

KEOL**UV ADHESIVE****K-LITE LOCA 613**

K-LITE LOCA 613 Adhesive is a low-viscosity, fast-curing, UV-curing acrylate adhesive designed for use as an adhesive for optical screen bonding. This product cures in seconds to form a soft, flexible, low-modulus polymer that can provide high bond strength without imposing stress. K-LITE LOCA 613 has excellent moisture resistance. This product requires exposure to UV or short-wavelength visible light during curing. Due to the variability of different UV light sources, it is suggested that the user test and specify the UV intensity and exposure time. Low-intensity UV light sources (4000 mj/cm²) with an exposure time of 60 to 120 seconds.

- LOW VISCOSITY – LOW MODULUS
- LOW TG
- NON-YELLOWING
- EXCELLENT HYDROLITHIC STABILITY
- EXCELLENT MOISTURE RESISTANCE

CHEMICAL BASIS	Urethane Acrylate
CURING MODE	UV/LED
COLOR	Transparent
VISCOSITY	2100+/-400cps
GRAVITY	0,93

PROPERTIES

LOCA 613

UNCURED PROPERTIES

	VALUE	TEST METHOD
Appearance	liquid	
Color	Transparent	
Viscosity @23°C BrookfieldmPa.s	2100+/-400cps	N/A
Teneur en solvant	No non-reactive solvents	N/A

MECHANICAL/OPTICAL HARDENED PROPERTIES

Modulus of Elasticity (psi)	4.30	N/A
Tensile strength (psi)	27,5	N/A
Hardness – Shore 00	22	ASTM D638
Lengthening %	> 200	N/A
Densité (g/cc)	0.98	
Removal	<1%	N/A
Tg (°C)	<-50°C	DCS
CTE above the Tg	220	ASTM D638
Moisture resistance	Excellent	N/A
Operating temperature range	-50° à + 125°C	N/A
Constante diélectrique (200-1000kHz)	4.0	

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KEOL**UV ADHESIVE****PROPERTIES****LOCA 613****MECHANICAL/OPTICAL HARDENED PROPERTIES**

	VALUE	TEST METHOD
Refractive index	1.49	Refractometer
Transmission	>99	ASTM E903 to 550nm
Mist (%)	0.02	ASTM D1003

UV LIGHT TREATMENT DATA

Curing intensity(Energie), mW/cm ² (mJ/cm ²)	<50-100 (env.3000-4000)	FTIR cure ratio
Spectral Power, Nm	300-415	N/A
Optimal wavelength, Nm	390 Nm	N/A

RECOMMENDED SUBSTRATES

Glass

Plastics

Stainless steel and aluminium screens (dial)

Painted frames (dial)

STORAGE AND PRODUCT LIFE

K-LITE LOCA 613 should be stored between 38°C -28°C in tightly sealed, light-blocking containers, away from direct sunlight. Protect from freezing. Allow the material to equilibrate at the temperature of the processing area for 24 hours before use. Please refer to the product label for shelf-life information. Although the material can be heated to facilitate degassing before use (-26 to -28 HG, 50°C/Kg, minimum 30 minutes), this operation should only be carried out on the amount of glue to be used immediately. Multiple heating cycles of the bulk container or storage at high temperatures should be avoided. Consult the SDS for complete safety information

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 results obtained by others since we have no control over their method. It is the user's responsibility 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 risks 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 reason, arising from sales or use of KEOL products. KEOL cannot assume responsibility 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 for the specific product. Copies of this document will be provided upon request.

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