



TECHNICAL DATA SHEET Tacusil UVA0243-Gel

7/28/2021

DESCRIPTION:

Tacusil UVA0243-Gel is acrylic base resin paste with thixotropy, general purpose UV glue. It bonds well to engineered plastics, En-plating metal substrates and stainless steel. This product don't contain no-reactive solvent and fast cure upon exposure to UV light.

Because of oxygen inhibition on its surface during curing process, short wave length UV light as 260nm will reduce its surface tacky. This product is Halogen free and full complaint with RoHS directive 2011/65/EU and Reach directive 1907/2006(SVHC: 211 Items)

FEATRURES :

- General purpose
- Hight tensile strength and bonding strength to low surface energy metal substrate
- No VOCs, easy operation

TYPICAL PROPERTIES:

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

Property:	Value:	Test Method or Source:
Color	Translucence	Visual
Cure Schedule		
The minimum UV light intensity(365LED)	200mw/mm2	Power Puck II Radiometer
Typical Curing time(0.5mm thickness)	15s	
Viscosity	130000cps @1/s	Rheometer parallel plate 25mm@1/s
Thixotrophy area	1200 Pa.s	
Specific Gravity	1.05	ASTM D 1875
Hardness	60D	ASTM D2240
Tensile Properties:		ASTM D638/MTS
Strength	2500psi	
Elongation	15%	
Lap shear strength		ASTM D1002
PC/PC	10Mpa(SF)	
PC/SS304	6.8Mpa(PC substrate fail)	
PC/En-plating Fe	7.5Mpa	
Non volatile content*	100	N/A
Coefficient of Thermal Expansion	180ppm	ASTM E831
Linear Shrinkage*	1%	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.

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INSTRUCTIONS:

- 1 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.
- 2 For best performance bond surfaces should be clean and free from grease. Good exhaustion is necessary in the curing circumstance.
- 3 Cure speed is dependent upon many variables including lamp intensity, adhesive thickness and percent light transmission of components.
- 4 Oxygen in the atmosphere may inhibit surface cure. UVC light and high inert gas content in curing ambient will help to eliminate this surface tacky.

SHELF LIFE AND STORAGE:

Store product in the unopened container in a dry location.

Optimal Storage: 10 °C to 32 °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.