

## Technical Data Sheet

# KB014

## Cyanoacrylate Instant Adhesive

### Description

Krylex KB014 is a low viscosity, surface insensitive cyanoacrylate instant adhesive. It provides excellent adhesion to plastics, metals and elastomers as well as acidic surfaces such as wood, leather and paper.

Krylex KB014 provides high strength bonds within seconds and achieves full cure within 24 hours of assembly.

Krylex KB014 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 KB014 lends itself to easy automation of dispensing on production lines.

### Technical Features

|                            |                            |
|----------------------------|----------------------------|
| Resin:                     | Hybrid Ethyl Cyanoacrylate |
| Appearance:                | Clear                      |
| State:                     | Liquid                     |
| Cure Speed with Activator: | <5 seconds                 |
| Cure Speed w/o Activator:  | 15-40 seconds              |
| Viscosity <sup>1</sup> :   | 80-120 cPs                 |
| Gap Fill:                  | 0.15mm                     |
| Flash Point:               | >85°C                      |
| Specific Gravity:          | 1.06                       |
| Max. Operating Temp:       | -50°C to +80°C             |
| Shelf Life @ 5°C:          | 12 Months                  |

<sup>1</sup> Cone and Plate Rheometer, controlled stress

### Cured Performance

|                                       |                      |
|---------------------------------------|----------------------|
| Full Cure Time:                       | 24 Hrs @ 21°C        |
| Tensile Shear Strength <sup>2</sup> : | 21 N/mm <sup>2</sup> |

<sup>2</sup> ISO 6922

### Fixture Times

|                    |             |
|--------------------|-------------|
| Metal / Metal:     | <25 seconds |
| Plastic / Plastic: | <10 seconds |
| Rubber / Rubber:   | <5 seconds  |

### Factors Affecting Cure Speed

Cyanoacrylate adhesives cure when confined between close-fitting parts and in the presence of surface moisture on substrates.

Cure speed can be negatively influenced by very large gaps, low temperatures or low humidity environments.

Krylex activators can be used to accelerate cure speed and to cure excess cyanoacrylate outside of the bondline.

The use of an activator can reduce bond strength.

Chemence recommends testing for suitability of Krylex products for any specific application.

### Use Of Accelerators/Primer

Krylex activators can be used to accelerate the curing speed or for priming absorbent surfaces. Activators may also be used for fillet cure and curing adhesive outside the bond line.

Krylex KP707 primer may be used for "difficult to bond" low surface energy plastic substrates.

### Storage

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

### Presentation



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### General Information

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

### Product Safety

Cyanoacrylate bonds skin and eyes in seconds.

If accidental skin bonding occurs, wash with warm soapy water and pry skin apart using a blunt instrument (such as a teaspoon handle).

In case of eye contact, bathe immediately with water and seek medical attention.

Skin contact through clothing may cause burns due to an exothermic reaction.

### Instructions for Use

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

Apply approximately one drop of adhesive to 25mm<sup>2</sup> of bond area. Krylex KB014 performs best with minimal gaps between substrates.

Hold parts together firmly until handling strength is achieved.

Product is normally hand applied from the bottle.

KB014 is suitable for use with dispensing systems for high volume assembly applications.

### 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 are verified on a regular basis.

### Disclaimer

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