

### CLEAR STRUCTURAL ADHESIVE W/ACTIVATOR PART NO. 52401 PART A - ACTIVATOR

#### DESCRIPTION

*Dynatex® Structural Adhesive Activator* is a highly reactive surface activator designed to speed cure rates of acrylic adhesives and specially designed *Dynatex® Structural Adhesive Activator*. *Dynatex® Structural Adhesive Activator* can also be used as a cleaner for substrate preparation.

#### PHYSICAL PROPERTIES

##### Liquid

Base Compound .....	Acetone
Appearance.....	Green Liquid
Viscosity (cps @ 68 <sup>0</sup> F) .....	2 cP
Flash Point (TCC) .....	-4 <sup>0</sup> F
Shelf Life @ 40 <sup>0</sup> F.....	2 months in unopened containers
Boiling Point.....	210 <sup>0</sup> F
Odor .....	Pungent
Density (DIN 51562).....	0.786 g/cc

#### GENERAL DIRECTIONS

1. Apply adhesive as a bead or in drops to ensure enough material is applied for filling the bond-line with a small amount of squeeze out.
2. Apply Activator to the other mating bonding surface in a thin film using the applicator brush or with another applicator.
3. Assemble the parts and fixture with light clamp pressure for a minimum of 10 second where good contact of parts is evident.
4. Larger gaps will take longer to fixture and reach full cure strength. For gaps over 0.020", use Activator on both parts and apply adhesive over one activator primed surface, being careful not to touch adhesive applicator to the other primed surface.

**NOTE:** May adversely affect some plastics and other materials. **Test First.**

#### HEALTH PRECAUTIONS

*Dynatex® Structural Adhesive Activator* is highly reactive and should be stored away from heat, open flame, or ignition sources. Keep containers tightly closed. Use in a well ventilated area.

**STORAGE**

Must be stored in temperatures less than 90°F.

For safe handling information on this product, consult the Material Safety Data Sheet, (MSDS).

**CLEAR STRUCTURAL ADHESIVE  
PART B – ADHESIVE**

**DESCRIPTION**

*Dynatex® Clear Structural Adhesive* is a medium viscosity, fast curing adhesive for bonding metals, magnets or ferrites, ceramics, and glass. *Dynatex® Clear Structural Adhesive* can be heat-cured at temperatures of 200°F in less than ½ hour to total cure, fixtures in minutes with heated parts. Fixture speeds can be greatly increased with the use of *Dynatex® Clear Structural Adhesive Activator*.

**PHYSICAL PROPERTIES**

**Liquid**

Base Compound .....	Modified Acrylic
Appearance.....	Amber Liquid
Viscosity (cP @ 68°F).....	12,000 cP
Flash Point (COC) .....	>200°F
Shelf Life @ 40°F.....	6 months unopened
Odor .....	Pungent
Toxicity .....	Low to moderate, See MSDS
Specific Gravity .....	1.08 (20/20°C)

**Solid**

Shore D Hardness.....	65-70
Tensile Shear Strength.....	>3500 psi on Aluminum
Thermal Service Range .....	-65°F to 325°F
Solvent Resistance.....	Very good
Elongation .....	25%

**Electrical Properties**

Volume Resistivity .....	>1 x 10 <sup>14</sup> ohm-cm
Surface Resistivity .....	>2 x 10 <sup>13</sup> ohm-cm
Dielectric Strength.....	>450 volts per mil

## GENERAL INSTRUCTIONS

1. Apply adhesive as a bead or in drops to ensure enough material is applied for filling the bond-line with a small amount of squeeze out.
2. Apply *Activator* to the other mating bonding surface in a thin film using the applicator brush or with another applicator.
3. Assemble the parts and fixture with light clamp pressure for a minimum of 10 second where good contact of parts is evident.
4. Larger gaps will take longer to fixture and reach full cure strength. For gaps over 0.020", use *Activator* on both parts and apply adhesive over one *activator* primed surface, being careful not to touch adhesive applicator to the other primed surface.

## HEAT CURE

Cure at 200<sup>0</sup>F for ½ hour bond-line temperature, higher temperatures will produce faster cures.

## STORAGE

Product should be stored in a cool dry place out of direct sunlight. Shelf life can be extended by refrigeration.

## USERS PLEASE READ

The information and data contained herein is believed to be accurate and reliable; however, it the user's responsibility to determine suitable of use. Since the supplier cannot know all the uses, or the conditions of use to which there products may be exposed, no warranties concerning the fitness or suitability for a particular use or purpose are made.

It is the user's responsibility to thoroughly test any proposed use of our products and independently conclude satisfactory performance in the application.

Likewise, if the application, product specifications or manner in which our products are used require government approval or clearance, it is the sole responsibility of the user to obtain sure authorization.

The supplier warrants only that its products will meet its specifications. There is no use, nor any other express or implied warranty. The users exclusive remedy and the suppliers sole liability is limited to refund of the purchase price or replacement of any product when to be otherwise than as warranted. The supplier will not be liable for incidental or consequential damages of any kind.

Suggestions of uses should not be taken as inducements to infringe any patents.

**Dynatex**<sup>®</sup> A division of Accumetric, LLC

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