

Uncured material

Viscosity [mPas] (Kinexus Rheometer, 25°C, 1s ⁻¹) <i>PE-Norm 064</i>	shear thinning 100 000 - 250 000
Viscosity [mPas] (Kinexus Rheometer, 25°C, 10s ⁻¹) <i>PE-Norm 064</i>	15 000 - 40 000
Thixotropic index <i>PE-Norm 064</i>	5 - 8
Density [g/cm ³] <i>PE-Norm 004</i>	1,1
Flash point [°C] <i>PE-Norm 050</i>	>100
Refractive index [nD20] <i>PE-Norm 018</i>	1,468

Cured material

Hardness shore A <i>PE-Norm 006</i>	20 - 40
Temperature resistance [°C]	-45 - 145
Shrinkage [%] <i>PE-Norm 031</i>	<4
Water absorption [mass %] <i>PE-Norm 016</i>	<3

Glass transition temperature DSC [°C] <i>PE-Norm 009</i>	-30 - -20
Coefficient of thermal expansion [ppm/K] below Tg <i>PE-Norm 017</i>	17
Coefficient of thermal expansion [ppm/K] above Tg <i>PE-Norm 017</i>	614

Young's modulus [MPa] <i>PE-Norm 022</i>	3
Tensile strength [MPa] <i>PE-Norm 014</i>	1
Elongation at break [%] <i>PE-Norm 014</i>	224

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. 3 months, max. 6 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".

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Technical Datasheet

Vitralit[®] MASK 20109



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