



## PRODUCT CHARACTERISTICS

Basis Technology	UV-Acrylate
Components	1K
Appearance/Color	Transparent
Cure	LED (365nm, 385nm, 405 nm) UVA

## UNCURED PHYSICAL PROPERTIES

Viscosity /mPa.s/-2 rpm	110000-150000
Density	1,02-1,05
Appearance/Color Liquid	Clear/yellowish

## FIXTURE TIME

Test on glass (gap: 0,125 mm)

UVA  
Intensity 50-60 mW/cm<sup>2</sup>      7 ± 0,5 s

LED 405 nm  
Intensity 2 W/cm<sup>2</sup>      4 ± 0,5 s

## CURING PHYSICAL PROPERTIES

Shore Hardness D /ISO 868/	20-35
Tensile Strength (ISO 527)	9-11 MPa
Nominal Elongation at Break (ISO 527)	200-230%
Tg (DMA)	49°C
Water absorption after 48 h /ASTM D542/	≤ 1 %
Volume Shrinkage (ISO 10563)	8 ± 0,5 %

## SAMPLES PREPARATION

For all performance data provided in this TDS, samples were prepared using UVA lamp with an irradiation measured on sample of 40-50 mW/cm<sup>2</sup> for 60s.

## SUBSTRATES RECOMMENDATION

Substrates	Recommendation
ABS	X
PA	O
PMMA	X
PBT	O
PC	O
SAN	X
Glass	X
Aluminium	X
Stainless Steel	X

X: Recommended

O : Limited application

## BONDING PERFORMANCE

Lapshear strength (ISO 4587) @ 23° C (MPa)

Samples were prepared using UVA lamp with an irradiation measured on sample of 40-50 mW/cm<sup>2</sup> for 60 s and a gap of 0,25 mm.

PMMA/ABS	7 ± 1
PMMA/PMMA	7 ± 1
SAN/SAN	7 ± 1
Glass/Glass	5 ± 1
PMMA/Aluminum	6 ± 1
PMMA/Stainless Steel	8 ± 1



