

MR Series Moisture-Resistant Instant Adhesives Pacer® Technology (Distributed By DYMAX Corporation)

Pacer® MR Series Adhesives are specially formulated to resist moisture and humidity while retaining tensile shear strength, impact strength, and heat resistance. Three viscosity ranges are available to meet a variety of bonding application needs.

PROPERTIES: LIQUID STATE

	MR-10	MR-290	MR-3000
Chemical Type	-----	Ethyl Hybrid	-----
Viscosity Range, cps	6 -- 12	250-350	2500-3500
Specific Gravity (25/4Cel)	1.05	1.05	1.05
Flashpoint (COC Fahr)	185	185	185
Vapor Pressure @ 70Cel, mmHg	1	1	1
Soluble In:	Acetone, MEK, Nitromethane		

PROPERTIES: CURED STATE

Service Temp. Range	(-65° to +260°F) (-54° to +127°C)		
Gap Fill, Typical, Inches	0.002	0.012	0.020
Elongation %	5	5-10	10-15
Tensile Shear - Steel (psi)	3,140	2,850	2,840
- Aluminum (psi)	1,930	2,130	2,200
Impact Strength (ft-lbs/in(2))	5-10	5-10	5-10
T-Peel Strength (lb/in)	8.8	13.4	14.7
Soluble In:	Pacer® X-8 Debonder, Acetone		

TENSILE SHEAR STRENGTH TESTING, PSI

Water Resistance: Steel/Steel immersed in 40°C (104°F) water

	MR-10	MR-290	MR-3000
Initial	3140	2850	2840
30 Days	1190	1400	1520

Heat Aging @ 120°C (248°F)

	MR-10	MR-290	MR-3000
Initial	3140	2850	2840
30 Days	740	1270	1690

Hot Strength

	MR-10	MR-290	MR-3000
Initial	3140	2850	2840
120C (248°F)	2300	1720	1520
150C (302°F)	1380	1350	1240

Thermal Shock 1 Cycle: -20°C (-4°F) for 3 hours, 1 hour ramp, 70°C (158°F) for 3 hours

	MR-10	MR-290	MR-3000
Initial	3140	2850	2840
10 Cycles, psi	2640	2410	2500

Note: Values are typical and should not be used as product specifications.

APPLICATION AND CURE CHARACTERISTICS

For best results, use a minimal amount of adhesive. In general, one free-falling drop covers one square inch of bond area. Fixture time and full cure rates are dependent upon temperature, relative humidity, bondline thickness, and substrates being bonded. Pacer® Accelerators can be used to promote quicker cures when necessary.

SAFETY AND HANDLING PRECAUTIONS

Cyanoacrylate adhesives bond skin in seconds. In case of skin contact, flush with water. If skin becomes bonded, peel (not pull) apart after immersion in warm, soapy water.

In case of eye or mouth contact, flush with water, get immediate medical attention.

Use with adequate ventilation. Vapors can irritate eyes and mucous membranes. Symptoms disappear after removal of individual from vapors.

For more information, refer to Material Safety Data Sheet available upon request. In case of emergency, call Pacer® Technology at 1-800-538-2091 (outside CA only), or 1-909-987-0550.

The data contained herein is furnished for descriptive purposes only and is believed to be reliable. Users of any products described in the data sheet have the responsibility to determine the suitability for their particular use thereof, and Pacer® relies upon such users to adopt all necessary precautions to ensure the protection of property and persons against hazards involved in the use thereof.

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