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Technical Data Sheet

KA 021

Smooth surface, low shrinkage, two-component acrylic adhesive suitable for inert plastic materials

Product Description

KA021 is a two-component acrylic-based adhesive of cured at room temperature. No special surface treatment is required. This resin has excellent adhesion to many low surface energy materials after curing. Such as polypropylene (PP), thermoplastic polyolefin (TPO) and other common plastic materials. Such as polymethyl methacrylate (PMMA)...etc. KA004 has the excellent smooth surface and extremely low shrinkage.

Features

1. This product exhibits good handling property after mixing.
2. It has the ability to adhere to dissimilar plastic materials, with a smooth surface and extremely low shrinkage.
3. Excellent adhesive strength of thermoplastic polyolefin elastomer.
4. No surface treatment is required.
5. Excellent chemical resistance / water resistance.
6. This product complies to the 2011/65/EU RoHS regulations.
7. This product complies to chlorine < 900ppm, bromine < 900ppm, chlorine + bromine < 1500ppm.

Typical Uncured Properties

	KA021A	KA021B
Appearance	Liquid	Liquid
Color	Creamy	Creamy
Viscosity 25°C, S14 100 rpm cps	7,000~11,000	5,000~9,000
Specific Gravity	1.01~1.15	1.02~1.12
Thixotropic Index	≧2	≧1.5

Typical Curing Properties

Mix Rate (A：B) by Weight	1：1
Work Life, 25~33°C, min	5~10
Initial Cure Time, 25~33°C, hr	2~4
Full Cure Time, 25~33°C, hr	24~48

Direction of Use

1. When using this product, first take it out of the refrigerated environment and let it sit out at room temperature (14~34°C) for 2 to 4 hours. Then discard the front end of the A part and B part mixed adhesive, then coating the product (A part and B part 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 volume 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	35~40
Durometer Hardness, Shore D	60~65
Specific Gravity	1.08
Shear Strength, PP/PMMA (Shear Strength), kgf/cm^2	38/50
Degradation Temp. 5wt% (TGA 10°C /min), °C	230~232

* Specimen Cure Condition：Room temperature(25~35 °C)

Storage and Shelf Life

This product should be kept without any possibility of light exposure. Replace the lid immediately after use. Please keep the bottle mouth clean and avoid any contact with acid-base asubstance after opened. This product has a one year minimum shelf life when stored in dark place below 2~13 °C in original, 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 Material Safety Data Sheet.