Kem Vibra-TITE 302

High Setting Cyanoacrylate Adhesive

Product Description

Kem Vibra-TITE 302 is a High viscosity rubber toughness, medium setting velocity ethyl cyanoacrylate adhesive . Spesial Resistance to high temperture, impact,vibration and moisture.

Applications:

Kem Vibra-TITE 302 is ideal for Automotive rubber parts, loudspeaker voice coils, strain relief of components, cable tying in computers, mounting electrical components, bonding auto bumper strips.

Physical Properties

#	Parameter	Specifications
1	Base Compound	**Ethyl Cyanoacrylate**
2	Appearance	**Colorless**
3	Viscosity, cp @ 20DegC	**80 - 100**
4	Specific Gravity	**1.06**
5	Flash Point	**>80°C**
6	**Shelf Life @ 8°C (as Packed)**	**6 Months**

Curing Properties

Ambient surface moisture will initiate the hardening process. Handling strength is reached in a short period of time and varies depending on environmental conditions and substrates being bonded. Product will continue to cure for at least 24 hours.

Setting Properties (22°C, 50% RH)

Tensile Shear Strength 0.1N/mm2 (ASTM D 1002)

#	Material	
1	Steel	10 – 20 sec
2	Aluminum	10– 20 Sec.
3	Neoprene/EPDM	< 10 Sec.
4	ABS	15– 20 sec
5	Polycarbonate	10 – 20 sec.
6	PVC	10 – 20 Sec.
7	Wood	10 – 40 sec.

Curing Time:

Under normal conditions, the atmospheric moisture initiates the curing process.

Although full functional strength is developed in a relatively short time,curing continues for at least 24 hours before full chemical /solvent resistance is developed.

Setting Time depends on the kind of adherent – whether it is acidic or basic and also on the relative presence of moisture on the adherent surface.

Cure Speed

Plastic to Plastic	10-20 seconds
Rubber to Rubber	10-20 seconds
Metal to Metal	10-20 seconds

Cured Polymer

Appearance	**Colorless Liquid**
Service Temperature Range	**-55 to 82°C**
Gap filling	**0.05 mm**
Full Cure Time	**24 Hours**
Tensile strength (Steel/Steel) ASTM D1002	**≥9.8N/mm2**

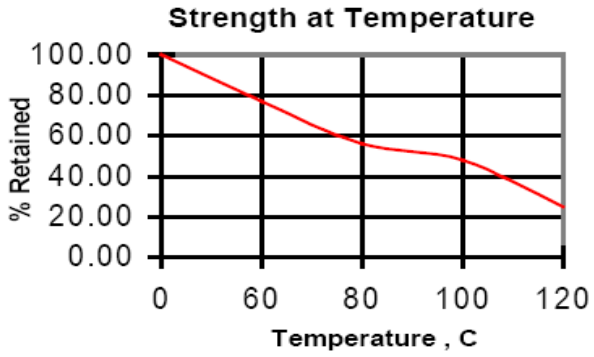
Performance of Cured Material

Tensile Shear strength after 48 hours at 20° to 25°C

Substrate	Range in N/mm²
Blasted Steel	10 – 20
Etched Aluminum	10 – 20
Neoprene/EPDM	> 10
ABS	> 5
Polycarbonate	> 5
PVC	> 6

Temperature Range

Sheer Strength on steel after 1 week at 22 °C



Chemical Resistance

Chembond Chemicals Limited (Industrial Adhesives Division)
EL-71, 'Chembond Centre', TTC Industrial Area, M.I.D.C. Mahape, Navi Mumbai – 400710
Ph – 022 – 3921 3000, Fax – 022- 2768 1294, visit us at www.chembondadhesives.com

Sheer strength on steel after 12 month soak

Application Instructions

For best results degrease / abrade and make sure the surface is clean and free from dirt, dust and contamination . If Setting time is too long due to large gape and low relative humidity. If the porosity of surface is higher, higher viscosity type shouled be better.

General Information

Surfaces to be bonded should be clean and dry. Dispense a drop or drops to one surface only. Apply only enough to leave a thin film layer after compression. Press parts together and hold firmly for a few seconds. Good contact is essential. An adequate bond develops in less that one minute and maximum strength is attained in 24 hours. Wipe off excess adhesive from the top of the container and recap. Cyanoacrylate products if left uncapped may deteriorate by contamination from moisture in the air. Because Cyanoacrylate products cure by polymerization, whitening may appear on the surface of the container or the bonded materials. Should this happen, wipe surfaces well with acetone.

Storage

The adhesive should be stored at less than 22ºC always.

Health & Safety

Danger,irriant

Avoid Contact with Eyes And skin, bonds skin in seconds. In Case Of eye Contact, Flush with Plenty Water For Over 15 minutes, call a physician immediately. Use in Well- Ventilated place. Avoid Contact Clothing ,it Can Cause very strong heat

Exposure to sunlight and heat should be avoided.

Adhesive should not be mixed with any other component and water.

Avoied contact with skin, fingers,eyes or any other part of the body.

NOTE TO USER

The information contained in this document while based on evidence and reliable methods can not be considered exhaustive. This information are current to the date of issuance of this data sheet.

The user, under its own responsibility, shall respect all the existing provisions on hygiene and safety and shall verify every time the features and the specific and appropriate way to use the product, cause the respect of the provisions is not under producer's direct control. The manufacturer does not guarantee nor assume any liability or responsibility for whatsoever harm that might result from a misuse of the product or for damages that have arisen after the product's distribution.