

Follow the instructions in our technical and safety data sheet before processing.

### PRODUKT SPECIFICATION

Vitralit® materials are solvent-free 1-part products that can be cured with UV or UV/Vis light.

### PREPARATION

Cold-stored adhesives should be conditioned to room temperature before application.

The parts to be joined should be free of contaminants such as grease, oil and dust in order to achieve the optimum bond strength. Isopropanol can be used as a cleaning agent. In addition, the parts to be joined should also be conditioned to room temperature if they have been stored in a cool place.

### PROCESSING

Depending on the area of application, dosing can be carried out directly from the original container or after transfer to a dosing system.

Care must be taken to ensure that the adhesive in the opened container or dosing system remains protected from ambient light with wavelengths below 500 nm. To block light of the critical wavelengths, amber-colored UV protection films can be used, for example, which can be glued to windows and lamps.

Vitralit® products can be cured by means of UV or UV/Vis irradiation. The photoinitiators react to certain wavelengths, which are specified in the data sheet for each adhesive. The curing time depends on various factors:

- Wavelength of the irradiation
- Intensity of the irradiation
- Layer thickness of the respective Vitralit® product
- Influences of the parts to be joined (absorption, reflection, UV permeability)
- Temperature

Exemplary curing parameters are given in the technical data sheet. A certain amount of heat is required for an optimum light-curing reaction of the epoxy products. In many cases, this heat is generated by the light exposure and the exothermic reaction of the adhesive itself. If this is not sufficient, which may be due to heat-dissipating substrates, for example, an external supply of heat is required.

Some Vitralit® products have a secondary curing mechanism to cure the adhesive in possible shadow zones or deeper layers. The following mechanisms are available:

**Thermal** – by a thermal post-treatment using an oven, thermode etc.,

**Moisture** – through humidity and/or absorbed moisture on the part to be joined,

**Chemical** – through a separately applied activator

**Anaerobic** – in the presence of metal ions and exclusion of oxygen

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### STORAGE

Store the supplied adhesives in accordance with the temperatures specified in the technical data sheet. Adhesives and parts to be joined that are stored in a cool place must be conditioned to room temperature before processing. Frequent temperature changes can damage the adhesive, as can frequent opening and closing of the container.

### DISPOSAL

Used cleaning cloths, containers and adhesive residues in uncured form should be disposed of as hazardous waste. They can be collected in a closed container. Once hardened, they can be disposed of as household waste.

### CONTACT

Hoenle Adhesives GmbH | Stierstädter Straße 4 | 61449 Steinbach | Germany  
T: +49 6171 6202-0 | adhesivesystems@hoenle.com

For regional sales and technical support, please refer to our global contact directory  
<https://www.hoenle.com/contact>.