



# KU5026

**Product Description:**

Krylex® KU5026 is a fast curing and high strength light cure acrylic adhesive formulated for strong adhesion to many substrates, including low surface energy materials, typical plastics, metals, glass and glass filled epoxy.

## Product Features

- Instant cure with UV light
- Dry to touch in open face curing applications
- High dispense viscosity for good bead control
- Excellent multi-substrate adhesion
- High peel and shear adhesion values
- 100% solids

## Cure Notes

- Instant UV cure
- Fixture time glass/glass: 2 seconds
- 365nm to 405nm LED or broad-spectrum UVA lamps recommended for curing. Optimal broad-spectrum systems utilize Medium Pressure Mercury and Medium Pressure Mercury Metal Halide bulbs or Fusion D lamps

UNCURED PROPERTY	VALUE	TEST METHOD
Viscosity cPs	9,800	Rheometer (20s <sup>-1</sup> )
Thixotropic Index	3.97	N/A
Appearance	Black	N/A

CURED PROPERTY	VALUE	TEST METHOD
Tensile Modulus (MPa)	246	ASTM D638
Elongation, %	>350	ASTM D638
Tensile stress at break (N/mm <sup>2</sup> )	14.28	ASTM D638
Shore Hardness	55	ASTM D2240
Glass Transition (°C)	65	DMA
Water Absorption (2hr boiling)	6.39%	ASTM D570
Water Absorption (24hr @ 25°C)	1.11%	ASTM D570

## Lap Shear Properties ASTM D1002

PROPERTY	Max Force (MPa)
PC - LCP	3.83
PC – Aluminium	10.76
PC - PET	6.97
PC – 30% GFNylon	6.86
PC – Steel*	12.5
PC – Acrylic*	10.07
PC – PC*	15.15

\*Indicates substrate failure at 0.5X1 inch bond area

## General Information

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

## Directions for Curing

1. KU5026 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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