

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°C)
Color.....	Bluish-Green
Flash Point.....	70°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°C
Thermal Service Range.....	-60°F to 125°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°F to 250°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.

**PHYSICAL PROPERTIES
PART B - ADHESIVE**

UNCURED PROPERTIES (Liquid)

Viscosity ... Light gel (30,000–40,000 cPs @ 2rpm)
Specific Gravity 1.05 (20/20°C)
Color Amber
Flash Point >200°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°F to 125°F
Solvent Resistance Good
Impact Strength >13 ft-lbs/in²

**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°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

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.

**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.

Dynatex® A division of Accumetric, LLC

Dynatex
350 Ring Road
Elizabethtown
Kentucky 42701 USA
(800) 999-2937
TEL (270) 769-5557
FAX (270) 769-6418
Outside U.S.
TEL +1(270) 769-5557
FAX +1(270) 769-6418

Accumetric Asia Pacific, LTD
18 Kitpanit Bldg. 5th Floor
#502 Patpong Road
Suriyawong, Bangrak
Bangkok, 10500 Thailand
TEL (662) 634-3060
FAX (662) 634-3066

Email: sales@dynatexinc.com
Website: www.dynatexinc.com