

KEOL**UV ADHESIVE****K-LITE 389**

K-LITE range 389 adhesive, has been specially developed for UV bonding of assemblies with shadow zones (not accessible to UV). The dual UV/humidity resin curing mode allows for application in "shadowzone".

The elasticity of the adhesive makes it possible to compensate for differential expansion forces between the assembled parts.

Single-component, it is available in 3 viscosities and is very easy to apply on all types of support.

- SINGLE COMPONENT
- DUAL HARDENING MODE
- UV / HUMIDITY
- HIGH ELASTICITY
- 3 RANGES OF VISCOSITIES

CHEMICAL BASIS

**Urethane
Acrylate**

HARDENING MODE

UV / Humidity

COLOR

Transparent

UV CURING TIME

6 seconds

HARDNESS

80± 5 A

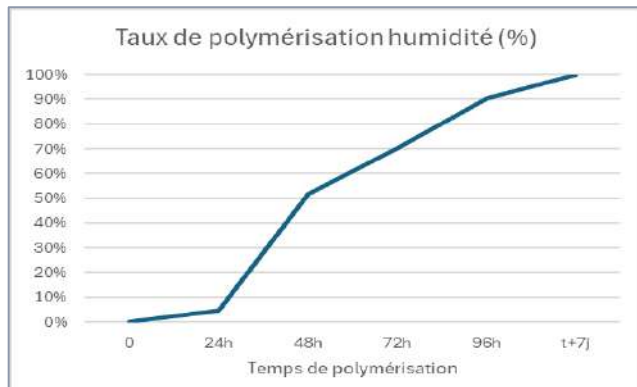
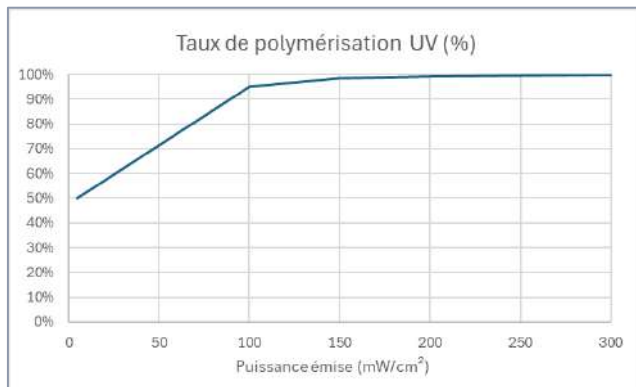
PROPERTIES	K-LITE 389 L	K-LITE 389 M	K-LITE 389 V
Color	Transparent		
Chemical base	Urethane - acrylate		
Viscosity @23°C 3 RPM, mobile S4 Brookfield (mPa.s)	10,000 – 20,000	45,000 – 55,000	95,000 – 105,000
Density @20°C	1.06	1.13	1.15
Composition	100% dry extract		
Absorption wavelength (nm)	365-405		
Polymerization energy (J/cm ² =W/cm ² .s)	Thickness 0.15mm1.8 Thickness 4.00mm 9		
Breaking stress (MPa) - ISO 527-1 300 mW/cm ² , 85 seconds, 405 nm	10Mpa		
Elongation at break (%) 300 mW/cm ² , 85 seconds, 405 nm	250%		
Water absorption % m/m, 24h, 23°C, immersion	0.7	0.7	0.9
Transmittance (%)	93%		
Shore A hardness	80±5 A		
Shelf life in packaging	28 days		
Complete polymerization	7 days		

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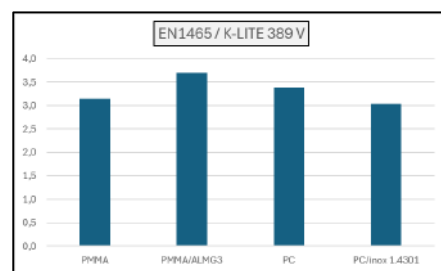
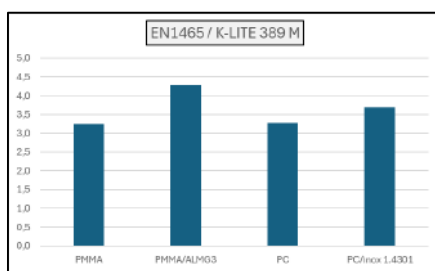
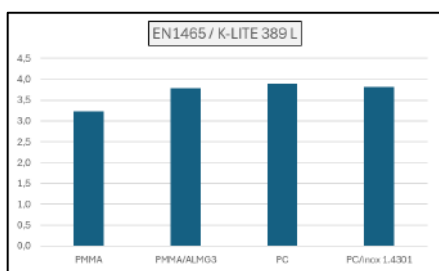
UV ADHESIVE



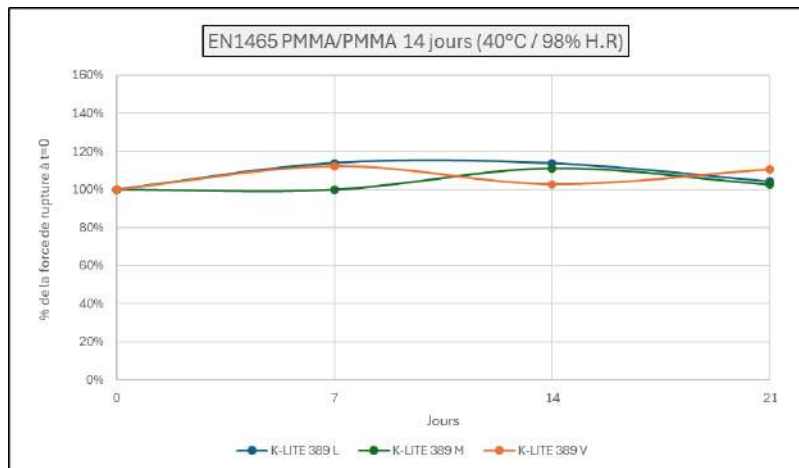
POLYMERIZATION RATE



SHEAR STRENGTH (MPa) - EN 1465405nm; t+7j; 9J/cm²



HUMID HEAT AGING (40°C/98% RH)



LE K DES COLLES !

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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.

Pre-treatment 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 the plastic surfaces. For any other surface, acetone or trichloroethylene can be used for pre-treatment. Never use petroleum or any other solvent. When possible, perform mechanical abrasion to remove paint from the surfaces (if necessary) and to increase the strength and retention of the adhesive. Allow the pre-treated surface to dry before applying the adhesive.



APPLICATION & PACKAGING

K-LITE range 389 adhesive is packaged in 30cc, 600cc syringes, 1L, 3.5L and 20L jar

Storage between 1-5°C. The product must be stored in a dry place and protected from humidity.



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.