



SUPERBOND MITRE KIT

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DESCRIPTION

GRAFT® Superbond Mitre Kit consists of an industrial grade cyanoacrylate adhesive and aerosol accelerant activator. GRAFT® Superbond Adhesive has been specially formulated to achieve the strongest possible bond between rough or irregular surfaces, on most metals, plastics or rubbers. GRAFT® Superbond Adhesive is a one-component, solvent-free system and does not require the use of a catalyst, heat or clamps.

Once GRAFT® Superbond Activator is applied, it significantly increases the cure speed of GRAFT® Superbond Adhesive. This product kit is used primarily on wood mitre joints or on porous, acidic or difficult to bond surfaces and uPVC.

FEATURES

Used together an almost instant bond is attained. Ideal for fine joints such as mitres where a close aesthetically pleasing joint is required. GRAFT® Superbond Adhesive is also solvent free.

Bonds in seconds:

- MDF
- Wood
- Rubber
- Plastics

Remark: As a part of our policy of on-going product development and testing, we reserve the right to modify, alter or change product specifications without giving notice. All information contained in this document is given in good faith and is provided for guidance only. Any drawings provided are for illustrative purposes only. As Polyseam has no control over the methods or competence of installation and of prevailing site conditions, no warranties, expressed or implied, are intended to be given as to the actual performance of the product mentioned or referred to herein and no liability whatsoever will be accepted for any loss, damage or injury arising from the use of the information given.



APPLICATION INSTRUCTIONS

Ensure both surfaces to be bonded are clean, dry and free from grease. Lightly spray one the surfaces to be bonded with GRAFT® Superbond Mitre Kit Activator. If the applied activator is running off the substrate as a liquid, too much has been applied and may lead to discolouration or staining of the surface.

Allow the activator to dry. Apply a thin layer of GRAFT® Superbond Mitre Kit Adhesive to the other surface. Bring both surfaces together to achieve a bond. Depending on the substrates being used and the temperature a rapid bond will be typically formed in 2-10seconds.

STORAGE AND SHELF LIFE

GRAFT® Superbond Mitre Kit Activator should be stored between 5°C and 30°C, away from direct sunlight. It has 12 months shelf life.

GRAFT® Superbond Mitre Kit Abhesive storage life below 5°C is 12 to 18 months. It has a 12 months shelf life.

PACKAGING

GRAFT® Superbond Mitre Kit Activator - 200ml
GRAFT® Superbond Mitre Kit Abhesive - 50gm



CURING PERFORMANCE

There are many factors that can influence the rate of cure. These include: the types of substrate used, the condition of the surface to be bonded, the smoothness of the surface, the closeness of the surfaces, the atmospheric conditions.

CURE SPEED/SUBSTRATE

Steel to Steel	20 - 50 seconds
Stainless Steel	30 - 90 seconds
Aluminum	10 - 30 seconds
Zinc plated	40 - 90 seconds
ABS to ABS	15 - 40 seconds
ABS to NBR	5 - 15 seconds
ABS to Wood	5 - 10 seconds
NBR to NBR	5 - 10 seconds
Polycarbonate	20 - 60 seconds

ADHESIVE PERFORMANCE

Tensile Strength	
Steel	190 - 210 Kg/ cm ²
Stainless Steel	250 - 450 Kg/ cm ²
Aluminum	170 - 190 Kg/ cm ²
Copper	150 - 170 Kg/ cm ²
PVC	40 - 60 Kg/ cm ²
ABS	50 - 70 Kg/ cm ²
Polycarbonate	80 - 120 Kg/ cm ²
Polystyrene	30 - 45 Kg/ cm ²
NBR	5 - 9 Kg/ cm ²
SBR	5 - 10 Kg/ cm ²

After 24 hours at 25°C.

TYPICAL PROPERTIES OF CURED MATERIAL

The rate of cure depends on the bond-gap. A smaller bond-gap results in faster cure speeds.

Physical Properties	
Coefficient of Thermal Expansion (K ⁻¹)	100 x 10 ⁻⁶
Coefficient of Thermal Conductivity (W/m.K)	0.10
Working temperature	-55°C - 80°C
Electrical Properties	
Volume Resistivity (Ω cm)	1 x 10 ⁻¹⁶
Surface Resistivity (Ω)	1 x 10 ⁻¹⁶
Dielectric Constant @ 10 kHz	2.30
Dielectric Dissipation Factor @ 10 kHz	<0.02
Dielectric Breakdown Strength (kV/mm)	25

TYPICAL PROPERTIES OF UNCURED MATERIAL

Base	Ethyl Cyanoacrylate
Colour	Transparent, colorless to yellowish colored liquid
Specific Gravity @ 25°C	1.05
Refractive Index (n D ²⁰)	1.439
Flash Point	See MSDS
Vapor Pressure (hPa)	< 1
Viscosity (cP) ,25°C	1000 - 1500

HEALTH AND SAFETY

Extremely flammable. Keep in well ventilated place away from sources of ignition. Do not breathe vapour or empty in drains. Do not pierce or burn after use. Avoid contact with eyes, will bond skin and eyes in seconds. Keep out of reach of children.

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