



Tyfo® MB

High-Performance Adhesive

DESCRIPTION

Tyfo® MB is a two-component acrylic adhesive which bonds a wide variety of metals and fiber reinforced polymers. It provides high peel and impact strengths even in low temperature environments.

USE

Tyfo® MB is specially designed to bond FRP to steel and/or steel to steel. It may be used in place of welding, riveting, brazing and other types of mechanical fasteners.

ADVANTAGES

- Excellent low temperature properties
- Bonds to metal and polymers
- Ambient cure
- Non-Sag
- Excellent resistance to dilute acids, alkalis, solvents, greases, oils and moisture
- UV exposure resistance

COVERAGE

One gallon will cover approximately 150 sq. ft. (14m²) of surface area at 0.01" (0.25mm) thick. One 12.68 oz. (375ml) cartridge will cover approximately 15 sq. ft. (1.4m²) at 0.01" (0.25mm) thick.

PACKAGING

Order in 5-gallon (19L) units, 55-gallon (208L) drums or 12.68 oz. (375ml) cartridges.

MIX RATIO

100 parts of component A to 25 parts of component B by volume. (100 parts of component A to 30 parts of component B by weight.)

SHELF LIFE

Six months from date of shipment at 75° F (24° C) in original, unopened and properly stored containers.

STORAGE CONDITIONS

Store in well-ventilated areas at temperatures under 80° F (27° C). For maximum shelf life store at temperatures between 40° to 50° F (4° to 10° C). Avoid storage at temperatures above 100° F (38° C) and below 32° F (0° C). If stored at lower temperatures, allow product to return to room temperature before use. Protect from exposure to ultraviolet light. Keep away from open flame.

CERTIFICATE OF COMPLIANCE

- Will be supplied upon request, complete with state and federal packaging laws with copy of labels used.
- Material safety data sheets will be supplied upon request.

HOW TO USE THE TYFO® MB ADHESIVE

INSTALLATION

Tyfo® System to be installed by Fyfe Co. LLC trained and certified applicators. Installation shall be in strict compliance with the Fyfe Co. LLC Quality Control Manual.

SURFACE PREPARATION

Remove dust, debris, grease, or other loose contamination from surface to be bonded. Polymers and plastics may only require simple cleaning prior to bonding. Some surfaces may require abrading for best performance.

MIXING

Use mixer to thoroughly blend the Tyfo® MB component A with the proper amount of Tyfo® MB component B until uniformly blended.

APPLICATION

Apply blended Tyfo® MB to substrates and join.

CURE

Full cure is achieved within 24 hours at a room temperature of 77° F (25° C). Cure time can be accelerated by applying heat; not to exceed 150° F (66° C).

Important: Bonded surfaces must remain in contact until full cure is achieved.

LIMITATIONS

Do not exceed temperatures of 150° F (68° C). DO NOT THIN; solvents will prevent proper cure.

EPOXY COMPONENT PROPERTIES

	Tyfo® MB-A	Tyfo® MB-B
Color	Off-white to Tan Paste	Off-white textured
Viscosity, cps Brookfield at 77° F (25° C)	100,000-350,000 cps	150,000-450,000 cps
Density (lbs./Gallon)	9.15 - 9.65	11.9 - 12.9
Flash Point	59° F (15° C)	>200° F (>93° C)
Pot Life	20 - 30 minutes	N/A

CAUTION!

COMPONENTS A & B - Irritant:

Prolonged contact to the skin may cause irritation. Use of neoprene, nitrile or rubber gloves is recommended.

Avoid eye contact; causes eye irritation. Use of safety eyewear with side shields or chemical goggles where splashing may occur.

Inhalation may cause headache, nausea and respiratory tract irritation. Use of a NIOSH/MSHA approved air-purifying organic vapor respirator is recommended. For confined space use or other conditions where exposure limits may be exceeded, use of an approved air-supplied respirator is recommended.

FIRST AID

Skin contact: Wash thoroughly with soap and water. Seek medical attention if symptoms occur.

Eye contact: Flush immediately with plenty of water, lifting upper and lower eyelids for 15 minutes; contact physician immediately.

Inhalation: Move person to fresh air. If breathing is difficult, give oxygen; get immediate medical attention.

Ingestion: Do not induce vomiting. Give victim one or two glasses of water or milk. Call physician or poison control center immediately for further instructions. Important: Never give anything by mouth to an unconscious person.

Wash clothing before reuse.

CLEANUP

Uncured adhesive: Clean excess adhesive on the bonded assembly, and mixing and application equipment prior to cure. Use hot water and detergent or an approved organic solvent; ketones work best.

Cured adhesive: Heat the cured adhesive to 400°F (204°C) or above to soften the adhesive and separate the assembly. A commercial epoxy stripper may also work effectively.

Collect with absorbent material, flush with water. Dispose of in accordance with local disposal regulations.

SHIPPING LABELS CONTAIN

- State specification number with modifications, if applicable
- Component designation
- Type, if applicable
- Manufacturer's name
- Date of manufacture
- Batch name
- State lot number, if applicable
- Directions for use
- Warnings or precautions required by law

**KEEP CONTAINER TIGHTLY CLOSED.
NOT FOR INTERNAL CONSUMPTION.
CONSULT MATERIAL SAFETY DATA SHEET
(MSDS) FOR MORE INFORMATION.
KEEP OUT OF REACH OF CHILDREN.
FOR INDUSTRIAL USE ONLY.**

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