Dynatex® *A division of* SOUDAL Accumetric

TECHNICAL DATA SHEET

REAR VIEW MIRROR ADHESIVE
PART NO. 49401, PART A & B

PHYSICAL PROPERTIES
PART A - ACTIVATOR

UNCURED PROPERTIES (Liquid)
- Viscosity ..... 5 cPs
- Specific Gravity..... 0.75 (20/20^{0}C)
- Color ..... Bluish-Green
- Flash Point..... 70^{0}F (COC method)
- Toxicity.....Low to moderate, see MSDS

Solvents-IPA
Filler-None
Base Carrier – IPA **Percent Solids** – 5%
CURING PROPERTIES (Solid)
- Type of Cure.....Activator cure, heat accelerated
- Cure Parameters..... 25-40 seconds @ 23^{0}C
- Thermal Service Range .....-60^{0}F to 125^{0}F
- Gap Cure ..... 0.010" – one side activation
  ..... 0.020" – two-side activation

CURED PROPERTIES (Solid) typical bond thickness 0.003"
- Tensile Shear Strength.....>2000 psi on steel
  >1600 psi on steel
- Thermal Service Range .....-65^{0}F to 250^{0}F

DESCRIPTION
PART A – ACTIVATOR

Dynatex® *Rear View Mirror Activator* is a low viscosity, isopropyl based activator for rearview mirror bonding and other glass to metal applications. When used with ***Dynatex®*** *Rear View Mirror Adhesive*, this activator fixtures parts within 40 seconds (2kg dead weight pick up) and produces shear strength of 2000 psi between durable substrates such as glass to glass or to metals.

FEATURES

- Blend of toughness and high tensile shear strength
- Fast evaporation of IPA
- Strong fixturing in 40 seconds
- Excellent surface wetting

TYPICAL APPLICATIONS

- All foreign and domestic metal rearview mirror mounting buttons

DIRECTIONS FOR USE
(Typical Process Methods)

1. Clean surfaces to be mated.
2. Apply Activator to one of the mating surfaces in a thin film using the applicator.
3. Allow solvent to flash.
4. Apply ***Dynatex®*** *Rear View Mirror Adhesive* to other surface to be mated, assemble parts and fixture with light pressure for a minimum of 40 seconds where good contact of parts is evident.
5. Allow 5-15 minutes for final cure. Disturbing the fixture during this time could result in a weaker bond. Fixture time is dependent on gap between parts and temperature of parts. Larger gaps require more time for the activator to promote cure through the gap. If gap is over 0.010" use activator on both parts and apply adhesive over one activator-primed surface.

PART B – ADHESIVE INFORMATION ON BACK

PHYSICAL PROPERTIES
PART B - ADHESIVE

UNCURED PROPERTIES (Liquid)

Viscosity	Light gel (30,000–40,000 cPs @ 2rpm)
Specific Gravity	1.05 (20/20^{0}C)
Color	Amber
Flash Point	>200^{0}F (COC method)
Toxicity	Moderate, see MSDS

Solvents - None
Component Parts - Two
Filler - None
Base Resin – modified urethane acrylic
Percent Solids – 100%

CURING PROPERTIES (Solid)

Shore D Hardness	60-65
Tensile Shear Strength	>2500 psi on steel
Thermal Service Range	-60^{0}F to 125^{0}F
Solvent Resistance	Good
Impact Strength	>13 ft-lbs/in^2

DESCRIPTION
PART B - ADHESIVE

Dynatex® *Rear View Mirror Adhesive* is a medium viscosity, toughened adhesive system for metals and glass, which gives good tensile shear strength, and outstanding performance for peel, cleavage, fatigue and impact shock loading. ***Dynatex®*** *Rear View Mirror Adhesive* is formulated for very fast curing on smooth surfaces and can fixture in less than 30 seconds when used with a metal (blue or green) based activator or an amine (yellow) based activator. Cured performance shows excellent adhesion and bond strength to glass, sintered metals, aluminum, steel and plated metals.

FEATURES

- Blend of toughness and high tensile shear strength
- Excellent for metal and glass bonding
- Light gel viscosity for Non-sag, Non-migration on porous surfaces
- 100% solids formulation for VOC compliance and safety
- Can be used with solvent-based or solvent less activators

TYPICAL APPLICATIONS

- All foreign and domestic metal rearview mirror mounting buttons

SHELF LIFE

12 months when packaged into small sachets of 2-3 grams.

DIRECTIONS FOR USE
(Typical Process Methods)

1. Clean surfaces to be mated.
2. Apply Activator to metal surface and allow material to dry.
3. Apply adhesive to other surface to be mated and position fixture on the glass. Hold firmly for 1 minute to develop initial cure.
4. Allow 5-15 minutes for final cure. Disturbing the fixture during this time could result in a weaker bond. Fixture time is dependant on gap between parts and temperature of parts. Larger gaps require more time for the activator to promote cure through the gap. Temperatures below 230^{0}C require longer cure times. Run defroster in winter or cold weather to heat glass surface to speed cure. If applied in direct sunlight to a hot windshield, fixture speed will greatly increase.

USERS PLEASE READ

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