

## Technical Data Sheet

# KB2034

## High Temperature Cyanoacrylate Instant Adhesive

### Description

KB2034 is a low-medium viscosity, modified ethyl cyanoacrylate instant adhesive with enhanced temperature resistance properties.

KB2034 is formulated to resist higher operating temperatures than standard cyanoacrylate grades and can be used at continuous temperatures up to 105°C with intermittent temperature resistance up to 125°C.

KB2034 has excellent resistance to thermal cycling.

### Applications

KB2034 can be used to bond a wide variety of substrates including metals, plastics, rubbers and most other common substrates.

Typical applications include: electric motors, filters, heaters, electronic component mounting and computer disk drives.

The one component nature of Krylex KB2034 lends itself to easy automation of dispensing on production lines.

### Technical Features

Resin:	Modified Ethyl Cyanoacrylate
Appearance:	Transparent
State:	Liquid
Cure Speed with Activator:	<5 seconds
Cure Speed w/o Activator:	10 - 60 seconds
Viscosity <sup>1</sup> :	90 - 110 cPs
Typical Viscosity:	100 cPs
Gap Fill:	0.15mm
Flash Point:	>85°C
Specific Gravity:	1.06
Operating Temperature:	
Continuous:	-50°C to +105°C
Intermittent:	-50°C to +125°C
Shelf Life @ 5°C:	12 Months

<sup>1</sup> Cone and plate rheometer, controlled stress

### Cured Performance

Full Cure Time: 24 Hrs @ 21°C

Tensile Shear Strength <sup>2</sup>: 21 N/mm<sup>2</sup>

<sup>2</sup> ISO 6922

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

### Fixture Times

Metal / Metal: <60 seconds

ABS / ABS: <20 seconds

Rubber / Rubber <10 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.

### Storage

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



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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.

Contains cis-1,2,3,6-tetrahydrophthalic anhydride. May produce an allergic 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 KB2034 performs best with minimal gaps between substrates.

Hold parts together firmly until handling strength is achieved.

Product is normally hand applied from the bottle.

KB2034 is suitable for use with dispensing systems for high volume assembly applications.

### Presentation

Bottles: .....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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