

KB064-LO

Cyanoacrylate Instant Adhesive

Description

KB064-LO is a low viscosity, odourless, non-staining, flexible, instant adhesive specially designed for bonding most plastics and various rubbers. The formulation consistency has been designed for easy application and for high bond strength even for areas that are subject to much flexing and bending. Careful selection of the formulation ingredients ensures that the product does not stain regions close to the adhesive joint. The product is non-irritant.

Technology	Cyanoacrylate
Chemical Type	Methoxyethyl Cyanoacrylate
Appearance (uncured)	Transparent liquid
Components	One part
Viscosity	Low
Cure	Humidity

Typical Properties of Uncured Material

PART A:	
Specific gravity, 25 °C, g/cm ³ :	1.14
Viscosity, Brookfield, 25 °C, mPa·s (cP):	
Spindle 21, speed 100 rpm	40-80

Typical Curing Performance

Under normal conditions, the atmospheric moisture initiates the curing process. Although full functional strength is developed in a relatively short time, curing continues for at least 24 hours before full chemical resistance is developed.

Fixture Times

Fixture time is the time at which an adhesive bond (250 mm²) is capable of supporting a 3 kg load for 10 seconds. The fixture time will depend on the substrate. The table below shows the fixture time for different substrates using lap shears.

	Time (s)
Pine Wood	20 - 105
Beech Wood	20 - 50
Polycarbonate	30 - 90
Aluminium A5754	30 - 120
Mild steel	10 - 60

Typical Performance of Cured Material

Tensile Shear Strength

The shear strength will depend on the substrate. The Table below shows the shear strength for different substrates using lap shears according to ISO 4587.

Cured for 24h at 22 °C

	Strength (N/mm ²)
Pine Wood	6 - 11 *
Beech Wood	7 - 11 *
ABS	10 - 12 *
Aluminium A5754	6 - 8
Mild steel	12 - 15

* Substrate Failure



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Instructions for Use

Ensure parts are clean, dry and free from oil and grease.

Apply approximately one drop of adhesive per square inch of bond area. Product performs best with minimal gap between substrates.

Hold parts together firmly until handling strength is achieved.

Product is normally hand applied from the bottle. Dispensing systems are available for high volume assembly applications. Please contact your Krylex representative for further advice on dispensing situations.

Storage

Store in a cool area out of direct sunlight. Refrigeration to 5° gives optimum stability.

General Information

For safe handling of this product consult the Material Safety Data Sheet.

Cyanoacrylate bonds with skin and eyes in seconds. If accidental skin bonding occurs, wash with warm soapy water and peel skin apart using blunt object (i.e. pen). In case of eye contact, bathe immediately with water and seek immediate medical attention. Skin contact through clothing may cause burns due to exothermic reaction.

Notes

The data contained in this data sheet may be reported as typical value and/or range. Values are based on actual test data and area verified on a regular basis.

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