

KEOL**UV ADHESIVE****K-LITE RANGE 278**

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

- **MONO-COMPONENT**
- **RESISTANCE TO TEMPERATURES**
- **UL 94 HB STANDARD**
- **BIOCOMPATIBILITY ISO 10993-5**

CHEMICAL BASIS	Acrylate
REACTION TIME	12 s
COLOR	Transparent
HARDNESS	70D

PROPERTIES	278L	278M	278V	278-80K
Chemical basis	Acrylic – Urethane			
Viscosity @23°C Brookfield)mPas	70-150 Liquid	20,000-30,000 Average	110,000-150,000 Viscous	70,000-90,000 Intermediate
Density at 20°C	1.01	1.06	1.09	1.08
Color	Transparent slightly yellow			
Glass Transition Tg	30°C			
Refractive index	1,466			
Dielectric strength - IEC 60243-1 (kV/mm)	15			
Absorption wavelength	365-405nm			
Polymerization energy (J/cm ² =W/cm ² .s)	Thickness 0.15mm 4 Thickness 4.00 mm 9			
Breaking strength(MPa) (ISO 527-1)	8 (+/- 1.2)	10 (+/- 1.5)	8 (+/- 1.2)	9 (+/- 1.4)
Elongation at break (%)	200	200	170	170
Shear pull(MPa) (EN 1465)				
PC/PC	9	8	9	7
PMMA/PMMA	6	7	4	7
GLASS/GLASS	7	5	5	4
PC/STEEL	6	5	6	6
PMMA/ALU 2024	4	6	6	3
Water absorption % m/m, 24h, 23°C, immersion	1.5	1.2	1.6	1.2
Shore D hardness	70 +/-5			
Temperature range of use	-50°C to +120°C *180°C peak			
Thermal resistance UL94	HB @11mm			

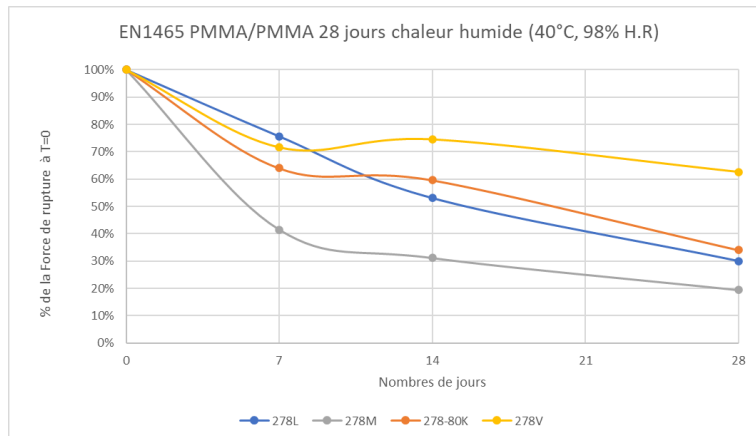
THE BONDING KEY !

UV ADHESIVE

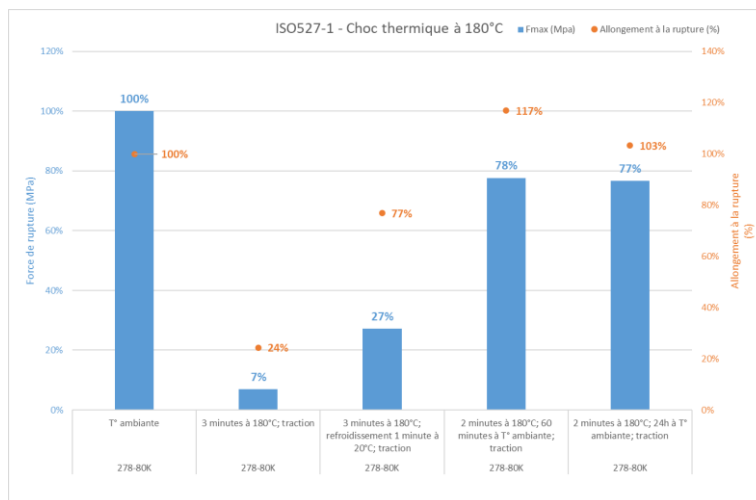


MECHANICAL PERFORMANCE

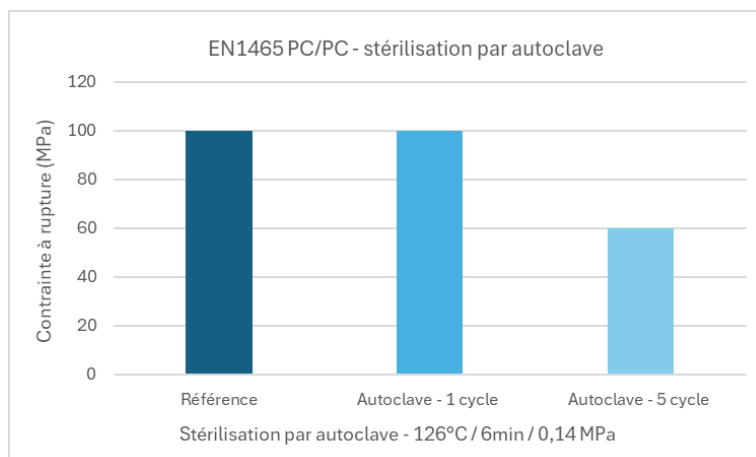
Accelerated aging in humid heat : EN1465



Thermal shock : ISO 527-1



Sterilization by autoclave :



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UV ADHESIVE



BIOCOMPATIBILITY

K-LITE 278-80K adhesive is certified according to standard ISO 10993-5. Technical report on biocompatibility ISO 10993-5 available on request.



PACKAGING

278 adhesive from the K-LITE range is available in 30, 50 and 600cc black syringes, 1L bottle, 20L bucket and 200L drums.



PRODUCT STORAGE

The shelf life of the range **K-LITE RANGE** is 12 months in original unopened packaging. The product can be stored in a closed container, in a dry place at a temperature between 15°C and 30°C. Exposure to higher or lower temperatures will result in a reduction in the stated shelf life, as well as possible losses performance.



PRECAUTIONS FOR HANDLING THE PRODUCT

K-LITE RANGE products are generally safe to handle, provided precautions regarding handling of chemicals are taken. The cartridge product should not be brought into contact with food products or kitchen 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 the 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 greater detail in the safety leaflet for the individual products and you should refer to this document for further information.



SURFACE PREPARATION

The strength and durability of joints depend on adequate pretreatment of the surfaces to be bonded. At a minimum, bonded surfaces should be cleaned with a good degreaser to remove all traces of dust, dirt, oils or grease.

Pretreatment of thermoplastic materials like PVC, polycarbonate, polypropylene, PMMA, etc., can be made using a light 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 trichlorethylene can be used for pretreatment. Never use petroleum or any other solvent.

Where possible, perform mechanical abrasion to remove paint from surfaces (if necessary) and to increase the strength and retention of the adhesive. Allow the pretreated surface to dry before applying the adhesive.



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.