

## Technical Data Sheet

# KB034

## Low Odour Cyanoacrylate Instant Adhesive

### Description

KB034 is a high viscosity, low odour, low bloom cyanoacrylate instant adhesive.

KB034 general purpose instant adhesive is designed to bond to a variety of materials including: most plastics, rubbers, metals, and other common substrates.

KB034 is an alkoxy-alkyl cyanoacrylate formulated for cosmetically critical applications, virtually eliminating the chlorosis (whitening / frosting) effect which can occur in some bonding situations.

Cure times vary according to the materials being bonded, but most combinations are fast-fixing in 6 - 60 seconds.

### Applications

KB034 instant adhesive is widely used in applications including: jewellery assembly, various optical products and general industrial manufacturing processes where odour / fumes are an issue.

KB034 will not attack many low density foams such as expanded polystyrene, allowing cyanoacrylate to be used for bonding these types of substrates.

Instant adhesives are also widely used in the electronics, automotive and white goods industries.

### Technical Features

|                            |                            |
|----------------------------|----------------------------|
| Resin:                     | Alkoxy Alkyl Cyanoacrylate |
| Appearance:                | Clear                      |
| State:                     | Liquid                     |
| Cure Speed with Activator: | <5 seconds                 |
| Cure Speed w/o Activator:  | 6 - 60 seconds             |
| Viscosity <sup>1</sup> :   | 900 - 1200 cPs             |
| Gap Fill:                  | 0.20mm                     |
| Flash Point:               | >85°C                      |
| Specific Gravity:          | 1.08                       |
| Max. Operating Temp:       | -50°C to +70°C             |
| Shelf Life @ 5°C:          | 6 Months                   |

<sup>1</sup> Brookfield LVF, spindle 3, speed 30rpm

### Cured Performance

Full Cure Time: 24 Hrs @ 21°C

Tensile Shear Strength <sup>2</sup>:

After 3 minutes: 3.5 - 11 M Pa

After 24 Hours: 9 - 18 M Pa

<sup>2</sup> ISO 6922

After 2 minutes on steel: ~50% of final strength

### Fixture Times

Metal / Metal: <60 seconds

ABS / ABS: <30 seconds

Nitrile Rubber / Rubber <20 seconds

Wood (Balsa) <6 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.

Chemence recommends testing the 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.

The use of an activator can reduce bond strength.

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



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### 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 KB034 performs best with minimal gaps between substrates.

Hold parts together firmly until handling strength is achieved.

Product is normally hand applied from the bottle.

KB034 is suitable for use with dispensing systems for high volume assembly applications.

### Storage

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

### General Information

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

### Presentation

Bottles: .....20g, 50g & 500g

### 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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