

## Technical Data Sheet

# KG745

## Gasket Maker

### Description

KG745 is a single component, thixotropic, low-medium strength, smooth, easily applicable paste, formulated to cure rapidly when confined in the absence of air on close-fitting metal surfaces.

KG745 gives an almost instant low-pressure seal (up to 2 Bar after 20 mins.) to allow on-line pressure testing.

### Typical Applications

KG745 is a 'form-in-place' gasket product designed for multi-purpose applications on rigid metal flanges and surfaces.

Typical applications include: gearbox casings, machinery covers, fuel and water pump housings, compressor end caps, engine thermostat housings and split crank cases on engines.

### Technical Features

Chemical type:	Modified Urethane Acrylate
Appearance:	Orange
State:	Paste
Specific Gravity:	~1.11
Viscosity <sup>1</sup> :	50,000 - 150,000 cPs
Viscosity <sup>2</sup> :	20,000 - 40,000 cPs
Tensile Shear Strength <sup>3</sup> :	1.5 - 6 N/mm <sup>2</sup>
Initial Fixture Time <sup>4</sup> :	≤120 minutes
Max. Gap Fill:	0.35 mm
Full Cure:	24 hours
Flash Point:	> 100 °C
Shelf Life:	12 months @ 20 °C
Operating Temp. Range:	-50 to +150 °C

<sup>1</sup> Brookfield RVT, 'T' spindle 6, Speed 2.5 rpm

<sup>2</sup> Brookfield RVT, 'T' spindle 6, Speed 20 rpm

<sup>3</sup> ASTM D1002, on grit blasted mild steel

<sup>4</sup> To achieve 0.2 N/mm<sup>2</sup> in ASTM D1002, on grit blasted mild steel

### Typical Curing Performance

Typical curing speed as % of final strength.

Time	Value %
20 Minutes (Fixture time):	5
6 hours:	~30
24 hours (Full cure):	100

If used on threaded parts, KG745 will give a break torque of 6-12 Nm\* and a prevail torque of 1.5-5 Nm\*

\* tested to ISO10964 on M10 black oxide steel bolt and M10 bright steel nut

### Factors Affecting Cure Speed

Cure speed can be negatively influenced by very large gaps, low temperatures and can be dependent on the substrates being bonded.

Heating the assembled parts accelerates the curing process.

When used on mild steel and brass components, anaerobic adhesives will reach full strength more rapidly than more inert materials such as stainless steel and zinc dichromate.

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

Anaerobic activator KP6497 should be used on plated parts or when the temperature is less than 5°C. The use of an activator can reduce bond strength.

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.

All figures relating to cure speed are tested at 20°C.

Chemence recommends testing the suitability of Krylex products for any specific application.

### Chemical / Solvent Resistance

KG745 has good environmental resistance to water and other organic solvents including motor oil, ethanol and glycols.

KG745 is not recommended for use in pure Oxygen or Chlorine lines.



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### Typical Environmental Resistance

**Hot strength:** 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:** KG745 retains ~90% full strength when heated to 100°C for 90 days then cooled and tested at 21°C.

### Instructions For Use

For best results, ensure parts are clean, dry and free from oil and grease.

KG745 adhesive should be applied 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.

Product is normally hand applied from the bottle.

KG745 dispensing systems for high volume assembly applications.

### Storage

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

**Please Note:** When packed, KG745 requires an air space above the product to maintain stability.

**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.

### General Information

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

### Presentation

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

Cartridges: ..... 270ml

Available in bulk for use with dispensing systems.

### 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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