

Room Temperature Cured Adhesive for Dissimilar Materials

Product Description

KA022 is a two-component acrylic-based adhesive 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 polyamide (PA), polypropylene (PP), polyethylene (PE), and thermoplastic polyolefin (TPO). It can replace screws, rivets, plastic welding, and two-step processes, including chemical etchants, primers, or surface treatments in many applications.

Features

1. This product exhibits good handling properties after mixing.
2. This product can bond with different plastic materials.
3. Excellent adhesion strength of thermoplastic polyolefin elastomers.
4. No surface treatment is required.
5. This product complies with the 2011/65/EU RoHS regulations.

Typical Uncured Properties

	KA022A	KA022B
Appearance	Liquid	Liquid
Color	Light yellow	Light yellow
Viscosity 25°C, S14 10rpm cps	10,000~20,000	25,000~40,000
Specific Gravity	1.06~1.21	1.02~1.12
Thixotropic Index	>3	>3

Typical Curing Properties

Mix Rate (A : B) by Volume	10 : 1
Pot 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, discard the front end of the A part and B part mixed adhesive, then coat 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 that is free of dirt, grease, or mold release. In many cases, a simple solvent wipe is sufficient.
3. Mix thoroughly by volume 10 : 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 a dual syringe cartridge can be obtained by requesting a copy of "Introduction for Adhesive Cartridge Dispenser," F-06122201.

Typical Cured Properties*

Durometer Hardness, Shore D	60~65
Specific Gravity	1.10
Shear Strength, PA vs. PA, kgf/cm ²	80
Shear Strength, PP vs. PP, kgf/cm ²	110
Shear Strength, TR90 vs. SUS304, kgf/cm ²	100
Shear Strength, PA vs. SUS304, kgf/cm ²	70

* 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 a substance after opening. This product has a one-year minimum shelf life when stored in a 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 due to long-term recurrent application to the skin. However, contact with skin is likely to produce mild transient reddening. Removing adhesive from the skin thoroughly with soap and water is important. DO NOT use solvents for cleaning hands. This product has moderate acute toxicity when swallowed. 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.