## Technical Datasheet Vitralit® 6128 VT



#### **Product Description**

Panacol Vitralit<sup>®</sup> adhesives are one-component, solvent-free radiation-curing adhesives. The advantages are very short curing times, good adhesion to a variety of substrates, and easy handling. Vitralit<sup>®</sup> products are used in electronics, medical applications, optics and for fixing parts in general.

Vitralit<sup>®</sup> 6128 VT is characterized by a wide range of applications with good adhesion to glass, metals and many thermoplastics as well as good temperature resistance. As a special feature Vitralit<sup>®</sup> 6128 VT has a thermal initiator and a chemical activator, which allows subsequent curing of shadow areas.

Vitralit® 6128 VT can easily compensate unevenness and bridge gaps.

#### Suitability on various substrates

PMMA	*	chrome	✓	glass	✓	FR4	0
PC	*	copper	<b>√</b>	steel	✓	PA	0
brass	✓	PBTP	0	ΑI	✓	ceramic	✓
wood	0	PVC	*				

<sup>✓</sup> excellent o suitable \* pretreatment necessary/recommended

#### **Curing Properties**

UV-A	VIS	Thermal curing	Activator curing
✓	-	✓	✓

<sup>✓</sup> suitable - not suitable

The product cures within seconds with radiation in the UV-A - range (320 nm - 390 nm). For rapid and high quality crosslinking we recommend the UV devices manufactured by Dr. Hoenle AG, which complement our adhesive technology.

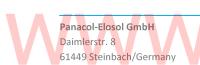
Bluepoint LED/LED-spot				
Wavelength [nm] 365 405				
Suitability	++	-		

<sup>+</sup> application-related ++ well-suited +++ ideal - not suitable

To obtain full cure at least one substrate must be transparent to the recommended wavelength. The curing speed will depend on the intensity of light, light source, the exposure time, and the light transmittance of the substrate. Increased mechanical properties are achieved after 12 hours.

UV-curing					
Intensity [mW/cm²]	Layer thickness [mm]	Time [sec]			
60	1	15			

Thermal curing	[min]
Time at 120°C	40



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Chemical curing	[min]
Activated	25

#### **Technical Data**

Resin acrylate Appearance translucent

#### **Uncured material**

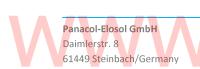
Viscosity [mPas] (Brookfield LVT, 25°C, Sp 4, 6rpm) PE-Norm 001	18 000 - 30 000
Density [g/cm³] PE-Norm 004	1,1
Flash point [°C] PE-Norm 050	>97
Refractive index [nD20] PE-Norm 018	1,4738

#### **Cured material**

Hardness shore D PE-Norm 006	72 - 79
Temperature resistance [°C] PE-Norm 065	-40 - 150
Shrinkage [%] PE-Norm 031	2,3
Water absorption [mass %] PE-Norm 016	<2,8

Glass transition temperature DSC [°C] PE-Norm 009	40 - 60
Coefficient of linear expansion [ppm/K] below Tg PE-Norm 017	106,0
Coefficient of linear expansion [ppm/K] above Tg PE-Norm 017	225,9

Thermal conductivity [W/m*K]  PE-Norm 062	0,3
Dielectric constant [10kHz]	6,2
Dielectric strength [kV/mm]	18,7
	1 -



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Young's modulus E [MPa] PE-Norm 056	1 136
Tensile strength [MPa] PE-Norm 014	31,1
Elongation at break [%] PE-Norm 014	2,8
Lap shear strength (glass/Al) [MPa] PE-Norm 013	13,6
Lap shear strength (glass/steel) [MPa] PE-Norm 013	22,6

#### Transport/Storage/Shelf Life

Trading unit	Transport	Storage	Shelf-life*
Cartridge	at room temperature	0°C - 10°C	at delivery min. 3 months
Other packages	max. 25°C	0 0 - 10 0	max. 6 months

<sup>\*</sup>Store in original, unopened containers!

#### **Instructions for Use**

#### **Surface preparation**

The surfaces to be bonded should be free of dust, oil, grease or other dirt in order to obtain an optimal and reproducible bond.

For cleaning we recommend the cleaner IP<sup>®</sup> Panacol. Substrates with low surface energy (e.g. polyethylene, polypropylene) must be pretreated in order to achieve sufficient adhesion.

#### **Application**

Our products are supplied ready to use. Depending on packaging they can be applied by hand directly from the container or semi or fully automatically. With automated application from the cartridge the adhesive is conveyed by a compressed air-operated displacement plunger via a valve in the needle. When metering low viscosity materials from bottles the adhesive is transported by a diaphragm valve. If help is required, please contact our application engineering department.

Adhesive and substrate may not be cold and must be warmed up to room temperature prior to processing.

After application, bonding of the parts should be done quickly. Vitralit<sup>®</sup> adhesives cure slowly in daylight. Therefore, we recommend to expose the material to as little light as possible and the use of opaque hose lines and dispensing needles.

For safety information refer to our safety data sheet.



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#### Note

The product is free of heavy metals, PFOS and Phthalates and is conform to the EU-Directive 2011/65/EU "RoHS II" .

Our data sheets have been compiled to the best of our knowledge. The enclosed information describes characteristic properties, with no declaration of commitment. We recommend trials in order to confirm that our products satisfy the particular application requirements. For any additional technical support, please contact our application engineering department. For warranty claims, please refer to our standard terms and conditions.

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DIN ISO 9001 certified