

Technical Data Sheet

KB0642

Cyanoacrylate Instant Adhesive

Description

KB0642 is a low viscosity, high performance, surface insensitive cyanoacrylate instant adhesive. It provides excellent adhesion to plastics, metals and rubbers as well as acidic surfaces such as wood, leather, card and paper.

Cure times vary according to the materials being bonded, but most combinations are very fast-fixing in 3 - 15 seconds.

Applications

KB0642 is a premium, surface insensitive instant adhesive used in applications including: white goods assembly, filter assembly, electronic housing assembly and general industrial manufacturing.

KB0642 is recommended for use on assemblies with close fitting parts and smooth, even surfaces.

The one component nature of KB0642 lends itself to easy automation of dispensing on production lines.

Technical Features

Resin:	Hybrid Ethyl Cyanoacrylate
Appearance:	Clear
State:	Liquid
Cure Speed with Activator:	<3 seconds
Cure Speed w/o Activator:	3 - 25 seconds
Viscosity ¹ :	16 - 24 cPs
Gap Fill:	0.10mm
Flash Point:	>85°C
Specific Gravity:	1.06
Max. Operating Temp:	-50°C to +80°C
Shelf Life @ 5°C:	12 Months

¹ Cone and plate rheometer, controlled stress

Cured Performance

Full Cure Time: 24 Hrs @ 21°C

Tensile Shear Strength ²: 21 N/mm²

² ISO 6922

Strength Development

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

Fixture Times

Metal / Metal: <25 seconds

ABS / ABS: <10 seconds

Rubber / Rubber <5 seconds

Wood (Balsa) <3 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 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.

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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Storage

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

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 25mm² of bond area. Krylex KB0642 performs best with minimal gaps between substrates.

Hold parts together firmly until handling strength is achieved.

Product is normally hand applied from the bottle.

KB0642 is suitable for use with dispensing systems for high volume assembly applications.

Presentation

Bottles:20g, 50g & 500g

General Information

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

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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