

KEOL

UV ADHESIVE

K-LITE 421



K-LITE range 421 adhesive is a methacrylate-based photosensitive structural adhesive specially developed for bonding applications on glass. Its innovative formulation, gives superior adhesion, a high-quality visual finish and excellent moisture resistance.

- SINGLE COMPONENT
- TRANSPARENT
- MOISTURE RESISTANCE
- HIGH TEMPERATURE RESISTANCE

CHEMICAL BASIS

Methacrylate

HARDENING MODE

UV

CURING TIME

10s

COLOR

Transparent

PROPERTIES

421

Chemical base

Methacrylate

Viscosity @23°C

12 RPM, S3 Brookfield mobile (mPa.s)

5,000

Appearance

Liquid

Color

Transparent

Curing energy (J/cm²)

5

Absorption wavelength

365 - 405nm

Breaking force_{(ISO 527-1) (MPa) 405nm,30 seconds}

35

Elongation at break_{(ISO 527-1) (%) 405nm,30 seconds}

15

Shear strength_(MPa)

Lap shear strength – 405nm, 30 seconds

Glass

22

Glass / Inox Steel

12

Shore D hardness

85 +/-5

Transmission rate %

98.8

Water absorption (% m/m)

0.5

Temperature range of use (°C)

-25 to +150°C

Shelf life in packaging

6 months

Complete curing (hour)

24

LE K DES COLLES !

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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. KEOL CLEANER is particularly recommended for cleaning surfaces before bonding.

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 range 421 adhesive is available in 30 and 600cc syringes, 1L, 3.5L pots and 20L drums.



PRODUCT STORAGE

Shelf life of **421 adhesive** is 6 months in its original unopened packaging. The product can be stored in a closed container, in a dry place protected from humidity and excessive heat. Storage 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.