

Vitralit® 7642 is a UV /visible light curable PMMA adhesive that has been formulated to form high tensile shear bonds. The cured product is hard.

**Shelf life:**

Store in original, unopened containers for 6 months at max. 25°C

**Technical Data**

Color	transparent
Resin	Urethan Acrylat

**UNCURED PROPERTIES**

Viscosity (Brookfield LVT/25°C) [mPa·s]	PE-Norm P001	1500 to 2000
Flash point [°C]	PE-Norm P050	> 93
Density [g/cm³]	PE-Norm P003	approx. 1.1
Refractive Index [nD20]	PE-Norm P018	1.483

**Curing**

UV(UV-A 40mW/cm² in 0,02mm): [sec.]	PE-Norm P002	8
Visible Light (UV-LED) :[sec.]	PE-Norm P037	10
Full Strength [hours]	PE-Norm P032	12
Depth of Cure [mm]	PE-Norm P033	3

**CURED PROPERTIES**

Temperature Resistance [°C]	PE-Norm P030	-30 to 120
Hardness [Shore D]	PE-Norm P052	75 to 85
Shrinkage [Vol-%]	PE-Norm P031	3.7
Water Absorption [mass-%]	PE-Norm P053	< 9

Our data sheets have been compiled to the best of our knowledge. The information included in our data sheets is exclusive information for the tended user and describes characteristics, with no declaration of commitment. We recommend trials in order to confirm that our products satisfy the particular application requirements. For an additional technical consultation, please contact our RD department. In general, for guarantee claims, please refer to our standard terms and conditions.

**Adhesives  
and more...**

**Mechanical Data**

Compression Shear Strength (PC/PC) [MPa]	[PE-Norm P061]	approx. 9.3
Compression Shear Strength (PC/PMMA) [MPa]	[PE-Norm P061]	approx. 6,1
Compression Shear Strength (PMMA/PMMA) [MPa]	[PE-Norm P061]	approx. 4,4
Lap Shear Strength (PMMA/PMMA) [MPa]	[PE-Norm P013]	approx. *3,9
Elongation at Break [%]	[PE-Norm P060]	approx. 75

**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  
and more...