



KROXX MX2

TECHNICAL

1. PRODUCT DESCRIPTION

Kroxx Mx2 is Instant Superglue Methyl Cyanoacrylate is a wicking type, methyle based instant super glue that is Primarily used for bonding smoth, even close fitting Metal parts. It exhibits high bond strength and fast cure times.

2. TYPICAL APPLICATIONS

I deally suited for bonding or wicking pre-assembled or fitted parts. Locks calibration or set screws against tampering or vibration loosening.

3. PROPERTIES OF UNCURED MATERIAL

Resin	Methyl Cyanoacrylate
Appearance	Clear Liquid
Viscosity	2 ~ 5cps
Flash Point	> 185°C
Shelf Life	12months at 5°C
Max.OperatingTemp.	-20°C to 80°C
Typical Cure Speed	metal / metal <20 sec
	plastic/ plastic <3sec
	rubber/ rubber NA
Full Cure Time	24hours at 20°C
Tensile Shear Strength	2500-3915 psi

4. DIRECTIONS FOR USE

Bond speed is very fast so ensure that parts are properly aligned before bonding.
 Activators may be required if there are gaps or porous surfaces. Some plastics may require Primer.
 Ensure parts are clean, dry and free from oil and grease.
 Product is normally hand applied from the bottle. Apply sparingly to one-surface and press parts firmly together until handling strength is achieved. As a general rule, as little cyanoacrylate as possible should be used – over application will result in slow cure speed and lower bond strength.

5. STORAGE

Store in a cool area out of direct sunlight. Refrigeration to 5° C gives optimum storage stability.

6. CURE SPEED VS. BOND GAP

Kroxx superglues give best results on close fitting parts. The product should be applied in a very thin line in order to ensure rapid polymerisation and a strong bond. Excessive bond gaps will result in slower cure speeds. Cyanoacrylate Activators may be used to greatly increase cure speeds

7. CURE SPEED VS. ENVIRONMENTAL CONDITIONS

Kroxx superglues require surface moisture on the substrates in order to initiate the curing mechanism. The speed of cure is reduced in low- humidity conditions. Low temperatures will also reduce cure speed. All figures relating to cure speed are tested at 21°C.

8. TYPICAL ENVIRONMENTAL RESISTANCE

Hot strength

Kroxx superglues are suitable for use at temperatures up to 80°C. At 80°C the bond will be approximately 70% of the strength at 21°C. The bond strength at 100°C is approximately 50% of full strength at 21°C.

Heat ageing

Kroxx superglues retain over 90% of their strength when heated to 80°C for 90 days and then tested at 21°C. Heating the bond to 100°C and then testing at 21°C gives bond strength of approximately 50% of initial strength.

Chemical / Solvent Resistance

Kroxx superglues exhibit excellent chemical resistance to most oils and solvents including motor oil, leaded petrol, ethanol, propanol and freon. Cyanoacrylates are not resistant to high levels of moisture or humidity over time.

9. DATA RANGES

The data contained in this data sheet may be reported as typical value and/or range. Values are based on actual test data and are verified on a regular basis.

NOTES

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