

Technical Data Sheet

KB760

Moisture Resistant Cyanoacrylate Instant Adhesive

Description

Krylex KB760 is a an instant adhesive with a high resistance to humidity.

The bond strength of KB760 does not degrade from its original fully cured value, even after several days submerged in hot water.

The product has excellent bonding properties to a broad range of materials including plastics, but gives especially good bonds on metal substrates.

Technical Features

Cure System:	Moisture
Appearance:	Transparent / Clear
State:	Liquid
Chemical Type:	Ethyl Cyanoacrylate
Viscosity ¹ :	120 - 200 cPs
Gap Fill:	0.10mm
Max. Operating Temp:	-40 °C to +80 °C
Shelf Life @ 2 - 8 °C ² :	12 Months

¹ Brookfield RVT, Spindle 21, speed 100 rpm @ 25 °C

² Stored in original unopened containers out of direct sunlight

Cured Performance

Tensile Shear Strength ISO 4587 (N/mm²)

The shear strength will depend on the substrate. The table below shows the shear strength for different substrates using lap shears

Substrate	Strength after 24 hr @ 22 °C (N/mm ²)
Pine Wood	8 - 10*
Beech Wood	10 - 11*
ABS	9 - 10*
Polycarbonate	7 - 11*
Stainless Steel A316	8 - 12
Mild Steel	12 - 20

* Substrate failure

Fixture Times

Fixture time is the time at which an adhesive bond (250 mm²) is capable of supporting a 3 kg load for 10 seconds.

The fixture time will depend on the substrate.

The table below shows the fixture time for different substrates using lap shears.

Substrate	Fixture Time (s)
Pine Wood	50 - 90
Beech Wood	30 - 60
ABS	30 - 45
Polycarbonate	50 - 100
Stainless Steel A316	50 - 80
Mild Steel	14 - 45

Typical Environmental Resistance

All measurements are based on Lap Shear Strength to ISO 4587 after curing for 24 hr @ 22 °C before testing.

Heat Aging

Aged at 125 °C then cooled and re-tested at 22 °C

Substrate	Initial Strength (N/mm ²)	After 3 Days (N/mm ²)
Mild Steel	12 - 20	6 - 15

Water Resistance

Submersion testing - Lap shear joint on mild steel, total immersion in fresh water @ 60 °C

	N/mm ²
Initial Strength	12 - 20
After 3 days	12 - 20
After 7 days	12 - 20
After 14 days	12 - 20
After 21 days	12 - 20



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Limitations

This product is not recommended for use in pure oxygen and / or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials.

Not recommended for use on polypropylene, polyethylene or Teflon®.

Instructions for Use

KB760 performs best with minimal gaps between substrates.

- 1) Ensure parts are clean, dry and free from oil and grease.
- 2) Apply adhesive to one of the surfaces. Do not use items like tissue or a brush to spread the adhesive.
- 3) Accurately locate the parts and assemble within a few seconds. The short fixture time leaves little opportunity for adjustment.
- 4) Hold or clamp parts together firmly until handling strength is achieved.

Product should be allowed to develop full strength before subjecting to any service loads (typically 24 to 72 hours after assembly, depending on bond gap, materials and ambient conditions).

General Information

For safe handling of this product consult the 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 an 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 are verified on a regular basis.

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