

# Technical Data Sheet

TDS REAR VIEW MIRROR ADHESIVE Revised

03.08.10



## Rear View Mirror

### TECHNICAL FEATURES

#### PRODUCT DESCRIPTION

Rear View Mirror is an Anaerobic Structural Adhesive based on modified Urethane Acrylic technology for bonding of rigid parts such as Rear View Mirrors in-place, Ferrite to Metals in loudspeakers, magnets, discs, electric motors etc.

#### APPLICATIONS

Typical applications are where tough, shock resistant bonds of high production speeds are necessary. Magnet bonding as described in above applications are typical of its usefulness.

#### USEFUL HINTS/NOTES

Rear View Mirror Adhesive is used with our special Activator to speed cure. Use Rear View Activator with Rear View Adhesive for metal, glass, ceramic and ferrite bonding, including plated metals. Accelerated cure is achieved without Activator @120°C for 30-60 minutes.

#### PROPERTIES

Typical Gap Design: 0.1mm  
Maximum Gap Design: 0.5mm  
Tensile Strength: Up to 25 N/mm(2)  
Max. Temp@60% Retained Strength - 85°C  
Max. Temp@100% Retained Strength -60°C

#### INSTRUCTIONS FOR USE

Ensure parts are clean, dry and free from oil and grease.

#### PROCEDURE FOR APPLICATION

Product is normally hand applied from the bottle.

#### COMPATIBLE ACCELERATOR/PRIMERS

(Standard Anaerobic Activator) can be used, however it reduces speed of cure to 2 minutes).

#### STORAGE

Store in a cool area out of direct sunlight.

#### HEALTH & SAFETY IN USE

IRRITANT: Contains Methacrylate Esters and some products contain small amounts of Acrylic Acid. Irritates eyes, the respiratory organs and the skin. In case of contact with the skin wash immediately with plenty of water.

|                              |                    |
|------------------------------|--------------------|
| Resin                        | Urethane Acrylate  |
| Colour                       | Clear - Amber      |
| Cure speed with activator    | <1 minute          |
| Cure speed without activator | <10 mins           |
| Viscosity                    | 6,000 - 10,000 cps |
| Gap fill                     | 0.05 mm preferred  |
| Flash point                  | >100°C             |
| Shelf life                   | 12 months at 20°C  |
| Max operating temperature    | + 120°C            |

### CURED PERFORMANCE

|                       |                  |
|-----------------------|------------------|
| Full cure time        | 24 hours         |
| Tensile strength      | 15 - 25 N/mm (2) |
| Static shear strength | 10 - 25 N/mm(2)  |

#### GAP SIZE/CURE RATE RELATIONSHIP

Minimum 0.05mm - Fix <2 mins, Full Cure <6 hours  
Medium 0.25mm - Fix <15 mins, Full Cure <16 hours  
Maximum 0.5mm - Fix <2 hours, Full Cure <36 hours

#### GAP SIZE/STRENGTH RELATIONSHIP

Minimum Gap - 100% Strength Medium Gap - >65% Strength  
Maximum Gap - >45% Strength

#### PRESENTATION

Bottles.....2ml

PRECAUTIONS: This product and the auxiliary materials normally combined with it are capable of producing adverse health effects ranging from minor skin irritation to serious systemic effects. None of these materials should be used, stored, or transported until the handling precautions and recommendations as stated in the Material Safety Data Sheets (MSDS) for this and all other products being used are understood by all persons who will work with the product.

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