

Technical Data Sheet

KB1054

Rubber Toughened Cyanoacrylate Instant Adhesive

Description

KB1054 is a high viscosity, black, rubber toughened ethyl cyanoacrylate adhesive.

KB1054 displays excellent peel and impact strength and is well suited to applications involving vibration, thermal shock, temperature cycling and high humidity.

KB1054 is formulated to provide a more flexible bond than standard cyanoacrylates and can be used at continuous temperatures up to 105°C with intermittent temperature resistance up to 125°C.

Applications

KB1054 can be used to bond a wide variety of substrates including metals, composites, plastics, rubbers, etc. Typical examples include bonding weather stripping and rubber pads to equipment base or legs.

KB1054 can be used on printed circuit boards to provide strain relief on components.

The one component nature of Krylex KB1054 lends itself to easy automation of dispensing on production lines.

Technical Features

Resin:	Modified Ethyl Cyanoacrylate
Appearance:	Black
State:	Liquid
Cure Speed with Activator:	7 - 15 seconds
Cure Speed w/o Activator:	40 - 70 seconds
Viscosity ¹ :	1000 - 3000 cPs
Viscosity ² :	5000 - 10000 cPs
Gap Fill:	0.20mm
Flash Point:	>85°C
Specific Gravity:	1.10
Operating Temperature:	
Continuous:	-50°C to +105°C
Intermittent:	-50°C to +125°C
Shelf Life @ 5°C:	6 Months

¹ Brookfield RVT, spindle 3, speed 20rpm

² Brookfield RVT, spindle 3, speed 2.5rpm

Cured Performance

Full Cure Time: 24 Hrs @ 21°C

Tensile Shear Strength ²: 21 N/mm²

² ISO 6922

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

Fixture Times

Metal / Metal: <70 seconds

ABS / ABS: <50 seconds

Rubber / Rubber <40 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.

KB1054 is designed for use with Krylex Activators to enable curing through large gaps and when applying large deposits / drops in applications such as bridging and wire tacking or when used for strain relief of components.

Krylex KP707 primer may be used for "difficult to bond" low surface energy plastic substrates.



CHEMENCE®

Technical Data Sheet

KB1054

Cyanoacrylate Instant Adhesive

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 KB1054 performs best with minimal gaps between substrates.

Hold parts together firmly until handling strength is achieved.

Product is normally hand applied from the bottle.

KB1054 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.

Disclaimer

Information presented herein has been compiled from sources considered to be accurate and reliable, but is not guaranteed to be so. Nothing herein shall be considered as recommending practices or products in violation of any patent, law or regulation. It is the user's responsibility to determine the suitability of any material for a specific purpose and to adopt such safety precautions as may be necessary.

WE MAKE NO WARRANTIES REGARDING THE PRODUCTS AND DISCLAIM ALL EXPRESS OR IMPLIED WARRANTIES, INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE.

