

# KH102

## Polyurethane Hot Melt

### Description

Krylex KH102 is a one component reactive polyurethane hot melt. It is solid at room temperature. After being applied warm the product will cool to allow immediate handling. Upon further exposure to ambient humidity Krylex KH102 will achieve high strength bonds and excellent environmental resistance.

### Product Features

- High strength.
- Suitable for bonding metal and plastic, especially for ABS, PC.
- Low application temperatures (105°C-120°C).
- Excellent heat resistance and solvent resistance.
- Excellent high temperature and low temperature resistance.

### Technical Features

#### *Typical Uncured Properties*

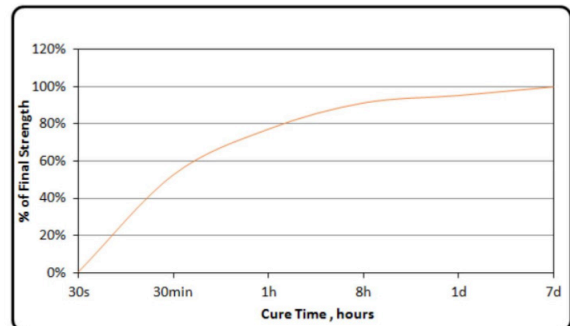
Color:	Light Foggy White Solid
Solid Content:	100%
Specific Gravity @ 25°C	1.1
Viscosity (Brookfield HBTD 10rpm)	@120°C 4500±1000cp @100°C 6500±1000cp
Open Time (1mm line):	1 minute
Application Temperature:	105°C-120°C

#### *Typical Cured Properties*

Coefficient of Thermal Expansion:	160.3µm/ (mK)
Coefficient of Thermal Conductivity:	0.19 W/ (mK)
Specific Heat:	3.10KJ/ (Kg.K)
Elongation, at break:	>400%
Tensile Modulus:	>300MPa
Tensile Strength:	>7.3 MPa
Tensile Shear Strength:	>6.8Mpa

### *Cure Speed Curve*

The below curve is for reference only. The cure speed is dependent on temperature, humidity and substrate choice. Please contact your local sales representative for assistance and recommendations regarding this product.



Cured condition: 25°C; 50%-70%RH

Substrates: fiber sheet & fiber sheet

Strength: Tensile Shear Strength.



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### Instructions for Use

For best results, ensure parts are clean, dry and free from oil and grease, although good bonds can still be achieved on 'as received' or slightly oily parts. The temperature of substrate should not be lower than 20°C. Low temperature will shorten the open time and cause the bonding failure. If needed, pre-heating of the substrate is recommended. Dispense bead of product onto substrate. Mate opposite substrate within recommended open time. Allow for handling strength to be achieved.

### Storage

Optimal storage conditions are between 15°C to 30°C and stored in original sealed foil bag. Storage outside this temperature range can adversely affect product properties and may reduce the stated shelf life.

### General Information

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

### 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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