

KHC18226

Polyurethane Hot Melt

Description

Krylex KHC18226 is a one component reactive polyurethane hot melt. It is solid at room temperature. It is a thermal reactive poly-battery assembly adhesive. After being applied warm the product will cool to allow immediate handling. Upon further exposure to ambient humidity Krylex KHC18226 will achieve high strength bonds and excellent environmental resistance.

Product Features

- High green strength.
- Suitable for bonding plastic and metal membranes. Especially for ABS.PC.
- Low application temperatures (170°C-195°C).
- Suitable for bonding thermistor for polymer battery.
- Excellent heat resistance and solvent resistance.
- Excellent high temperature and low temperature resistance.

Technical Features

Typical Uncured Properties

Color:	Grey Solid
Solid Content:	100%
Specific Gravity @ 25°C	1.1
Viscosity (Brookfield HBTD 10rpm)	@160°C 16000±3000cp @180°C 8000±2000cp
Open Time (1mm line):	< 20 seconds
Application Temperature:	170°C-195°C

Typical Cured Properties

Coefficient of Thermal Expansion:	169.8µm/ (mK)
Coefficient of Thermal Conductivity:	0.7-1.0 W/ (mK)
Initial Adhesion Force (20s)	
180° Peel Strength:	>3N / 18 mm
Tensile Shear Strength:	>3N (Line L:18mm, W:3mm)
End Adhesion Force (24hr)	
180° Peel Strength	>50N / 18mm
Tensile Shear Strength:	>6N (Link L:18mm, W:3mm)

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Instructions for Use

For best results, ensure parts are clean, dry and free from oil and grease, although good bonds can still be achieved on 'as received' or slightly oily parts. The temperature of substrate should not be lower than 20°C. Low temperature will shorten the open time and cause the bonding failure. If needed, pre-heating of the substrate is recommended. Dispense bead of product onto substrate. Mate opposite substrate within recommended open time. Allow for handling strength to be achieved.

Storage

Optimal storage conditions are between 15°C to 30°C and stored in original sealed foil bag. Storage outside this temperature range can adversely affect product properties and may reduce the stated shelf life.

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 area verified on a regular basis.

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