KRYLEX® Adhesives and sealants

KB954

Instant Adhesive (Cyanoacrylate)

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Date:	29.02.2012
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TECHNICAL DATA

TYPICAL APPLICATIONS

KRYLEX® KB954 is a low-medium viscosity ethyl cyanoacrylate adhesive. KB954 is formulated for high speed, high strength bonding of plastics and rubbers. KB954 will give superior performance on all types of plastic and rubber substrates when bonding to themselves or to other common substrates.

TYPICAL APPLICATIONS

KRYLEX® KB954 is specially formulated for the bonding of most common plastics and rubbers, but will also bond other substrates. Recommended for use on close-fitting parts and smooth, even surfaces.

PROPERTIES OF MATERIAL

		Value
Chemical type		Ethyl
Appearance		Clear Liquid
Specific Gravity		1.06
Viscosity [1]	cPs	34-44
Typical Value	cPs	40
Tensile Strength[2]	(N/mm^2)	20
Fixture Time	(secs)	3-20
Full Cure	(hours)	24
Flash Point	(°C)	> 85
Shelf Life @ 5°C	(months)	12
Max Gap Fill	(mm)	0.1
Temperature Range	(°C)	
	Continuous	-50 to +80

[1] Cone and Plate Rheometer, controlled stress

[2] ISO 6922

CURING PERFORMANCE

Typical Speed:

Steel/steel	<20 seconds
ABS/ABS	<10 seconds
Rubber/Rubber	<5 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® cyanoacrylate adhesives are suitable for use at temperatures up to 80°C. At 80°C the bond will be approximately 70% of the strength at 21°C. The bond strength at 100°C is approximately 50% of full strength at 21°C.

Heat ageing

KRYLEX® cyanoacrylates retain over 90% of their strength when heated to 80°C for 90 days and then tested at 21°C. Heating the bond to 100°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 a cool area out of direct sunlight. Refrigeration to 5°C gives optimum storage stability.

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TECHNICAL DATA

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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