

Technical Datasheet

Vitralit® MID-007



Product Description

Panacol Vitralit® adhesives are one-component, solvent-free radiation-curing adhesives. The advantages are very short curing times, 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® MID-007 is a higher viscosity, solvent-free, LED light curable adhesive that forms resilient, high strength bonds between many plastics and dissimilar materials including polycarbonate, acrylic, PVC, PU, and stainless steel.

Bonds prepared with Vitralit® MID-007 are clear, firm, and highly resistant to moisture and aging. Vitralit® MID-007 cures incredibly fast with broad spectrum UV lamps (320-450 nm), as well as monochromatic LED lamps. Optimal LED curing is achieved using LED systems with outputs of 365nm or 405nm. Vitralit® MID-007 has been formulated to pass USP Class VI biocompatibility testing. It is compatible with common sterilization methods including gamma irradiation, EtO, and limited autoclaving. Vitralit® MID-007 fluoresces in a brilliant orange color when exposed to low intensity UV light, ("blacklight"). It is easily detectable by vision systems or through manual inspection.

Curing Properties

UV-A	VIS	Secondary heat cure	Activator curing
✓	✓	-	-

✓suitable - not suitable

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

UV-curing (Hoenle Bluepoint 4 Spot, 320-450nm)		
Intensity [mW/cm ²]	Layer thickness [mm]	Time [sec]
2000	0,05	<1

VIS-curing (Hoenle Bluepoint LED ECO, 405 nm)		
Intensity [mW/cm ²]	Layer thickness [mm]	Time [sec]
2000	0,05	<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	urethane acrylate/monomer blend
Appearance	transparent, liquid
Fluorescence	orange

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Uncured material

Viscosity [mPas] (Kinexus Rheometer, 25°C, 1s ⁻¹) <i>PE-Norm 064</i>	10 000 - 20 000
Viscosity [mPas] (Kinexus Rheometer, 25°C, 10s ⁻¹) <i>PE-Norm 064</i>	1 000 - 3 000
Density [g/cm ³] <i>PE-Norm 004</i>	1,1
Flash point [°C] <i>PE-Norm 050</i>	>93
Refractive index [nD20] <i>PE-Norm 018</i>	1,4826

Cured material

Hardness shore D <i>PE-Norm 006</i>	60 - 80
Temperature resistance [°C]	-40 - 140
Shrinkage [%] <i>PE-Norm 031</i>	<3

Glass transition temperature DSC [°C] <i>PE-Norm 009</i>	30 - 50
Coefficient of thermal expansion [ppm/K] below Tg <i>PE-Norm 017</i>	13
Coefficient of thermal expansion [ppm/K] above Tg <i>PE-Norm 017</i>	346

Young's modulus E [MPa] <i>PE-Norm 022</i>	219
Tensile strength [MPa] <i>PE-Norm 014</i>	13
Elongation at break [%] <i>PE-Norm 014</i>	44

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 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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