

KEOL**UV ADHESIVE****K-LITE 278V-N**

K-LITE range 278V-N adhesive has been specially developed for bonding plastic materials. Its great flexibility allows it to compensate for differential expansion forces between the assembled parts. It is a black resin with a photosensitive acrylic base. One-component, its application is very simple on all types of support.

- SINGLE COMPONENT
- RAPID POLYMERIZATION
- HIGH ELONGATION
- BLACK

CHEMICAL BASIS	Urethane Acrylate
THICKNESS MAX.	500µm
COLOR	Black
HARDNESS	70 D

PROPERTIES	278V - N		
Chemical base	Acrylic – Urethane		
Viscosity @23°C 3 RPM, mobile S3 Brookfield (mPa.s)	110,000-150,000		
Appearance	Viscous		
Density @20°C	1.07		
Color	Black		
Absorption wavelength	405nm		
Working thickness	0.5mm	0.15mm	0.35mm
Polymerization power(mW/cm²)	6000mW/cm²	200mW/cm²	1000mW/cm²
Sunshine time	120s	60s	120s
Shear tension(MPa) (EN 1465) 405nm; T+24h	0.15mm	0.35mm	
PC/PC (Mpa)	6.1	8.5	
PMMA/PMMA (Mpa)	3	2.3	
Shore D hardness	70 +/-5		
Shelf life in packaging	6 months		
Complete polymerization (hour)	24		

KEOL**UV ADHESIVE****SURFACE PREPARATION**

The strength and durability of joints depends on proper pretreatment of the surfaces to be bonded. At a minimum, the bonded surfaces should be cleaned with a good degreasing product to remove all traces of dust, dirt, oils or grease.

Pretreatment of thermoplastic materials such as PVC, polycarbonate, polypropylene, PMMA, etc., can be done using a mild mixture of ethers or isopropanol. It is not recommended to use strong solvents as they may damage plastic surfaces.

For any other surface, acetone or trichloroethylene 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 the strength and retention of the adhesive. Allow the pre-treated surface to dry before applying the adhesive.

**PACKAGING**

K-LITE 278V-N is available in 30 and 600cc black syringes, 1L and 3.5L pots.

**PRODUCT STORAGE**

Shelf life of glue 278V-N is 6 months in its original unopened packaging. The product can be stored in a closed container, in a dry place at a temperature between 15°C and 25°C. Exposure to higher or lower temperatures will result in a reduction of the indicated shelf life, as well as possible loss of performance.

**PRECAUTIONS FOR HANDLING THE PRODUCT**

K-LITE products are generally safe to handle, provided that precautions regarding handling of chemicals are taken. The cartridge product should not come into contact with food products or cooking utensils, and certain safety measures should be taken to prevent the contents of the cartridges from escaping and coming into contact with the skin, as people with very sensitive skin may be affected. The use of rubber or plastic gloves is recommended, as is eye protection. The skin should be thoroughly cleaned at the end of each work session by washing with soap and warm water. Avoid the use of solvents. To dry the skin, use disposable paper. Adequate ventilation for the work area is recommended. These precautions are explained in more detail in the safety data sheet for the individual products and you should refer to this document for further information.

**NOTE**

The information, and particularly the recommendations concerning the 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 assume 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 advised for the protection of the establishment and persons against any kind of risks that may arise during the handling and use of the products. KEOL cannot assume any warranties mentioned or implied, including warranties of merchantability or fitness for a particular reason, arising from the sales or use of KEOL products. KEOL cannot assume responsibility for incidental or consequential damages of any kind, including lost profits. Users should always refer to the most recent edition of the technical data sheet for the relevant product. Copies of this document will be provided on request.