

**KEOL****UV ADHESIVE****K-LITE 246**

Adhesive 246 from the K-LITE range is a high-strength, light-curing anaerobic adhesive. Suitable for small technical bonding filler applications, if cured with suitable lamps. K-LITE 246 is designed for bonding, sealing or varnishing metal and bonding glass in industrial applications. Curing can be aided by heat, or the use of an activator and/or UV light (wavelength range 365 to 405 nm).

- **SOFT & CHOCK RESISTANT**
- **HIGH TEMPERATURE RESISTANCE**
- **SOLVENT-FREE**

CHEMICAL BASIS

ACRYLATE

DUAL CURING

ANAEROBIE / UV

COLOR

TRANSPARENT

HARDNESS

70 D

PROPRIÉTÉS		K-LITE 246
Appearance		Liquid
Viscosity at 23°C, (mPa.s)		1200
Density at 20°C		1,07
Color		Light yellow
Absorption wavelength (nm)		365-405
Curing energy (J/cm²=W.s/cm²)		4
Tensile strenght at break(ISO 527-1) 350 mW/cm², 25 seconds, 405 nm		44
Elongation at break (%) 350 mW/cm², 25 secondes, 405 nm		17
Tensile shear (MPa) (EN 1465)	1.4301 Stainless steel	13
	DC04 Steel	11
	DC04 shot-blasted steel	14
	5005A Aluminium	6
	5005A shot-blasted Aluminium	7
	ALMG3 Aluminium	7
	Zinc	6
Hardness		70D
Temperature operating range (°C)		-50 à +150
Shelf life (months)		6
Full curing anaerobie (hours)		72

# KEOL

## UV ADHESIVE



### SURFACE PREPARATION

The strength and durability of joints depend on proper pretreatment of the surfaces to be bonded. At a minimum, the bonded surfaces should be cleaned with a good degreaser to remove all traces of dust, dirt, oil or grease. The pretreatment of thermoplastic materials such as PVC, polycarbonate, polypropylene, PMMA, etc., can be made using a light blend of ethers or isopropanol. Strong solvents are not recommended as they may damage plastic surfaces. For any other surface, acetone or trichlorethylene can be used for pretreatment. Never use petroleum or any other solvent. When possible, perform mechanical abrasion to remove paint from surfaces (if necessary) and to increase adhesive strength and retention. Allow the pretreated surface to dry before applying the adhesive.



### PRODUCT PACKAGING

**K-LITE 246** is available on 50g et 200g bottles.



### STORAGE

The product can be stored in a closed container in a dry place at a temperature between 0°C and 10°C. Exposure to higher or lower temperatures will result in a reduction of the stated shelf life.



### NOTE

The information, and particularly the recommendations regarding application and KEOL products, are given to you in good faith and are based on current knowledge and experience of the products having been properly stored, handled and applied under normal conditions. KEOL cannot take responsibility for the results obtained by others since we have no control over their method. It is up to the user to determine the suitability of the products for the specific application for any production methods mentioned in this document. Also, it is up to the user to adopt the necessary precautions as recommended for the protection of the establishment and people against any kind of risk that could arise during the handling and use of the products. KEOL cannot assume all warranties mentioned or implied, including warranties of merchantability or fitness for a specific purpose, arising from the sale or use of KEOL products. KEOL cannot assume liability for incidental consequences or damages of any kind, including lost profits. Users should always refer to the most recent edition of the technical data sheet or material safety data sheet for the product concerned. Copies of those documents will be provided upon request.