TECHNICAL DATA SHEET

Tacusil UVA0237

2/8/2023

DESCRIPTION:

Tacusil UVA0237 adhesive is hybrid epoxy base dual-cure UV glue with thixotropy, which is designed for the application requiring low shrinkage and CTE. It has good adhesive to PBT, LCP and fiber glass. UV with 365mn wave length light can cure this glue to get good strength and heat secondary cure mechanism is for adhesive in shadow area as same time improving its strength.

Because of special hybrid epoxy in this glue, short wave length UV light as 265~325nm is preferred to make it full cure. This product is Halogen free and full complaint with RoHS directive 2011/65/EU and Reach directive 1907/2006(SVHC: 233 Items)

FEATRURES :

- Low shrinkage
- Heat Secondary cure
- Hight tensile strength and bonding strength to versatile substrate
- No VOCs, easy operation

TYPICAL PROPERTIES:

All properties given are at 25 °C unless otherwise noted.

Property:	*Value:*	*Test Method or Source:*
Color	White	Visual
Cure Schedule		
The minimum UV light intensity **Typical Curing time(365nm)** **Secondary heat cure**	200mw/cm2 60s 80C for 60 mins	Power Puck II Radiometer
Viscosity , 25C /cps		Rheometer parallel plate 25mm@1/s
UVA0237	85000	
Specific Gravity	1.6	ASTM D 1875
Hardness	90D	ASTM D2240
Tensile Properties: **Strength** **Yung's Modules** **Elongation**	 7500 psi 1500Mpa 0.1~0.3%	ASTM D638/MTS
Non volatile content*	100%	N/A
Filler content	20%	
Coefficient of Thermal Expansion	28ppm(-30~150C)	ASTM E831
Linear Shrinkage*	0.3%	ASTM2556

* Asterisk denotes values considered typical to associated resin systems or extrapolated from other test results.

** This TDS contains values that have been updated. The values reported in this technical data sheet are typical values of the product, and are highly dependent on test conditions and methodology.

INSTRUCTIONS:

1 Thawing this adhesive under room temperature for 60~120mins before use.

2 This product cured with exposure to UV and visible light. Dispensing components including needles and fluid lines should be 100% light locking not just UV blocking.

3 For best performance bond surfaces should be clean and free from grease. Good exhaustion is necessary in the curing circumstance.

4 Cure speed is dependent upon many variables including lamp intensity, adhesive thickness and percent light transmission of components.

SHELF LIFE AND STORAGE:

Store product in the unopened container in a dry location.
Optimal Storage: 0 °C to 10 °C.
Shelf life: 9months

Material removed from containers may be contaminated during use. Do not return product to the original container. KPHZ cannot assume responsibility for product which has been contaminated or stored under conditions other than those previously indicated.

NOTES:

This product is intended for industrial use only. Keep it way from children. Personal protection wearing in necessary in using this adhesive including gloves, glass and face mask. In case contact it, remove it with soap and water. Make sure the operator to know clearly its safety information in SDS before use.