

PERMACOL UV 310**Capillary UV curable adhesive**

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PERMACOL[®] UV-adhesive type 310 is a one component adhesive with low viscosity, that can be cured with UV-A-light in the 360-380 nanometer range. Best results are obtained with wavelengths of the highest possible intensity.

PERMACOL[®] UV 310 is a low viscosity adhesive used for high strength bonding of glass-glass and glass-metals. Due to its composition, this adhesive remains clear and transparent. Permacol[®]UV adhesives are 100% reactive, they are solvent free.

Product properties:

Resin composition	: urethane-acrylate resin with monomeres
Colour	: clear transparant
Viscosity	: 75 mPa.sec / 23°C
Specific gravity	: 1,06-1,08 g/cm ³
Storage stability	: 12 months 15 - 25°C (closed and dry)

Curing time (360-380 nanometer): 4 - 5 sec setting time

At 50 mWatt/cm² : 10 - 30 sec full cure

Faster curing is possible with higher UV intensities (100 – 200 mWatt/cm²).
In that case one must be careful at heat development.

Film properties:

Transparency	: clear, transmission 99%
Temperature resistance	: -20° to + 125°C
Hardness	: 65° Shore D
Refractive index	: nD/20 = 1,473°
Tensile Shear strength	: glass-steel 110 kg/cm ²

Manual of instruction:

1. Degrease glass with ethanol. Abrade metal with medium-grit paper and clean afterwards.
2. Apply adhesive on one side.
3. Assemble parts to be bonded and hold them together.
4. Expose adhesive film to UV-light according to curing schedule.

Packings:

100 g. flask

Or on demand package

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