

**Collacryl® K 60**

Thin-bodied chloride-free solvent adhesive

**Type**

Thin-bodied chloride-free solvent adhesive with physically curing.

**Applications**

Removes adhesives ( K 45, K 25, KD ) before curing time.

Is not gap-filling.

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 ), but also for other plastics such as PS, SBC, ABS, PVCu, CAB; 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 ( wear protective gloves ).

In areas with high stress level anneal the parts beforehand to relieve stress.

The parts to be bonded must have a very accurate fit. Grooves and notches are not filled.

Either of two methods may be used :

1. Lock the two parts in position without adhesive and introduce K 60 into the joint from a small nozzled bottle. The adhesive penetrates the joint by capillary action.

2. The appropriate edge of one of the parts to be bonded is dipped into K 60 and placed in contact with the second part after 30 – 60 sec. After a short holding time, the bond is locked in position and a pressure of at least 100 g / cm<sup>2</sup> adherend is applied.

Apply from nozzled bottle in PE, PP, PA type, no PVC type.

Bleeding may occur with colored plastics; whitening around the adhesive is due to water condensing especially if the room temperature is low.

Material has to be at room temperature ( 18-20°C ) before use.

The maximum pot-life in a open dish is about 10 min because its composition changes by evaporation of one component.

**Typical Values**

Brookfield viscosity (20°C)	<= 15 mPa.s
Density (20°C)	≅ 1,00 g/cm <sup>3</sup>
Colour	clear to yellowish; colour does not affect bonding properties
Refractive Index	≅ 1,38
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
	keep in freezer for greater certainty
Packaging	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.