KB1641

Cyanoacrylate Instant Adhesive

Description

KB1641 is a high viscosity, surface insensitive, ethyl cyanoacrylate instant adhesive. It provides excellent adhesion to plastics, metals and rubbers as well as acidic surfaces such as wood, leather and paper.

The high viscosity of KB1641 gives enhanced gap filling capability.

Cure times vary according to the materials being bonded, but most combinations are very fast-fixing in 3-60 seconds.

Applications

Typical applications for KB1641 are: product assembly, filter assembly and electronic housing assembly.

Surface insensitive instant adhesives are also widely used in general industrial manufacturing and the electronics, automotive and white goods industries.

The one component nature of Krylex KB1641 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:	3 - 60 seconds
Viscosity [1]:	1275 - 1650 cPs
Gap Fill:	0.20mm
Flash Point:	>85°C
Specific Gravity:	1.10
Max. Operating Temp:	-50°C to +80°C
Shelf Life @ 5°C:	12 Months

1 Brookfield LVF, spindle 3, speed 30rpm

Cured Performance

Full Cure Time:	24 Hrs @ 21°C
Tensile Shear Strength [2]:	20 N/mm^2

2 ISO 6922

Fixture Times

Metal / Metal:	<60 seconds
Plastic / Plastic:	<20 seconds
Rubber / Rubber	<15 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.

The use of an activator can reduce bond strength.

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.

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 25mm^2 of bond area. Krylex KB1641 performs best with minimal gaps between substrates.

Hold parts together firmly until handling strength is achieved.

Product is normally hand applied from the bottle.

KB1641 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.

Disclaimer

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