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Technical Data Sheet

KA 023-2

Two-component Room Temperature Curing Adhesive

Product Description

KA023-2 is a two-component acrylic-based adhesive cured at room temperature. This product cures at room temperature to exhibit excellent bonding strength. It is highly suitable for bonding dissimilar materials such as metals and glass substrates (e.g., stainless steel, carbon steel, aluminum, polyester fibers, etc.). It is ideal for various applications, including electronic components, automotive parts, high-end accessories, etc.

Features

1. This product exhibits good handling properties after mixing.
2. This product can cure at room temperature or be accelerated with heat for faster curing.
3. This product exhibits balanced adhesive properties, including tensile strength, peel resistance, and impact resistance after mixing.
4. This product complies to chlorine <900ppm, bromine <900ppm, chlorine + bromine <1500ppm.

Typical Uncured Properties

	KA023-2A	KA023-2B
Appearance	Liquid	Liquid
Color	Ink black	Milky
Viscosity 25°C, cps	35,000~60,000 S14 10rpm	32,000~60,000 S14 10rpm
Specific Gravity	1.01~1.15	1.02~1.12
Thixotropic Index	≧4	≧4

Typical Curing Properties

Mix Rate (A：B) by Volume	1：1
Mix Ratio (A：B) by Weight	1：1
Pot Life, 25~33°C, min	5~10
Initial Cure Time, 25~33°C, hr	0.5~1
Full Cure Time, 25~33°C, hr	12~24

Direction of Use

1. Take this product out of the refrigerated environment and let it sit 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 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 free of dirt, grease, or mold release. In many cases, a simple solvent wipe is sufficient.
3. Mix thoroughly by volume 1：1 or 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 a 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	104
Durometer Hardness, Shore D	70
Specific Gravity	1.1
Shear Strength*1, Al vs. Al, kgf/cm^2	130
Shear Strength*1, Cu vs. Cu, kgf/cm^2	120
Shear Strength*1, Stainless Steel vs. Stainless Steel, kgf/cm^2	150
Shear Strength*1, Blasted Steel vs. Blasted Steel, kgf/cm^2	230
Shear Strength*1, Glass vs. Glass, kgf/cm^2	110
Weight Loss Ratio @100℃, %	1.76
Weight Loss Ratio @150℃, %	3.57
Weight Loss Ratio @180℃, %	4.81
Weight Loss Ratio @200℃, %	5.72
Weight Loss Ratio @250℃, %	8.23
Degradation Temp. 5wt% (TGA 10°C /min),	184

*Specimen Cure Condition: Room temperature (25~33°C / 18~24 hr)

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 is of 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.