

Technical Datasheet

Vitralit® 7041 T



Product Description

Panacol Vitralit® adhesives are one-component, solvent-free radiation-curing adhesives. The advantages are very short curing time, good adhesion to a variety of substrates, and easy handling. Vitralit® products are used in electronics, medical applications, optics and for fixing parts in general.

Vitralit® 7041 T is a shear thinning UV and/or light cure adhesive. Vitralit® 7041 T appears transparent in thin layers. In thick layers it is translucent.

Vitralit® 7041 T is a high viscosity instant adhesive with gap filling ability. The shear thinning behavior provides clean, fast and automated dispensing processes. The product is specially designed for plastic bonding applications in medical devices. It provides a very good bonding to a wide range of materials like PC, ABS, PET, glass and metals. Vitralit® 7041 T is suitable for transparent plastic materials with low UV transmission such as PC.

Vitralit® 7041 T has met the requirements for USP Class VI, ISO 10993-4 and ISO 10993-5. Therefore it is suitable for use in the assembly of disposable medical devices. It is compatible with sterilization by autoclaving, gamma irradiation and EtO. Vitralit® 7041 T is also available with fluorescent capabilities improving the process quality.

Curing Properties

UV-A	VIS	Thermal curing	Activator curing
✓	✓	-	-

✓ suitable - not suitable

The product cures within seconds with radiation in the UV-A - (320 nm - 390 nm) and visible range (405nm). For rapid and high quality crosslinking we recommend the UV devices manufactured by Dr. Hoenle AG, which complement our adhesive technology.

UV-curing (Hoenle Discharge lamp, 320-450nm)		
Intensity [mW/cm ²]	Layer thickness [mm]	Time [sec]
35	2	5

VIS-curing (Hoenle LED Spot 100, 405nm)		
Intensity [mW/cm ²]	Layer thickness [mm]	Time [sec]
1000	2	1

To obtain full cure at least one substrate must be transparent to the recommended wavelength. The curing speed will depend on the intensity of light, light source, the exposure time, and the light transmittance of the substrate. Increased mechanical properties are achieved after 12 hours.

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Resin
Appearance

acrylate
transparent, slightly yellow

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Uncured material

Viscosity [mPas] (Brookfield RVT, 25°C, sp 6/30 rpm) <i>PE-Norm 001</i>	2 000 - 4 000
Viscosity [mPas] (Brookfield RVT, 25°C, sp 6/6 rpm) <i>PE-Norm 001</i>	10 000 - 20 000
Density [g/cm ³] <i>PE-Norm 004</i>	1,05
Flash point [°C] <i>PE-Norm 050</i>	>100
Refractive index [nD20] <i>PE-Norm 018</i>	1,47

Cured material

Hardness shore D <i>PE-Norm 006</i>	60 - 80
Temperature resistance [°C]	-40 - 120
Shrinkage [%] <i>PE-Norm 031</i>	<3
Water absorption [mass %] <i>PE-Norm 016</i>	<6

Glass transition temperature DSC [°C] <i>PE-Norm 009</i>	37 - 47
Coefficient of thermal expansion [ppm/K] below Tg <i>PE-Norm 017</i>	109
Coefficient of thermal expansion [ppm/K] above Tg <i>PE-Norm 017</i>	441

Young's modulus [MPa] <i>PE-Norm 056</i>	580
Tensile strength [MPa] <i>PE-Norm 014</i>	14
Elongation at break [%] <i>PE-Norm 014</i>	158
Lap shear strength (PC/PC) [MPa] <i>PE-Norm 013</i>	12
Lap shear strength (PMMA/PMMA) [MPa] <i>PE-Norm 013</i>	6
Lap shear strength (glass/stainless steel) [MPa] <i>PE-Norm 013</i>	15

Transport/Storage/Shelf Life

Trading unit	Transport	Storage	Shelf-life*
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 or other dirt in order to obtain an optimal and reproducible bond.

For cleaning we recommend the cleaner IP® Panacol. 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 packaging they can be applied by hand directly from the container or semi or fully automatically. With automated application from the cartridge the adhesive is conveyed by a compressed air-operated displacement plunger via a valve in the needle. When metering low viscosity materials from bottles the adhesive is transported by a diaphragm valve. If help is required, please contact our application engineering department.

Adhesive and substrate may not be cold and must be warmed up to room temperature prior to processing.

After application, bonding of the parts should be done quickly. Vitralit® adhesives cure slowly in daylight. Therefore, we recommend to expose the material to as little light as possible and the use of opaque hose lines and dispensing needles.

For safety information refer to our safety data sheet.

Disclaimer

The product is free of heavy metals, PFOS and Phthalates and is conform to the EU-Directive 2017/2102/EU "RoHS III".

THE VALUES NOTED IN THIS TECHNICAL DATA SHEET ARE TYPICAL PROPERTIES AND ARE NOT MEANT TO BE USED AS PRODUCT SPECIFICATIONS.

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Contact

Panacol-Elosol GmbH
Daimlerstr. 8
61449 Steinbach
Germany
Phone.: +49 6171 6202-0
Mail: info@panacol.de
www.panacol.com

Panacol-USA, Inc.
142 Industrial Lane
Torrington CT 06790
USA
Phone: +1 860-738-7449
Mail: info@panacol-usa.com
www.panacol-usa.com

Panacol-Korea Co., Ltd.
#707, Kranz Techno, 388 Dunchon-daero
Junwon-gu, Seongnam
Gyeonggi-do, 13403 KOREA
Phone: +82 31 749 1701
Mail: info@panacol-korea.com
www.panacol-korea.com

Eleco Panacol – EFD
125, av Louis Roche
Z.A. des Basses Noëls
92238 Gennevilliers Cdx FRANCE
Tél.: +33 (0)1 47 92 41 80
Mail: eleco@eleco-panacol.fr
www.eleco-panacol.fr