



TECHNICAL DATASHEET

Vitralit® 6104 VT F

Vitralit® 6104 VT F is a high viscosity and UV curing acrylate adhesive. The product features very good adhesion to a wide variety of substrates.

Vitralit® 6104 VT F cures during exposure to UV-light (UV-A 340-380nm or LED 365 nm). Vitralit® 6104 VT F fluorescent capabilities for adhesive bond verification improves your process quality. The product does not require post heat cure but can be thermal cured for applications with shadowed areas.

Shelf life:

Store in original, unopened containers for 6 months at 5°C

Technical Data

Color	translucent
Resin	acrylate
Filler	approx. 10% plastics

UNCURED PROPERTIES

Viscosity (Brookfield LVT/25°C) [mPa·s]	PE-Norm P001	70000 to 90000
Flash point [°C]	PE-Norm P050	> 100
Density [g/cm³]	PE-Norm P003	approx. 1.1

Curing

UV(UV-A 60mW/cm²): [sec.]	PE-Norm P002	15
Thermal Curing 120°C :[Min]	PE-Norm P035	15
Full Strength [hours]	PE-Norm P032	after 12
Depth of Cure [mm]	PE-Norm P033	9

CURED PROPERTIES

Temperature Resistance [°C]	PE-Norm P030	-40 to 200
Hardness [Shore D]	PE-Norm P052	40 to 60
Shrinkage [%]	PE-Norm P031	1.6
Water Absorption [mass-%]	PE-Norm P016	< 8
Tg [°C] (DSC)	PE-Norm P009	65 to 90
CTE [ppm/K]	PE-Norm P017	60
Dielectric Constant [10kHz]	PE-Norm P054	6
Thermal conductivity [W/m·K]	ASTM 1530	0,4
Dielectric Strength [kV/mm]	PE-Norm P055	25

Attention: Datasheet isn't decontrolled

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Adhesives
and more...

Mechanical Data

E-Modul [MPa]

[PE-Norm P056]

270

Instructions for Use

Surface Preparation

The surfaces to be adhered should be free of dust, oil, fat or any other dirt in order to optimise reproducible bonds. Lightly soiled surfaces can be cleaned with cleaner IP, whereas substrates with low surface energy (such as polyethylene, polypropylene or Teflon) need to be treated physically using plasma or corona to create a suitable working surface. For glass bonding applications we have developed a special primer pen which can be easily applied to prepare the surface for best results.

Application

Our products are delivered ready for use. As soon as you receive them, you can dispense them, be it by hand from the container, or semi/fully automatically. When applied automatically, we recommend the use of air pressure with the appropriate cartridge/piston combination to dispense the adhesive at the required speed and accuracy. If help is required, please consult our engineering department

Please read the corresponding **Safety Data Sheet** for this product.

Adhesives
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