

PERMACOL[®] UV 389/3**Flexible UV cure adhesive**

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PERMACOL[®] UV-adhesive type 389/3 is a one component adhesive, 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 389/3 is used when flexibility is wanted or needed, for bonding of glass-glass, LEDs' - and most synthetic foils. This product can also be used as casting resin for electronic components. 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 with monomer
Color	: clear and transparent
Viscosity	: 1.000 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)	: 15 sec setting time
At 50 mWatt/cm ²	: 30 sec full cure

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

Film properties:

Transparency	: transparent, transmission 99%
Temperature resistance	: -20° to + 100°C
Hardness	: 30-35° Shore D
Refractive index	: $n_{20}^D = 1,4742$
Tensile Shear strength	: glass-steel 80 kg/cm ²
Glass transition	: < 20°C

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:

100g en 500g flasks

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