



KG745

Anaerobic
Gasket Maker

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TECHNICAL DATA

PRODUCT DESCRIPTION

KRYLEX® KG745 is a single component, low-medium strength, anaerobic gasket compound. KG745 is a thixotropic product that cures quickly on metal surfaces. KG745 cures when confined in the absence of air between close fitting flat metal surfaces.

TYPICAL APPLICATIONS

KRYLEX® KG745 is a 'form-in-place' gasket product designed for multi-purpose applications on rigid metal flanges and surfaces, e.g. gearbox casings, machinery covers, pump housings, compressor end caps, etc. KG745 cures quickly on metal surfaces and develops low-medium strength. KG745 will give an almost instant low pressure seal. (Up to 0.5 Bar after 20mins.) to allow on-line pressure testing.

PROPERTIES OF MATERIAL

	Value
Chemical type	Dimethacrylate
Appearance	Orange
Specific Gravity	1.11
Viscosity ¹ cPs	(Range) 50,000 – 150,000 (Typical Value) 100,000
Viscosity ² cPs	(Range) 20,000 – 40,000 (Typical Value) 30,000
Tensile Shear Strength ³ , N/mm ² (24 Hrs)	Range 1.5 – 6
Initial Fixture Time ⁴	(mins) 20
Full Cure	(Hrs) 24
Flash Point	(°C) > 100
Max Gap Fill	(mm) 0.35
Shelf Life @ 20°C	(Months) 12
Temp Range °C	Continuous -50 to +150

- 1 Brookfield RVT spindle 6, 2.5rpm
- 2 Brookfield RVT spindle 6, 20rpm
- 3 ASTM D1002, on grit blasted mild steel
- 4 To achieve 0.2N/mm² in ASTM D1002, on grit blasted mild steel.

CURING PERFORMANCE

Typical curing speed as % of final strength

20 mins	5% strength
3 hours	~30% strength
24 hours	100% strength

For reference, if used on threaded parts, KG745 will give a break torque of 6-12Nm and a prevail torque of 1.5-5Nm (tested to ISO10964 on M10 black oxide steel bolt and M10 bright steel nut).

CURE SPEED VS. ACTIVATOR

Where speed of cure is too slow or the bond gap is very large, **KRYLEX**® KP6497 Activator may be used to accelerate cure speed. The use of an accelerator may reduce bond strength by up to 30%.

Chemence recommends testing on the parts to measure the effect.

CURE SPEED VS. BOND GAP

The size of the bond gap greatly affects the speed of cure of anaerobic adhesives. The larger the gap between the mating surfaces, the slower the cure speed. Maximum recommended gap for KG745 is 0.35mm.

CURE SPEED VS. TEMPERATURE

All figures relating to cure speed are tested at 21°C. Lower temperatures will result in slower cure. Heating the assembled parts accelerates the curing process.

KRYLEX® KP6497 Anaerobic activator should be used when the temperature is less than 5°C.

CURE SPEED VS. SUBSTRATE

Cure speed and strength vary according to the substrates. When used on mild steel components anaerobic gasket adhesives will reach full strength more rapidly than on more inert materials such as aluminium and stainless steel.

KRYLEX® KP6497 Activator may be used to accelerate cure speed.

Anaerobic adhesives only cure in the absence of air and with metal part activation.

TYPICAL ENVIRONMENTAL RESISTANCE

Hot strength

KRYLEX® KG745 is suitable for use at temperatures up to 150°C. At 130°C the bond strength will be ~25% of the strength at 21°C.

Heat ageing

KRYLEX® KG745 retains ~90% of full strength when heated to 100°C for 90 days then cooled and tested at 21°C.

CHEMICAL / SOLVENT RESISTANCE

KRYLEX® anaerobics exhibit excellent chemical resistance to most oils and solvents including motor oil, leaded petrol, brake fluid, acetone, ethanol, propanol and water. Anaerobic adhesives and sealants are not recommended for use in pure oxygen or chlorine lines.

DIRECTIONS FOR USE

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

Apply manually as a continuous bead or by screen printing to one surface. Assemble parts and allow to cure. Wipe excess adhesive from outside of joint.

If the temperature is less than 5°C KP6497 activator should be used.

Product is normally hand applied from the bottle. Dispensing systems are available for high volume assembly applications. Please contact your **KRYLEX**® representative for further advice on dispensing solutions.

LIMITATIONS

KG745 is not recommended on certain plastics as stress cracking can sometimes result. Some anti corrosion chemicals inhibit the cure system in this type of anaerobic. Trials are recommended to establish whether cleaning of the parts is necessary.

KRYLEX® KP6497 Activator may be required on plated parts.

GENERAL INFORMATION

For safe handling of this product consult the Material Safety Data Sheet. **Important:** Product packed in bulk (≥5kg) has a shelf life of 6 months. The material must be filled into smaller bottles/tubes within this time period.

KRYLEX®
Adhesives and sealants

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STORAGE

Optimal storage conditions are between 8°C and 21°C. Storage outside this temperature range can adversely affect product properties and may affect the stated shelf life.

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

PRESENTATION

Tottles.....50ml and 250ml.

Available in bulk for use with dispensing systems.

Please Note: When packed an air space above the product is vital to maintain stability.

NOTES

The information contained herein is produced in good faith and is believed to be reliable but is for guidance only. Chemence Ltd. and its agents cannot assume liability or responsibility for results obtained in the use of its product by persons whose methods are outside or beyond our control. It is the user's responsibility to determine the suitability of any of the products and methods of use or preparation prior to use mentioned in our literature and furthermore the user's responsibility to observe and adapt such precautions as may be advisable for the protection of personnel and property in the handling and use of any of our products.

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