

Technical Data Sheet

KB1614

Cyanoacrylate Instant Adhesive

Description

KB1614 is a high viscosity, ethyl cyanoacrylate instant adhesive, specially formulated to give superior bond performance on all types of plastic and rubber substrates, when bonding to themselves or to other materials.

KB1614 will also give high strength bonds on most other common substrates.

Cure times vary according to the materials being bonded, but most combinations are fast-fixing in 6 - 60 seconds.

Applications

Typical applications for KB1614 are: loud speaker parts, lampshades, centre consoles, dashboards and weather stripping, leather and rubber bonding during shoe manufacture and cord rubber "O" rings.

KB1614 is recommended for use on close-fitting parts and fairly smooth, even surfaces. KB1614 does however have enhanced gap filling capacity and can be used on parts that do not fit together perfectly.

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

The one component nature of Krylex KB1614 lends itself to easy automation of dispensing on production lines.

Technical Features

Resin:	Hybrid Ethyl Cyanoacrylate
Appearance:	Clear
State:	Liquid
Cure Speed with Activator:	<5 seconds
Cure Speed w/o Activator:	6 - 60 seconds
Viscosity ¹ :	1275 - 1650 cPs
Gap Fill:	0.20mm
Flash Point:	>85°C
Specific Gravity:	1.10
Max. Operating Temp:	-50°C to +80°C
Shelf Life @ 5°C:	12 Months

¹ Brookfield LVF, spindle 3, 30rpm

Cured Performance

Full Cure Time: 24 Hrs @ 21°C

Tensile Shear Strength ²: 20 N/mm²

² ISO 6922

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

Fixture Times

Metal / Metal:	<60 seconds
ABS / ABS:	<20 seconds
Rubber / Rubber	<20 seconds
Wood (Balsa)	<6 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.

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.

The use of an activator can reduce bond strength.

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 25mm² of bond area. Krylex KB1614 performs best with minimal gaps between substrates.

Hold parts together firmly until handling strength is achieved.

Product is normally hand applied from the bottle.

KB1614 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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