

TECHNICAL INFORMATION

DESCRIPTION

M100XF Is a light to medium viscosity cyanoacrylate developed especially for Almost ready to fly Aircraft. Use for demanding wicking applications. Excellent adhesion and cure speed on difficult to bond plastics and rubbers and contaminated or acidic surfaces.

APPLICATIONS

High performance wicking and bonding of close-fitting parts including: plastics, rubbers, metal, wood, leather, fabric and composites to themselves or in various combinations.

USEFUL HINTS/NOTES

Bond time is extremely fast, align parts prior to assembly. Also for locking parts that are pre-assembled.

PROPERTIES

Very low Viscosity

Speed: Metal/Metal <20seconds
Plastic/Plastic <10 seconds
Rubber/Rubber <5 seconds

INSTRUCTIONS FOR USE

Test on non-essential portion to ensure compatibility first. Ensure parts are clean, dry and free from oil and grease. Product is applied direct from the bottle. Apply sparingly to one side and hold parts together until handling strength is achieved. Bonding can be immediate so careful, speedy alignment of parts is required. Store in a cool area out of direct sunlight. Refrigeration to 40 F gives optimum storage stability.

COMPATIBLE ACCELERATORS/PRIMER

MH16 Activators can be used for fillet cure or for priming absorbent surfaces.

MEDIUM INSTANT M100XF Super Fast/High Performance

TECHNICAL FEATURES

Resin: Alkyl Cyanoacrylate
Color: Clear
Cure Speed with Activator: < 5 seconds
Cure Speed without Activator: 2- 20 seconds*
Viscosity : 110 cps
Gap Fill:005"
Flash Point: >185°F
Shelf Life: 24 months @ 40°F
Specific Gravity: 1.06
Max. Operating Temperature: -65°F to + 185°F
* Depending on substrate

CURED PERFORMANCE

Full Cure Time: 24 hours @ 68°F
Tensile Shear Strength: 3000-3700 psi

STORAGE

Store in a cool area out of direct sunlight. Refrigeration to 40 F gives optimum storage stability.

PRESENTATION

Bottles: 1oz

HEALTH & SAFETY IN USE

Contains Cyanoacrylate bonds skin and eyes in seconds. If accidental skin bonding happens, use Debonder M68DB and wash with warm soapy water and rise skin apart using a blunt instrument (such as a teaspoon handle). In case of eye contact, bath immediately with water and seek immediate medical attention.

KEEP OUT OF REACH OF CHILDREN

**REVISED 03/25/07
M100XF**

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