TECHNICAL DATASHEET
VITRALIT® 6128

PRODUCT DESCRIPTION

Modified acrylate | 1 part | solvent-free | UV curing | secondary heat cure

- Glass bonder
- Potting
- Very good adhesion to stone, glass, metal and plastics
- Chemical cure with activator possible

CURING PROPERIES

UV-A	LED 365nm	LED 405nm	Secondary heat cure	Chemical cure
✓	✓	-	✓	✓

✓ suitable - not suitable

In cases where UV curing is applicable, heat curing may only be used as a secondary process for shadowed areas.

Light-curing (Hoenle Discharge Lamp)		
Intensity [mW/cm²]*	Layer thickness [mm]	Time [s]
60	1	15

**measured by Hoenle UV-Meter 3.0 / UV-A F0*

LED-curing (Hoenle LED Spot 100, 365nm)		
Intensity [mW/cm²]**	Layer thickness [mm]	Time [s]
300	0.5	10

***measured by Hoenle UV-Meter 3.0 / LED F2*

Secondary heat cure	[min]
Time at 120°C	40

Chemical cure	[min]
With activator	25

To obtain full cure at least one substrate must be transparent to the recommended wavelength. The curing speed depends on the wavelength spectrum of the light source, the intensity of light, the distance to the light source, the component geometry and the amount of adhesive.

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TECHNICAL DATA

Resin	Acrylate
Appearance	Translucent

Uncured Material	
Viscosity [mPas] (Brookfield LVT, 25 °C, Sp. 3/60 rpm) *Test instruction P001*	800 – 1,200
Density [g/cm³] *Test instruction P004*	1.0 – 1.2
Refractive index [nD20] *Test instruction P023*	1.47 – 1.48

Cured Material	
Hardness shore D *Test instruction P006*	70 – 80
Typical operating temperature [°C]	-40 – 150
Linear shrinkage [%] *Test instruction P031*	<4
Water absorption [wt%] *Test instruction P016*	<3

Glass transition temperature - DSC [°C] *Test instruction P009*	40 – 60
Coefficient of thermal expansion [ppm/K] below Tg *Test instruction P017*	50 – 100
Coefficient of thermal expansion [ppm/K] above Tg *Test instruction P017*	230 – 400

Thermal conductivity [W/m*K] *Test instruction P062*	0.1 – 0.3
Dielectric constant [10kHz] *IEC 62631-2-1*	5 – 9
Dielectric strength [kV/mm] *DIN EN 60243*	17 – 21

Young´s modulus – Tensile test [MPa] *LED 365nm, 250mW/cm², 1min* *Test instruction P056*	900 – 1,400
Tensile strength [MPa] *UV-A Fe-doped hand lamp, 60mW/cm², 30s* *Test instruction P014*	30 – 38
Elongation at break [%] *UV-A Fe-doped hand lamp, 60mW/cm², 30s* *Test instruction P014*	5 – 8
Lap shear strength (glass/stainless steel) [MPa] *UV-A Fe-doped hand lamp, 60mW/cm², 30s* *Test instruction P013*	15 – 20
Lap shear strength (glass/Al) [MPa] *UV-A Fe-doped hand lamp, 60mW/cm², 30s* *Test instruction P013*	12 – 18

Lap shear strength (glass/steel) [MPa] *UV-A Fe-doped hand lamp, 60mW/cm², 30s* *Test instruction P013*	11 – 17

TRANSPORT/STORAGE/SHELF LIFE

Package type	Transport	Storage	Shelf life*
Syringe/Cartridge	At room temperature max. 25°C	At room temperature max. 25°C	At delivery min. 6 months max. 12 months
Other packages			

Store in original, unopened containers!

INSTRUCTIONS FOR USE

Surface preparation

The surfaces to be bonded should be free of dust, oil, grease, mold release, or other contaminants in order to obtain an optimal and reproducible bond. For cleaning we recommend the cleaner IP® from Hoenle, or a solution of Isopropyl Alcohol at 90% or higher concentration. 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 the packaging, our adhesives may be dispensed by hand directly from the package, or they can be applied using dispensing systems and automation that is compatible with light-curable adhesive chemistry. Vitralit® adhesives can begin to cure slowly in daylight and with longer term exposure under indoor lighting. We therefore recommend that adhesive exposure to ambient light must be kept to a minimum. Fluid lines and dispense tips must be 100% light blocking. For assistance with dispensing options, please contact our Application Engineering department. Adhesive and substrate should not be cold for proper bonding. They must be allowed to warm to room temperature prior to processing. After dispensing the adhesive, bonding of the parts should be done promptly. It is recommended that curing stations be equipped with air exhaust systems to evacuate vapors and heat generated during the curing process. After curing, the adhesive must be allowed to cool to ambient temperature before testing the product's performance. For safety information refer to our Material Safety Data Sheet (MSDS).

Storage

This is light sensitive material. Containers must remain covered when not in use. Minimize exposure of uncured material to daylight, artificial light, and UV light during storage and handling. Store uncured product in its original, closed container in a dry location. Any material removed from the original container must not be returned to the container as it could be contaminated. Hoenle cannot assume responsibility for products that were improperly stored, contaminated, or repackaged into other containers.

Handling and Clean-up

For safe handling information, consult this product's Material Safety Data Sheet (MSDS) prior to use. Uncured material may be wiped away from surfaces with organic solvents. Do not use solvents to remove material from eyes or skin!

DISCLAIMER

The product is free of heavy metals, PFOS and Phthalates and is conform to the current EU-Directive RoHS.

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