

# KB544

## Cyanoacrylate Instant Adhesive

### Description

Krylex KB544 is a gel viscosity, surface insensitive cyanoacrylate instant adhesive. It provides excellent adhesion to plastics, metals and elastomers as well as acidic surfaces such as woods, leather and paper. It provides high strength bonds within seconds of assembly and achieves full cure within 24 hours of assembly. Krylex KB544 is a premium surface insensitive instant adhesive used in applications including white goods assembly, filter assembly, electronic housing assembly and general industrial manufacturing. The one component nature of Krylex KB544 lends itself to easy automation of dispensing on production lines.

### Technical Features

Resin:	Ethyl Cyanoacrylate
Appearance	Clear
Cure Speed with Activator:	<3 seconds
Cure Speed w/o Activator:	10-30 seconds
Viscosity:	100000-150000 cps (@2.5rpm) 18000-35000 cps (@20rpm)
Gap Fill:	.012"
Flash Point:	>185°F
Specific Gravity:	1.1
Max. Operating Temp:	-65°F to +185°F

### *Cured Performance*

Full Cure Time:	24hrs @ 68°F
Tensile Shear Strength:	600-3800 psi

### *Properties*

Low Viscosity  
Speed:

Metal/Metal:	<120 seconds
Plastic/Plastic:	<60 seconds
Rubber/Rubber:	<45 seconds

### *Cured Speed Influence*

Cyanoacrylates cure confined in close fitting gaps and in the presence of surface moisture on substrates. Cure speed can be negatively influenced by large gap thickness or low humidity environments. Krylex activators can be used to speed up cure speed and cure excess cyanoacrylate outside of the bondline. Use of an activator can reduce bond strength. Chemence recommends testing for suitability of Krylex products on application.

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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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