

**KRYLEX®**  
Adhesives and sealants

**KB034**  
Low Odour / Low Bloom  
Instant Adhesive (Cyanoacrylate)

Document No:	KX-01-600-2321
Issue:	1
Amendment:	b
Date:	29.01.2013
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TECHNICAL DATA

### TYPICAL APPLICATIONS

**KRYLEX®** KB034 is a medium-high viscosity, low-odour alkoxy-ethyl cyanoacrylate adhesive. KB034 has low volatility compared to standard grades, which means that the white deposit known as blooming or chlorosis can be virtually eliminated. Its low odour can also improve worker comfort in production areas where ventilation is limited.

### TYPICAL APPLICATIONS

**KRYLEX®** KB034 is formulated for general purpose bonding of most plastics, rubbers and other common substrates. Recommended for use on close-fitting parts and fairly smooth, even surfaces it will not attack many low density foams such as expanded polystyrene, allowing the use of cyanoacrylate to bond these substrates.

### PROPERTIES OF MATERIAL

	Value
Chemical type	Alkoxy-Ethyl
Appearance	Clear Liquid
Specific Gravity	1.08
Viscosity <sup>1</sup>	cPs 900 - 1200
Typical Value	cPs 1000
Tensile Strength <sup>2</sup>	(M Pa) 3.5 - 11
- after 3 minutes	9 - 18
- after 24 hours	5 - 60
Fixture Time	(secs)
Full Cure	(hours) 24
Flash Point	(°C) > 85
Shelf Life @ 5°C	(months) 6
Max Gap Fill	(mm) 0.20
Temperature Range	(°C) Continuous -50 to +70

- <sup>1</sup> Cone and Plate Rheometer, controlled stress  
<sup>2</sup> ISO 6922  
<sup>3</sup> Depending on substrates and application conditions

### CURING PERFORMANCE

#### Typical Speed:

Steel/steel (degreased)	<60 seconds
ABS/ABS	<30 seconds
Nitrile Rubber/Rubber	<20 seconds
Wood (balsa)	<6 seconds

#### Cure speed vs. substrate

The speed of cure of cyanoacrylates varies according to the substrates to be bonded. Acidic surfaces such as paper and leather will have longer cure times than most plastics and rubbers. Some plastics with very low surface energies, such as polyethylene, polypropylene and Teflon® require the use of **KRYLEX®** KP707 Primer (see KP707 TDS for further info).

#### Cure speed vs. environmental conditions

Cyanoacrylate adhesives require surface moisture on the substrates in order to initiate the curing mechanism. The speed of cure is reduced in low humidity conditions. Low temperatures will also reduce cure speed. All figures relating to cure speed are tested at 21°C.

#### Cure speed vs. bond gap

**KRYLEX®** cyanoacrylates give best results on close fitting parts. The product should be applied in a very thin line in order to ensure rapid polymerisation and a strong bond. Excessive bond gaps will result in slower cure speeds.

#### Cure speed vs. activator

**KRYLEX®** KP4527 Activator may be used in conjunction with **KRYLEX®** cyanoacrylates where cure speed needs to be accelerated. Cure speeds of less than 2 seconds can be obtained with most **KRYLEX®** brand cyanoacrylates. The use of an activator can reduce the final bond strength by up to 30% - Chemence recommends testing on the parts to measure the effect.

### ENVIRONMENTAL RESISTANCE

#### Hot strength

**KRYLEX®** alkoxy-cyanoacrylate adhesives are suitable for use at temperatures up to 70°C. At 70°C the bond will be approximately 70% of the strength at 21°C. The bond strength at 80°C is approximately 50% of full strength at 21°C.

#### Heat ageing

**KRYLEX®** cyanoacrylates retain over 90% of their strength when heated to 70°C for 90 days and then tested at 21°C. Heating the bond to 80°C and then testing at 21°C gives bond strength of approximately 50% of initial strength.

#### Chemical / Solvent Resistance

**KRYLEX®** cyanoacrylates exhibit excellent chemical resistance to most oils and solvents including motor oil, leaded petrol, ethanol, propanol and freon. Cyanoacrylates are not resistant to high levels of moisture or humidity over time.

### REMOVAL OF CURED CYANOACRYLATE

Cured cyanoacrylate may be removed from most substrates, and parts disassembled, with **KRYLEX®** KP687 Debonder. It is not possible to fully remove cyanoacrylate from fabrics.

### GENERAL INFORMATION

For safe handling of this product consult the Material Safety Data Sheet.

### STORAGE

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

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#### DIRECTIONS FOR USE

Bond speed is very fast so ensure that parts are properly aligned before bonding.

**KRYLEX®** KP4527 Activator may be required if there are gaps or porous surfaces.

Some plastics may require application of **KRYLEX®** KP707 Primer.

Ensure parts are clean, dry and free from oil and grease.

Product is normally hand applied from the bottle. Apply sparingly to one surface and press parts firmly together until handling strength is achieved. As a general rule, as little cyanoacrylate as possible should be used – over application will result in slow cure speed and lower bond strength.

Please contact your **KRYLEX®** representative for further advice on dispensing solutions.

#### PRESENTATION

Bottles:.....20g, 50g, 500g  
Bulk (on request)

#### DATA RANGES

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.

#### NOTES

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