KB204

Cyanoacrylate Instant Adhesive

Description

KB204 is a high performance, fast curing, general purpose very low viscosity ethyl cyanoacrylate instant adhesive.

KB204 suitable for the bonding of a wide range of materials including: wood, leather, plastics, metals and rubbers, where rapid bonding times are required.

The very low viscosity of KB204 allows the adhesive to wick between closely fitting substrates and can be used as a post assembly adhesive.

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

Applications

Instant adhesives are widely used in the electronics and white goods industry.

KB204 is recommended for use on assemblies with very close fitting parts and smooth, even surfaces.

The one component nature of Krylex KB204 lends itself to easy automation of dispensing on production lines.

Technical Features

Resin:	Modified Ethyl Cyanoacrylate
Appearance:	Clear
State:	Liquid
Cure Speed with activator:	<3 seconds
Cure Speed w/o activator:	3 - 15 seconds
Viscosity [1]:	2 - 7 cPs
Gap Fill:	0.05mm
Flash Point:	>85°C
Specific Gravity:	1.04
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]:	20 N/mm^2

2 ISO 6922

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

Fixture Times

Steel / Steel:	<15 seconds
ABS / ABS:	<10 seconds
Rubber / Rubber	<10 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 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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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 KB204 performs best with minimal gaps between substrates.

Hold parts together firmly until handling strength is achieved.

Product is normally hand applied from the bottle.

KB204 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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