

KB604

Cyanoacrylate Instant Adhesive

Description

Krylex KB604 is a low viscosity, low odor cyanoacrylate instant adhesive with good adhesion to plastics, metals and elastomers. It provides high strength bonds within seconds of assembly and achieves full cure within 24 hours of assembly. Krylex KB604 is a low odor and low bloom instant adhesive formulated specifically to eliminate the potential for hazing in applications with strict aesthetic requirements. The one component nature of Krylex KB604 lends itself to easy automation of dispensing on production lines.

Cured Performance

Full Cure Time: 24hrs @ 68°F
Tensile Shear Strength: > 2600 psi

Properties

Low Viscosity
Speed:

Metal/Metal: <20 seconds
Plastic/Plastic: <20 seconds
Rubber/Rubber: <10 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.

Technical Features

Resin:	Alkoxy-Alkyl Cyanoacrylate
Appearance	Clear
Cure Speed with Activator:	<5 seconds
Cure Speed w/o Activator	25-60 seconds
Viscosity:	80-120 cps
Gap Fill	.005"
Flash Point:	>185°F
Specific Gravity:	1.07
Max. Operating Temp:	-65°F to +185°F

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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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