

Vitralit® 1671 is a stable dam material on an epoxy resin basis, which can be UV-A cured as well as thermally cured at low temperatures. The dam can be cured wet on wet with the filler material.

Vitralit® 1671 features high ionic purity (Na<sup>+</sup>,K<sup>+</sup>,Cl<sup>-</sup> <5ppm), good heat conductivity and low humidity absorption properties.

If stored properly in the refrigerator at (+ 5 °C/no UV radiation exposure), the product has a shelf-life of 6 months in closed original packaging

**shelf life:**

in closed original packing unit at 5°C without UV- irradiation -- 6 months --

## Technical Data

Color	grey
Resin	epoxy
Filler	approx. 35% Quarz <10µm

## UNCURED PROPERTIES

Viscosity (Brookfield LVT/25 °C) [Pa·s]	PE-Norm P001	250 to 300
Flash point [°C]	PE-Norm P050	> 100
Density [g/cm³]	PE-Norm P003	approx. 1.5

## Curing

UV(UV-A 60mW/cm²): [sec.]	PE-Norm P002	60
Visible Light (LED Power Pen) :[sec.]	PE-Norm P037	30
Thermal Curing 105 °C :[Min]	PE-Norm P035	30
Full Strength [hours]	PE-Norm P032	24

## CURED PROPERTIES

Temperature Resistance [°C]	PE-Norm P030	-40 to 180
Hardness [Shore D]	PE-Norm P052	80 to 90
Volume resistivity [Ohm x cm]	ASTM-D-257-93	1E+16
Shrinkage [Vol-%]	PE-Norm P031	.88
Water Absorption [mass-%]	PE-Norm P053	< 0.25
Tg [°C] (DSC)	PE-Norm P009	> 150
CTE [ppm/K]	PE-Norm P017	40
Dielectric Constant [10kHz]	PE-Norm P054	3.4
Dielectric Strength [kV/mm]	PE-Norm P055	15

Our data sheets have been compiled to the best of our knowledge. The information included in our data sheets is exclusive information for the tended user and describes characteristics, with no declaration of commitment. We recommend trials in order to confirm that our products satisfy the particular application requirements. For an additional technical consultation, please contact our RD department. In general, for guarantee claims, please refer to our standard terms and conditions.

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## Mechanical Data

Lap Shear Strength (Alu/Alu) [MPa]	[PE-Norm P013] approx. 10.23
Lap Shear Strength (Steel/Steel) [MPa]	[PE-Norm P013] approx. 13.21
Elongation at Break [%]	[PE-Norm P060] approx. 1,67
Tensile Stress [MPa]	[PE-Norm P060] approx. 34,15
E-Modul [MPa]	[PE-Norm P056] 3499

### Instructions of use of filled Vitralit UV epoxy:

- store at max. 5 °C
- warm up to room temperature before usage
- dispensable, filled systems are use at machines from e.g. Mühlbauer, Schiller, Esec or Ruhlmat
- surface must be clean and dry and free from fat and parting agents
- for curing UV- light at wavelength from 315 - 400 nm is needed.

### The curing time depends on:

- \* emission spectrum and energy of emitter, min 30mW/cm<sup>2</sup>
- \* distance to substrate
- \* ageing of emitter
- \* layer thickness
- \* material influence like reflection, adsorption and UV- diaphaneity

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