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**Technical Data Sheet**

# KA 015-6

## Two-component Room Temperature Curing Adhesive

## for PA, PP, PE, TPO, and so on Plastics and Acrylic Substrates Bonding

### Product Description

KA015-6 is the two-component room temperature curing acrylic-based adhesive. No special surface treatment is required. Cured product demonstrates excellent adhesion strength to many low surface energy materials, such as polyamide (PA), polypropylene (PP), polyethylene (PE), and thermoplastic polyolefin (TPO). This product can replace screws, rivets, plastic welding and two-step processes, including chemical etchants, primers or surface treatments in many applications.

### Features

1. Mixed product exhibits outstanding operability.
2. This product exhibits adhesion for different substrates structure.
3. This product professionally solves the structural adhesion of thermoplastic polyolefin elastomer (TPO).
4. This product does not require any pre-surface treatments for difficult adhesion substrates.
5. This product is solvent-free formula with low odor that fully complies to the environmental protection requirements.
6. This product exhibits excellent thermal stability.
7. This product exhibits excellent chemical resistance and water resistance.
8. This product complies to the 2011/65/EU RoHS regulations.
9. This product complies to chlorine < 900ppm, bromine < 900ppm, chlorine + bromine < 1500ppm.

### Typical Uncured Properties

| | KA015-6A | KA015-6B |
|---|---|---|
| Appearance | Liquid | Liquid |
| Color | Light yellow to brown | Light yellow or opaque |
| Viscosity 25°C, cps | 6,000~10,000 S14 100rpm | 6,000~10,000 S14 100rpm |
| Thixotropic Index | ≧4 | ≧4 |
| Specific Gravity | 1.01~1.12 | 1.01~1.10 |

### Typical Curing Properties

| | |
|---|---|
| Mix Ratio (A：B) by Weight | 1：1 |
| Mix Ratio (A：B) by Volume | 1：1 |
| Pot Life, 25~33℃, 0.5g, min | 55~70 |
| Initial Strength Cure Time, 25~33℃, hr | 7~9 |
| Through Cure Time, 25~33℃, hr | 36~48 |

### Direction of Use

1. When using this product, discard the front end of Part A and Part B mixed adhesive, then coating the product (after Part A and Part B mixed adhesive) on the substrate to achieve the best bonding performance.
2. It should be applied to a clean surface which is free of dirt, grease or mold release. In many cases, a simple solvent wipe is sufficient.
3. Mix thoroughly by weight 1：1 before use.
4. After mixing, it should be used within the pot life.
5. For maximum bonding strength apply adhesive evenly to both surfaces to be jointed.
6. The handling information of this product supplied in dual syringe cartridge can be obtained by requesting a copy of “Introduction for Adhesive Cartridge Dispenser”(F-06122201).

### Typical Cured Properties

| | |
|---|---|
| Glass Transition Temp., (MDSC), °C | 39 |
| CTE* (<Tg), μm/m/°C | 114 |
| CTE* (>Tg), μm/m/°C | 159 |
| Specific Gravity | 1.05 |
| Durometer Hardness, Shore D | 23 |
| Shear Strength, PP+PP, kgf/cm$^2$ | 46 |
| Shear Strength, PA+PA, kgf/cm$^2$ | 40 |
| Shear Strength, PP+PA, kgf/cm$^2$ | 46 |
| Shear Strength, PA+Glass, kgf/cm$^2$ | 70 |
| Shear Strength, HDPE+HDPE, kgf/cm$^2$ | 60 |
| Shear Strength, HDPE+HDPE, 70°C *168hr, kgf/cm$^2$ | 54 |
| Shear Strength, HDPE+HDPE, 70°C Water*168hr, kgf/cm$^2$ | 52 |
| Shear Strength, HDPE+HDPE, 5% Brine *168hr, kgf/cm$^2$ | 60 |
| Shear Strength, HDPE+HDPE, 70°C*5% Brine *168hr, kgf/cm$^2$ | 59 |
| Shear Strength, HDPE+HDPE, 10% Sodium Hydroxide *168hr, kgf/cm$^2$ | 60 |
| Shear Strength, HDPE+HDPE, Gasoline*168hr, kgf/cm$^2$ | 19 |
| Shear Strength, HDPE+HDPE, Diesel Fuel*168hr, kgf/cm$^2$ | 60 |
| Shear Strength, HDPE+HDPE, Toluene*168hr, kgf/cm$^2$ | 2.3 |
| Shear Strength, HDPE+HDPE, Acetone*168hr, kgf/cm$^2$ | 6.4 |
| Low Temperature Shear Strength, HDPE+HDPE, -30°C, kgf/cm$^2$ | 47 |
| Room Temperature Shear Strength, HDPE+HDPE, 25°C, kgf/cm$^2$ | 63 |
| High Temperature Shear Strength, HDPE+HDPE, 50°C, kgf/cm$^2$ | 42 |
| High Temperature Shear Strength, HDPE+HDPE, 70°C, kgf/cm$^2$ | 30 |
| High Temperature Shear Strength, HDPE+HDPE, 85°C, kgf/cm$^2$ | 18 |
| Shear Strength, PE+PE, kgf/cm$^2$ | 51 |
| Shear Strength, UHMWPE+ UHMWPE, kgf/cm$^2$ | 34 |
| Shear Strength, LDPE+LDPE, kgf/cm$^2$ | 25 |
| Shear Strength, ABS+ABS, kgf/cm$^2$ | 121 |
| Shear Strength, PC+PC, kgf/cm$^2$ | 123 |
| Shear Strength, PMMA+PMMA, kgf/cm$^2$ | 102 |
| Shear Strength, PVC+PVC, kgf/cm$^2$ | 140 |
| Shear Strength, FRP+FRP, kgf/cm$^2$ | 164 |
| Shear Strength, PTFE+PTFE, kgf/cm$^2$ | 16 |
| Shear Strength, PS+PS, kgf/cm$^2$ | 52 |
| Shear Strength, Glass+Glass, kgf/cm$^2$ | 62 |
| Shear Strength, SUS304+SUS304, kgf/cm$^2$ | 156 |
| Shear Strength, TPO+TPO, kgf/cm$^2$ | 51 |

*CTE: Coefficient of Thermal Expansion

## Storage and Shelf Life

This product should be stored in cool and dark place. This product should be kept without any possibility of sunlight or ultraviolet exposure. Replace the lid immediately after use. After opened, keep the bottleneck clean and avoid any contact with acid-base content substances. Shelf life of this product is 1 year when stored at 2~13℃ in the original and unopened containers.

## Caution

Some findings indicate a lack of potential for carcinogenicity with the compositions of this product by long term recurrent application to the skin. However, contact with skin is likely to produce mild transient reddening. It is important to remove adhesive from skin with soap and water thoroughly. DO NOT use solvents for cleaning hands. This product is of moderate acute toxicity by swallowing. If swallowed, call a physician. Avoid contact with eyes. In case of contact, flush with water for at least 15 minutes and get medical attention immediately. For specific information on this product, consult the Safety Data Sheet.