

### PRODUCT DESCRIPTION

MXBON® 41131 is a transparent, colorless, light-curing general purpose acrylic adhesive. Suitable for stress-sensitive plastics and can be cured at high speed. Mainly used to bond hard or flexible PVC to PC polycarbonate, its flexible properties improve the ability of the bonding surface to withstand loads. MXBON® 41131 is primarily used for plastic-to-plastic bonding, but can also be used on many different substrate surfaces.

<b>Chemical Type</b>	Acrylated urethane
<b>Appearance (uncured)</b>	Light yellow
<b>Components</b>	One component – requires no mixing
<b>Viscosity</b>	Low
<b>Cure</b>	Ultraviolet (UV) light and/or Visible light
<b>Application</b>	Bonding
<b>Specific Gravity @25 °C</b>	1.1
<b>Viscosity, mPa·s (cP) Brookfield-RVT (@25 °C)</b>	
<b>Spindle 1, 20 rpm</b>	200 to 400
<b>Shelf life</b>	Storage in 8 °C to 21 °C , 12 months (Unopened condition)

### TYPICAL CURING PERFORMANCE

MXBON® 41131 can be cured by UV light and/or visible light of 365nm、395nm and 460nm. To obtain full cure on surfaces exposed to air, radiation 220 to 260 nm is also required. Fixture time and cure speed achieved depend on substrate used, bonding gap, UV intensity, exposure time and spectrum distribution of light source.

#### Fixture time

Fixture time is defined as the time to develop the shear strength of 0.1 N/mm<sup>2</sup>.

UV Fixture Time, ISO 4587, Glass microscope slides, seconds:

$$6 \text{ mW/cm}^2 @365\text{nm}, \leq 15$$

UV Fixture Time, ISO 4587, Polycarbonate, seconds:

$$30 \text{ mW/cm}^2 @365\text{nm}, \leq 5$$

$$100 \text{ mW/cm}^2 @365\text{nm}, \leq 5$$

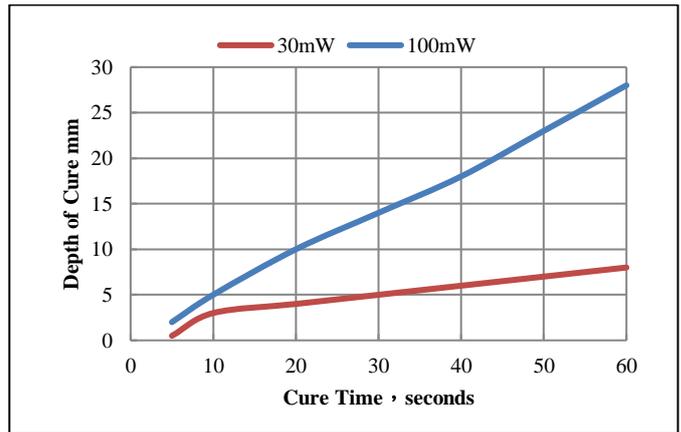
Tack free time :100 mW/cm<sup>2</sup> @365nm, ≤ 20

Deep (1-3 mm) Fixture time : 100 mW/cm<sup>2</sup>, ≤ 60

#### Depth of Cure vs. Irradiance (365 nm)

The graph below shows the increase in depth of cure with time at 50mW/cm<sup>2</sup> - 100mW/cm<sup>2</sup> as measured from the thickness of the cured pellet formed in a 15mm diameter PTFE die.

### Curing System: Metal Halide (Doped)



### TYPICAL PROPERTIES OF CURED MATERIAL

Cured @ 30 mW/cm<sup>2</sup>, measured @ 365 nm, for 80 seconds using a glass filtered metal halide light source

#### Physical properties

<b>Durometer (Shore D), ISO 868</b>	60
<b>Max. Operating Temperature (°C)</b>	-54 to 149
<b>Refractive index (%)</b>	1.5

#### Electrical characteristics

<b>Dielectric strength, IEC 60250 (kv/mm)</b>	28
<b>Volume resistivity, IEC 60093 (Ω·cm)</b>	8.1 x 10 <sup>14</sup>
<b>Dielectric constant, IEC 60250 @1-kHz</b>	4.67
<b>Dielectric dissipation factor, IEC 60093 @1-kHz</b>	0.02

### TYPICAL PERFORMANCE OF CURE MATERIAL

#### Adhesive properties

Cured @ 30 mW/cm<sup>2</sup>, measured @ 365 nm, for 80 seconds using a glass filtered metal halide light source (samples with 0.5 mm gap).

Lap shear strength, ISO 4587

Polycarbonate

Substrate	N/mm <sup>2</sup>	psi
PC / PC	12*	1740*

\* substrate failure

### TYPICAL ENVIRONMENTAL RESISTANCE

Cured @ 30 mW/cm<sup>2</sup>, measured @ 365 nm, for 80 seconds using a metal halide light source, (samples with 0.5 mm gap).

Lap Shear Strength, ISO 4587:

Polycarbonate

**Chemical/Solvent Resistance**

Aged under conditions indicated and tested @ 22 °C.

Environment	°C	% of initial strength		
		2H	24H	170H
Boiling water	100	*100	-----	-----
Water immersion	49	-----	-----	*100
Isopropanol immersion	21	-----	*100	-----
Heat/humidity	38	-----	-----	*100

\* substrate failure

**GENERAL INFORMATION**

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be use with chlorine or other strong oxidizing materials. Where washing systems are used to clean the surfaces before bonding, it is important to check the compatibility of the washing solution with the adhesive. In some cases, these solutions can affect the cure and performance of the adhesive. Users are recommended to confirm compatibility of the product with such substrates.

**Storage & Handling precaution**

Keep adhesive in a cool and dry place. The storage temperature is recommended at 8 °C to 21 °C. For details, consult the Safety Data Sheet, (SDS). Shelf life is one years from the date of manufacture in the original container under the optimal conditions.

1. Avoid contact with skin and eyes.
2. If contact with skin, rinse with water.
3. If adhesive gets into eye, keep eye open and rinse with water thoroughly. Seek medical attention immediately.
4. Keep the material out of children’s reach.

**Note**

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