

Product Description

Kem Vibra-TITE 303 is a Quick setting, low viscosity ethyl Cyanoacrylate that bonds acidic, insensitive surface and porous substrates even under low humidity condition.

Physical Properties

Parameter	Specifications
Base Compound	Ethyl Cyanoacrylate
Appearance	Colorless
Viscosity, cp @ 25°C	1.5 -5.0 cps
Specific Gravity 25°C	1.04
Flash Point (TCC)	>84°C
Shelf Life @ 8°C & 50°C (as Packed)	12 Months

Curing Properties

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.

Setting Properties (20°C, 85% RH)

Material	
Plastic	2 – 15 sec
Rubber	2– 15Sec.
Metal	2 - 30Sec.
Wood	2 – 30 sec

Curing Performance

The gap of the bond line will affect set speed. Smaller gaps tend to increase the speed. Activators can be applied to improve set speed but may also impair overall adhesive performance.

Polymer Cured

Appearance	Colorless Solid
Service Temperature Range	-53 to 95°C
Softening Point	155°C
Refractive Index (ND 20)	1.49
Full Cure Time	24 Hours
Di-electric Strength (kv/mm)	11.3
Di-electric Constant (@ 1 kC)	5.6
COE (in./in./C)	0.000126
Tensile strength (Steel/Steel)	3200 Psi
Solubility	Nitromethane, Acetone, Dimethylformamide

Performance of Cured Material

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

Substrate	Range in N/mm ²
Blasted Steel	18 – 26
Etched Aluminum	11 – 18
Neoprene	> 10
ABS	> 5
Polycarbonate	> 5
PVC	> 6

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 than 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

Refrigeration at 5°C provides optimum storage stability.

Note

Prior to use, remove all surface contaminants such as oil or grease. Products like isopropyl alcohol can be used. Test compatibility of cleaner with substrate. Make sure surface is completely dry before bonding.

Health & Safety

1. The adhesive should be stored at less than 22°C always.
2. Exposure to sunlight and heat should be avoided.
3. The adhesive should not be mixed with any other compound or water.
4. Avoid contact with skin, fingers, eyes or any other part of the body.

Using Method:

The ease of usage of instant adhesive CBO is primarily because it can be

applied at normal temperature as it is a single component adhesive. No heat is required to bond the adherents

The process of applying instant adhesive CBO is as follows:

The appropriate grade of instant adhesive CBO should be selected

based on the adherents and the purpose.

For best performance bond surface should be clean.

Apply instant adhesive CBO on the surface of the adherent. It can be spread evenly and thinly.

Put the adherents together and a light pressure will bond them together easily.

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.