

KS695 Thread Sealant

Description

KS695 is an anaerobic sealant which seals hydraulic and pneumatic fittings up to 2" in diameter, resisting high pressure and vibration loosening. This product has excellent solvent resistance and withstands temperature to 300°F. The product does not shrink when curing and gives a positive seal against moisture and corrosion attack.

Typical applications are hydraulic and pneumatic fittings, servo-mechanisms, and fine-filtration systems.

Technical Features

Resin:	Dimethacrylate
Appearance	Brown
Cure Speed with Activator:	<10 minutes
Cure Speed w/o Activator	<30 minutes
Viscosity:	300-500 cps
Gap Fill:	N/A
Flash Point:	>212°F
Specific Gravity:	1.09-1.10 @ 75°F
Max. Operating Temp:	-65°F to +300°F

Chemical/Solvent Resistance

Solvent	(F°)	%Initial Str. Retained	
		100hr	500hr
Motor Oil	190°	100	100
Unleaded Gas	"	100	100
Phosphate Ether	"	100	100
Brake Fluid	"	100	100
Isopropyl Alcohol	"	100	100
Auto Transmission Fluid	"	100	100
MIL-H-5606G Fluid	"	100	100
Water	"	100	100

Cured Performance

Full Cure Time:	24hrs @ 68°F
Tensile Shear Strength:	37-62 psi

Cure Speed Influence

Cure speed and strength vary according to the substrates. When used on mild steel and brass components, anaerobic adhesives will reach full strength more rapidly than more inert materials such as stainless steel and zinc dichromate. Krylex Activators may be used to accelerate cure speed.

The size of the bond gap greatly affects the speed of cure of anaerobic adhesives. Bond gap varies with tread type and size of the fastener. The larger the gap between threads, the slower the cure speed.

All figures relating to cure speed are tested at 22°C. Lower temperatures will result in a slower cure. Heating the assembled parts accelerates the curing process. Krylex Activators should be used when the temperature is less than 5°C.

When speed of cure is too slow or the bond gap is very large, Krylex Activators may be used to accelerate cure speed. The use of an accelerator may reduce bond strength by up to 30%. Chemence recommends testing on the parts to measure the effect.

Typical Environmental Resistance

Krylex anaerobic adhesives exhibit excellent chemical resistance to most oils and solvents including motor oil, leaded petroleum, brake fluid, acetone, ethanol, propanol and water. Anaerobic adhesives and sealants are not recommended for use in pure oxygen or chlorine lines.



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Instructions for Use

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

Apply adhesive to all engaged threads. Assemble parts and allow curing. Wipe excess adhesive from outside of joint.

Product is normally hand applied from the container. Dispensing systems are available for high volume assembly applications. Please contact your Krylex representative for further advice on dispensing solutions.

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.

Anaerobic adhesives only cure in the absence of air and with metal part activation. Adhesive outside the joint will remain uncured and may be wiped away with a cloth.

Anaerobic adhesives are not recommended on certain plastics as stress cracking can sometimes result. Some anticorrosion chemicals inhibit the cure system in this type of anaerobic. Trials are recommended to establish whether cleaning of the parts are necessary. Krylex Activators may be required on plated parts and inactive metals

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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