

MEGANITE®

TECHNICAL BULLETINS

MEGANITE® BONDING SYSTEM

DOCUMENT PURPOSE

This document provides an overview on Meganite® bonding system.

PRODUCT OVERVIEW

Meganite® bonding system, a semi-automated mix and dispense system composed of a dual component cartridge, static mixer and a hand-held dispenser.

This system accurately measures, mixes and dispenses the correct amount of pre-colored adhesive, providing consistent results, invisible seams, fast and uniform cure, reliable bond strength and minimal waste!



ADHESIVE INFORMATION

Meganite® adhesive is methacrylate-based, non-sagging and thixotropic, providing good adhesion for Meganite® solid surface. It is intended for rigidly bonding two surfaces of same composition. It is not intended for bonding dissimilar materials unless specifically approved by Meganite®.

Meganite® adhesive can be considered a low emitting material that will not negatively impact indoor air quality. It is available in 50 ml and 250 ml cartridges and a variety of colors which are color-coordinated with Meganite® Solid Surface.

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Adhesive Characteristics

Description	Property	Result
Component A	Density (22°C)	1.01±0.02 g/cm ³
	Viscosity	18,000 – 220,000 CPS
	Shelf Life	2 years * Store in a cool and dry place at temperatures between 10°C to 18°C.
Component B	Density (22°C)	1.04±0.02 g/cm ³
	Viscosity	4,000 – 6,000 CPS
	Shelf Life	2 years
Meganite® Adhesive Ratio 10:1 of Component A : Component B	Working Time (24°C)	8 – 10 mins
	Fixture Time (24°C)	18 – 22 mins
	Recommended Bond Line	0.02 – 1.0 mm
	Recommended Operating Temperature	15 – 30°C * Use at temperatures below 12°C or above 32°C may cause incomplete cure, yellowing and poor bonding strength.

Cured Adhesive Physical Properties

Meganite® adhesive was allowed to cure 3 days at room temperature (24°C) prior to evaluation.

Property	Result
Flexural Strength	4,000 – 6,000 PSI

READ BEFORE USE

Before use, all users should review the product SDS for hazard information and guidance on proper protective equipment. Meganite® adhesive is flammable. Keep away from heat, sparks, open flame and other sources of ignition. It should only be used in well ventilated areas.

Meganite® adhesive is optimized for use at room temperature. Lower temperature will reduce the cure rate, while elevated temperature will increase cure rate and reduce working time. Meganite® adhesive may be used with manual or pneumatic dispenser. Refer to dispenser instructions for guidance on use.

The adhesive should always be used by its expiration date as shown on the label.

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WARNING

MEGANITE® ADHESIVE SHOULD ONLY BE USED BY PERSONNEL WHO HAVE REVIEWED THE SDS, INSTRUCTIONS ON USE AND ARE WEARING THE PROPER PROTECTIVE EQUIPMENT.

KEEP OUT OF REACH OF CHILDREN.

DO NOT EAT. AVOID DIRECTLY CONTACT WITH EYES AND SKIN.

Keep in the cool, ventilated place and avoid UV.

Keep away from heat, spark and open flame.

FIRST AID MEASURE

- General information: Remove soiled, soaked clothing immediately. Medical treatment is necessary if symptoms occur which are obviously caused by skin or eye contact with the product or by inhalation of its vapors.
- After inhalation: Move subject to fresh air and keep him calm. See a physician.
- After contact with skin: Wash off immediately with soap and water. If skin irritation occurs consult a physician.
- After contact with eyes: Keeping the eyelids apart flush thoroughly with water immediately. If irritation persists, contact a physician.
- After ingestion: Do not induce vomiting. Contact a doctor immediately.

USAGE DIRECTION

Remove the cover and unplug, clean up the blockage if there is any. Please ensure that component A and component B flow out at the same time before putting on the mixer. Only apply the adhesive only after the mixer is fixed on the adhesive gun.

Please ensure that applied surfaces are dry, clean without any stain.

In order to have qualified performance of adhesive, please discard mixed adhesive in the quantity of the similar length of the mixer when changing new mixer.

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Please also ensure to finish the joint within 3 minutes (with miter clamps).

Please sand after applied adhesive is cured.

Please change a new mixer when suspending the application more than 5 mins.

When operating temperature is 10°C below, please heat up the adhesive, but the temperature should not be higher than 30°C. When heating up adhesive, the heat source should not be too closed to adhesive. The electric fan should be 1 meter away from adhesive while the lamp should be 3 meters away at least.

STEP IN DETAIL

1. Polishing the joint with 600P sanding paper, ensure both side of the joint are perfectly matched, and use alcohol wipes to clean the joint, allow to dry.
2. Fix timer blocks to either side of the joint and miter clamps to bring them together.
3. Get adhesive, dispenser, mixer ready for use. Install cartridge on dispenser, and take off the cover and plug.
4. Gently pull the dispenser handle, until component A and component B flow out at the same time, and then install the mixer.
5. Discard about 2g adhesive to ensure both component A and component B are present.
6. Evenly apply a continuous bead of adhesive along the full length of the top and bottom edge of the joint. Push two parts of solid surface together.
7. Apply a second continuous bead of adhesive to the top edge of the joint and fill the joint ensuring that sufficient adhesive is used so that when the solid surfaces are brought together, a continuous bead of adhesive flows out of the joint area.
8. Apply pressure to the joint with miter clamps, checking for alignment.
9. Allow the adhesive to cure to a hard rubber consistency, approx. 30 mins at 24°C.
10. Remove miter clamps first and then hot melt glue blocks and finally glue deposit on the surface with a wide sharp chisel taking care not to damage the surface. Complete with the sanding process.

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STORAGE

To ensure the longest shelf life, the adhesive should be stored in a well-ventilated room, in the dark, at 24°C or lower. Cartridges should be stored on their sides. Follow local regulations for flammable material storage. Use precautions during transport, as vehicles can rapidly reach elevated temperatures. Exposure to elevated temperatures will shorten shelf life. Do not place in freezer. In order to minimize viscosity issues, the adhesive should be stored above 13°C.

Storage, transportation, and disposal must be in accordance with applicable regulations. Do not flush to surface water or sanitary sewer system. Do not incinerate in closed containers.

IF YOU HAVE QUESTIONS, PLEASE CONTACT MEGANITE SOLID SURFACE REPRESENTATIVES, AUTHORIZED FABRICATORS, DISTRIBUTORS OR EMAIL US AT INFO@MEGANITE.COM.

ALL TECHNICAL BULLETINS CAN BE FOUND @ WWW.MEGANITE.COM