



MITRE KIT

Revision: 12/10/2005

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Product:

Mitre Kit is a two part instant adhesive system comprising a cyanoacrylate adhesive and aerosol activator.

Technical data:

Base	2-component cyanoacrylate
Curing system	Chemical curing
Adhesive Consistency Colour Specific gravity (DIN 53479) Brookfield viscosity (mPa.s)	Liquid Clear, colourless Approx. 1.05 g/cm ³ Approx. 90 - 120
Activator Consistency Colour Specific gravity (DIN 53479)	Liquid Colourless Approx. 0.79 g/cm ³
Mixture Pot-life at 21°C and 50% RH	 Approx. 1 – 3 sec.

* This varies according to ambient conditions such as temperature, humidity, substrate etc.

Product:

Mitre Kit is a fast acting cyanoacrylate based adhesive with activator which is particularly useful for production lines and UPVC window trim bonding.

Characteristics:

- Activator reduces blooming
- Activator reduces odour
- Fast acting
- Curing will occur almost instantly
- Easy to use

Applications:

Mitre Kit is mainly used in the furniture, timber, kitchen and plastics industries where its instant bonding properties dramatically reduce assembly times for mitre joints when compared to conventional wood adhesives. The product is also suitable for instant bonding of MDF, rubber, PVCu, metals and most plastics, as well as finding uses in

the electronics industry, where again rapid assembly of components is essential.

Surfaces:

Type: porous and non porous substrates

State of surface: Mitre Kit should be applied to an even, dry, clean and smooth substrate.

Preliminary treatment: non

We recommend a preliminary compatibility test.

Applying the adhesive:

Method: Spray a small quantity of Activator onto one substrate only. Allow solvent to evaporate. Apply Cyanoacrylate adhesive to the other substrate and bring together. Curing will occur almost instantly

Application temperature: +5°C to +35°C

Clean: Cured adhesive must be removed mechanically.

Repair: with same material

Remark: The directives contained in this documentation are the result of our experiments and of our experience and have been submitted in good faith. Because of the diversity of the materials and substrates and the great number of possible applications which are out of our control, we cannot accept any responsibility for the results obtained. In every case it is recommended to carry out preliminary experiments.



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Mechanical properties:**Cure Speed**

Balsa / Balsa	<5 seconds
Oak / Oak	90-180 seconds
Nitrile / Nitrile	<5 seconds
Neoprene / Neoprene	<5 seconds
EPDM / EPDM	<5 seconds
Steel / Steel	10-20 seconds
PVC / PVC	3-10 seconds
Polycarbonate / Polycarbonate	10-40 seconds

Shear Strength

Grit Blasted Steel	>15 N/mm ²
Etched Aluminium	>11 N/mm ²
Nitrile Rubber	>10 N/mm ²
Polycarbonate	>12 N/mm ²

Tensile Strength

Grit Blasted Steel	>18 N/mm ²
Nitrile Rubber	>5 N/mm ²
Neoprene Rubber	>5 N/mm ²
EPDM Rubber	>2,5 N/mm ²

Packaging Adhesive:

Colour: colourless
Packaging: 50g bottle

Packaging Activator:

Colour: colourless
Packaging: 200mL aerosol spray

Shelf life Adhesive:

12 months in unopened original packaging in a dry storage place at temperatures between +10°C and +22°C. Avoid exposure to strong light and heat sources. Refrigeration can prolong shelf life.

Shelf life Activator:

At least 12 months in unopened original packaging in a dry storage place at temperatures between +5°C and +25°C.

Health- and safety recommendations:

Apply the usual industrial hygiene precautions. Wear protective gloves. Consult the label for more information.

Recommendations:

- Take precautions not to spray Activator near unused Cyanoacrylate adhesive as this will cure off

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