

Product Description

Kem Vibra-TITE 306 is a low viscosity ultrafast setting velocity ethyl cyanoacrylate adhesive specially formulated for difficult to bond substrates like EPDM to EPDM rubber, EPDM rubber to Metal bonding etc.

Applications:

Kem Vibra-TITE 306 is ideal for bonding plastics, TPR Elastomers, difficult to bond rubber compounds like EPDM, nitrile, neoprene, viton,EVA, SBS rubber, ABS, Plasticized & rigid PVC. For polyolephine PE & PP bonding cyanoacrylate primer is recommended.

Physical Properties

#	Parameter	Specifications
1	Base Compound	Ethyl Cyanoacrylate
2	Appearance	Colorless
3	Viscosity, cp @ 20DegC	15-26
4	Specific Gravity	1.05
5	Flash Point	>80
6	Shelf Life @ 8°C (as Packed)	9 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 – 30 sec
2	Aluminum	2– 10 Sec.
3	Neoprene/EPDM	< 10 Sec.
4	ABS	2– 10 sec
5	Polycarbonate	15 – 40 sec.
6	PVC	2 – 10 Sec.
7	Wood	10 – 40 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.

Cure Speed

Plastic to Plastic	2-30 seconds
Rubber to Rubber	2-30 seconds
Metal to Metal	2-30 seconds
Wood to wood	2-30 seconds

Cured Polymer

Appearance	Colorless Solid
Service Temperature Range	-55 to 82°C
Gap filling	0.05 mm
Full Cure Time	24 Hours
Tensile strength (Steel/Steel) ASTM D1002	10-20N/mm ²

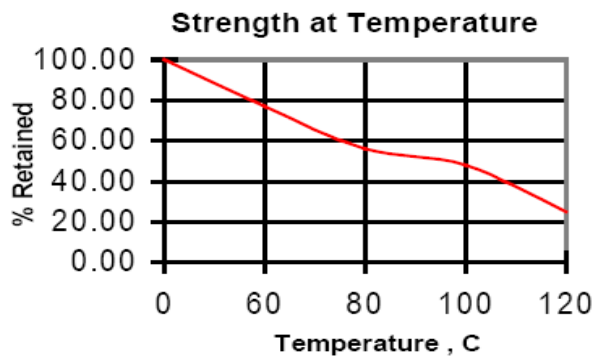
Performance of Cured Material

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

Substrate	Range in N/mm ²
Blasted Steel	10 – 26
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

Sheer strength on steel after 12 month soak

	% Strength Retained
Motor Oil	80
Gasoline	90
Tri-chloroEthane	90
Freon TA	100

Application Instructions

For best results degrease / abrade and make sure the surface is clean and free from dirt, dust and contamination such as mould-release agents. Apply a thin film or drop or glue line to one surface only and bring both parts together holding firmly for a few seconds until the parts achieve handling strength.

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

CAUTION: SuperGlues bond skin and eyes on contact. If accidental skin bonding occurs, wash area with warm soapy water and slowly pry skin apart using a blunt object (such as a teaspoon handle.) In case of eye contact, bathe immediately with water and seek immediate medical attention.

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.