

### Product Information

Cedesa Mirror Bonder is a one component, medium viscosity structural anaerobic adhesive that is designed to be cured with a mesh pad impregnated with catalyst to give very fast handling strength.

### Application

Cedesa Mirror Bonder and its impregnated mesh pad are primarily designed as a rear view mirror bonder for cars. The product can also be used for bonding aerials, catches etc. to windows.

### Technical data

Chemical type	Urethane methacrylate
Appearance	Amber
Specific gravity	1.08
Viscosity <sup>1</sup>	2200 - 3000
Tensile Strength <sup>2</sup>	2 – 5 N/mm <sup>2</sup>
Fixture time <sup>3</sup>	< 45 seconds.
Full cure (20°C) <sup>4</sup>	24 Hours
Flash point (°C)	> 100
Max gap fill	0.3 mm
Operating temp (°C)	- 50 to +130°C
Intermittent temp (°C)	- 50 to +150°C

<sup>1</sup> Brookfield LVF, spindle 2, 2.5 rpm, 25°C

<sup>2</sup> Grit blasted mild steel to glass, ASTM D2095-69, with mesh pad inserted in bond. No glass breakage should be seen (24hours).

<sup>3</sup> With mesh pad.

<sup>4</sup> All figures relating to cure speed are tested at 20°C, lower temperatures will result in significantly slower curing times.

The impregnated mesh insert is a nylon cloth coated with organometallic activator and is dark green in colour.

### Storage and shelf life

Cedesa Mirror Bonder has a shelf life of 12 months when stored in sealed container at < 20°C.

### Directions for use

- § Ensure all surfaces to be bonded are clean, dry and free from grease.
- § Trim the mesh to the shape of the mirror foot, or the mirror-mounting button if fitted and then remove.

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## Technical Data Sheet

- § Clean off any remains of previous adhesive and mark the position where the mirror is to be fitted.
- § Apply the adhesive to the foot of the mirror, or the mirror-mounting button if fitted. Evenly cover the area of contact with a thin coat of adhesive.
- § Place the mesh on top of the adhesive and apply immediately to the marked position on the windscreen. Hold firmly in place for at least one minute and then do not disturb for a further 15 minutes. The bond will reach full cure over the next 24 hours.

### Resistance

Cedesa Mirror Bonder is suitable for use at temperatures up to 130°C. At 130°C the bond strength will be approximately 10% of its strength at 21°C.

Cedesa Mirror Bonder retains over 95% of its strength when heated to 100°C for 90 days then cooled and tested at 21°C.

Cedesa Mirror Bonder exhibits excellent chemical resistance to most oils and solvents including motor oil, petrol, brake fluid, ethanol, glycols and water. This product is not recommended for use in pure oxygen or chlorine lines.

### Important Note

For safe handling of this product consult the Material Safety Data Sheet.

It is recommended that testing is carried out on plastics prior to bonding as uncured product may induce stress cracking in some circumstances.

Some anti-corrosion chemicals inhibit the cure system in this type of product. Trials are recommended to establish whether cleaning of the parts is necessary.

Whilst all reasonable care is taken in compiling technical data on the company's products, all recommendations or suggestions regarding the use of such products are made without guarantee, since the conditions of use are beyond the control of the Company. It is the customer's responsibility to satisfy himself that each product is fit for the purpose for which he intends to use it, that the actual conditions of use are suitable and that in the light of continued research and development the information relating to each product has not been superseded.

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