use only in a well ventilated area.
2. Primer may be applied by spraying, brushing or dipping. Apply **MXBON® Cyanoacrylate Adhesives** on to the parts to be bonded.
3. Assemble parts to be bonded.

PRECAUTIONS

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

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