KB0641

Cyanoacrylate Instant Adhesive

Description

KB0641 is a very fast curing, very low viscosity modified ethyl cyanoacrylate instant adhesive.

KB0641 suitable for the bonding of a very wide range of materials: paper, wood, leather, plastics, metals and rubbers, including acidic surfaces and some porous ones, where very rapid bonding times are required.

The very low viscosity of KB0641 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 5-15 seconds.

Applications

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

The one component nature of Krylex KB0641 lends itself to easy automation of dispensing on production lines.

Technical Features

Resin:	Modified Ethyl Cyanoacrylate
Appearance:	Clear
State:	Liquid
Cure Speed:	1 - 25 seconds
Viscosity [1]:	2 - 5 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

Fixture Times

Steel / Steel:	5 - 20 seconds
Aluminium / Aluminium:	2 - 10 seconds
ABS / ABS:	2 - 7 seconds
PVC / PVC:	~7 seconds
Chipboard:	25 - 70 Seconds
Fabric:	<10 seconds
Leather:	2 - 20 seconds
Paper:	2 - 10 seconds
Rubber / Rubber	1 - 6 seconds
Wood (Balsa)	2 - 5 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 KB0641 performs best with minimal gaps between substrates.

Hold parts together firmly until handling strength is achieved.

Product is normally hand applied from the bottle.

KB0641 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.

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