KG745
Gasket Maker

Description

Krylex KG475 is an orange, smooth, thick paste. Easily applicable, Krylex KG475 cures once confined between the parts to form a tough, flexible gasket. Krylex KG475 gives an instant low pressure seal.

Krylex KG475 is used for fuel and water pumps, split crank cases on engines, gearbox covers, engine thermostats, air compressor end caps, engine timing cam covers onto blocks, pump couplings, fuel tanks on small implements, chainsaws, lawn mowers ect. Use Krylex KG475 for dressing gaskets, spacers,

etc.

Technical Features

Resin:	Modified Urethane Acrylate
Appearance	Orange
Cure Speed with Activator:	<15 minutes
Cure Speed w/o Activator	60 minutes
Viscosity:	30,000 cps
Gap Fill:	.010” (.050” primed)
Flash Point:	>200°F
Specific Gravity:	1.1 @ 75°F
Max. Operating Temp:	-65°F to +300°F

Cured Performance

Full Cure Time:	24hrs @ 68°F
Tensile Shear Strength:	500-2000 psi

Cure Speed Influence

Cure speed and strength vary according to the substrates. When used on mild steel and brass components, anaerobic gasketing adhesives will reach full strength more rapidly than more inert materials such as stainless steel and zinc dichromate. Krylex Activators may be used to accelerate cure speed.

The size of the bond gap greatly affects the speed of cure of anaerobic adhesives. Bond gap varies with surface finish and flatness of flange. The larger the gap between mating surfaces, the slower the cure speed.

All figures relating to cure speed are tested at 22°C. Lower temperatures will result in a slower cure. Heating the assembled parts accelerates the curing process. Krylex Activators should be used when the temperature is less than 5°C.

When speed of cure is too slow or the bond gap is very large, Krylex Activators may be used to accelerate cure speed. The use of an accelerator may reduce bond strength by up to 30%. Chemence recommends testing on the parts to measure the effect.

Typical Environmental Resistance

Krylex anaerobic adhesives exhibit excellent chemical resistance to most oils and solvents including motor oil, leaded petroleum, brake fluid, acetone, ethanol, propanol and water. Anaerobic adhesives and sealants are not recommended for use in pure oxygen or chlorine lines.

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Instructions for Use

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

Apply adhesive to one side of flange. Assemble parts and allow curing. Wipe excess adhesive from outside of joint.

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 solutions.

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.

Anaerobic adhesives only cure in the absence of air and with metal part activation. Adhesive outside the joint will remain uncured and may be wiped away with a cloth.

Anaerobic adhesives are not recommended on certain plastics as stress cracking can sometimes result. Some anticorrosion chemicals inhibit the cure system in this type of anaerobic. Trials are recommended to establish whether cleaning of the parts are necessary. Krylex Activators may be required on plated parts and inactive metals.

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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