CHEMENCE
CREATING BONDS THAT LAST

KM9904-TDS-R1

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# KM9904

**Product Description:**

Krylex® KM9904 is a fast curing, high-clarity light cure adhesive formulated for strong adhesion to many substrates including flexible PVC, rigid PVC, PC and acrylics. It has a Newtonian viscosity that allows for easy automatic dispensing. KM9904is solvent free and has excellent stability.

## Product Features

- Instant cure with UV light
- ISO10993-5 Cytotoxicity
- Excellent multi-substrate adhesion
- Transparent color
- Solvent free,uUrethane acrylate
- Shelf life of 1 year

## Curing Notes:

- Instant UV cure
- Optimized for curing with medium pressure mercury lamps, medium pressure mercury metal halide lamps and fusion D lamps.

| UNCURED PROPERTY | VALUE | TEST METHOD |
|---|---|---|
| Viscosity cPs | 450 | ASTM D1084 |
| Appearance | Clear | N/A |

| CURED PROPERTY | VALUE | TEST METHOD |
|---|---|---|
| Density, g/ml | 1.02 | ASTM D1875 |
| Tensile Strength, N/mm2 | 14 | ASTM D638 |
| Modulus MPa | 260 | ASTM D638 |
| Elongation, % | 325 | ASTM D638 |
| Durometer Hardness | D55 | ASTM D2240 |
| Water Absorption 100°C/2hr | 1.15% | CSTM 1001 |
| Water Absorption 25°C/24Hr | 0.8% | CSTM 1001 |
| Fixture Time glass/glass | 1 second | CSTM 1002 |
| Linear Shrinkage | 1.42% | CSTM 1004 |

| SUBSTRATE ADHESION | BOND STRENGTH |
|---|---|
| PC | Good |
| PMMA | Good |
| PVC | Good |
| PET | Good |
| PS | Good |
| ABS | Good |
| PE | w/Surface Treatment |
| PP | w/Surface Treatment |
| AL | Good |
| SS | Good |
| Glass | Good |

## General Information

For safe handling of this product consult the Safety Data Sheet**.**

## Directions for Curing

1. KM9904 is very sensitive to light. Store in 100% light blocking container.
2. Dispensing lines must be 100% blocking for UV and Vis light.
3. All bond surfaces should be clean and free from grease, mold release or other contaminants.
4. Cure speed is dependent on the light intensity, the light transmission of substrate and required depth of cure.
5. Bonded parts should be allowed to cool before testing or subjecting to any service loads.
6. Plastic grades and part design should be considered to avoid cracking and improve adhesion.
7. The type of lamp and intensity should be selected for productivity and quality.
8. Improving the surface cure can be carried out at a higher intensity.
9. Check the lamp intensity regularly. Replace a lamp if an intensity is below 75% of initial intensity.

## Handling and Safety

For maximum shelf life, keep containers sealed when not in use. Keep out of the reach of children. Uncured sealant irritates eyes and skin. Refer to SDS for further information.

## NOTES

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