

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

277 No Fluorescent Agent (NFA) 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**
- **FAST CURING**
- **FLEXIBLE**
- **HIGH TEMPERATURE RESISTANCE**
- **WITHOUT OPTICAL BRIGHTENER**

CHEMICAL BASIS

Acrylic

CURING TIME

10 s

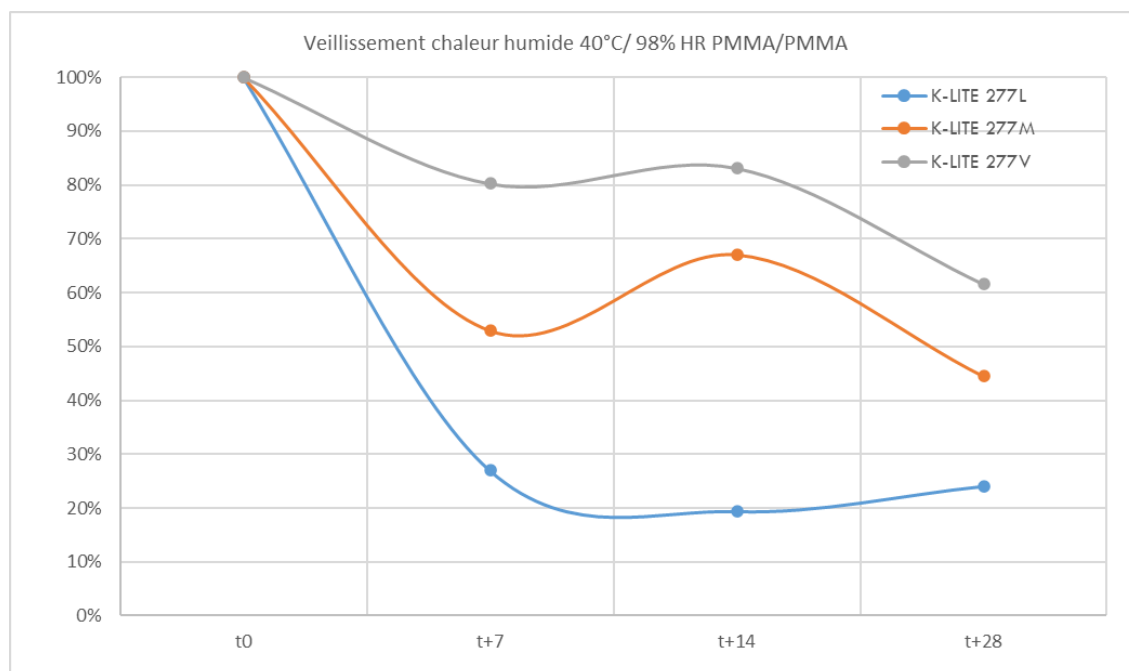
COLOR

Transparent

HARDNESS

50/70 A

PROPERTIES	UNITS	277L NFA	277M NFA	277V NFA
Base chimique	-	Acrylic		
Brookfield viscosity at 23°C	mPa.s	70-150 Liquid	20 000-30 000 Medium	100 000-150 000 Thixotropic paste
Density à 20°C	-	1,01	1,06	1,08
Color	-	Transparent slightly yellow		
Optical brightener	-	No		
Refractive index	-	1,466		
Absorption wavelenght	nm	365-405		
Curing time (0,15mm)	s	10		
Curing intensity (0,15mm)	mW/cm ²	300		
Tensile strenght at break (ISO 527-1)	MPa	3,0	2,7	6,3
Elongation (ISO 527-1)	%	260	380	350
Adhesion (EN 1465)				
PC/PC	MPa	7,7	5,4	3,8
PMMA/PMMA	MPa	5,1	2,7	2,9
GLASS/GLASS	MPa	4,1	2,7	-
PC/STEEL	MPa	6,3	4,7	-
PMMA/ALU 2024	MPa	3,3	4,2	2,5
Hardness shore	-	70 A	50 A	70 A
Temperature range	°C	-50 / +120		



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

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.