

Collacryl® KD

Viscous solution adhesive

Type

Viscous, clear solution adhesive with physically curing.
Contains polymethylmethacrylate polymers in organic solvents.

Applications

Only gap-filling to a certain extent.
Physically curing through evaporation and absorption in the bonded plastics in a short time.
For making T-bonds and bonding narrow areas of all kinds uncrosslinked Plexiglas™ (PMMA) and PS;
conduct prior tests for other plastics.

Working

Clean the adherends with DCL 80 detergent before applying the adhesive.
When bonding sawn edges, bubble formation can be reduced by smoothing the edges with abrasive paper (grit 400–600) and wiping them with a cloth soaked in K 90 thinner.
In areas with high stress level anneal the parts beforehand to relieve stress.
The parts to be bonded must have a very accurate fit.
Apply from nozzled bottle (PE, PP, PA type, no PVC type); after a short holding time the bond is locked in position and a pressure of at least 100 g/cm² adherend is applied.
Bleeding may occur with colored plastics; whitening around the adhesive is due to water condensing especially if the room temperature is low.
Clean the implements with K 90 thinner.
It may be diluted with K 90 thinner but this causes a texture to form in the dried adhesive bead.
The maximum pot life in an open tin is about 10 min because its composition deteriorates by evaporation.
Material has to be at room temperature (18-20°C) before use.

Typical Values

Brookfield viscosity (20°C)	750 – 1000 mPa.s
Density (20°C)	≅ 1,15 g/cm ³
Colour	clear to yellowish; colour does not affect bonding properties
Refractive Index	≅ 1,42
Initial Bond	5 minutes
Subsequent Treatment	after 3 hours
Tensile Shear Strength	25 – 28 MPa 30 MPa annealed 5h at 80°C
Storage Stability	1 year if correctly stored
Stored	keep container tightly closed in a cool place, max at 25°C
Packaging	keep in freezer for greater certainty tin (box : 6 x 1 litres)

Notes

For further information on safety measures and on disposal, see Safety Data Sheet.
Our technical advice on the application is given without obligation.
The buyer is responsible for their use and processing, technical data sheet are typical values subject to alteration.