

KEOL**UV ADHESIVE****K-LITE RANGE 277**

277 adhesive from the K-LITE range, has been specially developed for bonding plastic materials. Its great flexibility allows it to compensate for the differential expansion forces between the assembled parts. It is a photosensitive acrylic base translucent resin. Single-component and of intermediate viscosity, its application is very simple on all types of support. Very good bonding results on PMMA, ABS, SURLYN, etc ...

- SINGLE-COMPONENT
- QUICK POLYMERIZATION
- EXTREMELY FLEXIBLE PRODUCT
- HIGH TEMPERATURE HOLD

CHEMICAL BASIS

Acrylate

REACTION TIME

30s

COLOR

Transparent

HARDNESS

75 ± 5 A

VISCOSITY

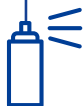
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PROPERTIES	277L	277M	277V
Chemical basis	Acrylic	Acrylic	Acrylic
Viscosity (at 23 ° C Brookfield) mPas	70-150 Liquid	20 000-30 000 Medium	100,000-150000 Viscous
Density at 20 ° C	1.06	1.06	1.06
Color	Transparent	Transparent	Transparent
Appearance	Liquid	Medium	Viscous
Refractive index	1.466	1.466	1.466
Absorption wavelength (nm)	380-400	380-400	380-400
Curing time under UVA exposure 60mW / cm ²	30s	30s	30s
Shear tension (MPa) NFT-EN-1465	3	3	3
Shore A hardness	75 ± 5 A	75 ± 5 A	75± 5 A
Elongation at break (%)	300	300	300
Temperature range of use	-50 °C to + 150°C	-50°C to + 100°C	-50°C to + 100°C
Shelf life in packaging and at room temperature	6 months	6 months	6 months
Complete polymerization after (hour)	24	24	24

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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 in order to remove all traces of dust, dirt, oils 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. It is not recommended to use strong solvents as they may damage the plastic surfaces. For any other surface, acetone or trichlorethylene can be used for the 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

277 adhesive from the K-LITE range is available in 50g, 250g and 1Kg bottles. Syringes of 30cc, cartridge of 600cc



PRECAUTIONS FOR HANDLING THE PRODUCT

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



NOTE

The information, and particularly the recommendations regarding the application and the 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 method. production costs 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 the people against all kinds of risks that could arise during the handling and use of the products. KEOL cannot assume all the guarantees mentioned or implied, including guarantees of market value. or compliance for a specific reason, arising from sales 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 for the product concerned. Copies of this document will be provided upon request.