TECHNICAL DATASHEET

Vitralit® 6104

Vitralit® 6104 is a UV curable adhesive that features excellent bonding on metal and sintered materials.

Thanks to the option to use thermal combination curing, the product is ideally suited for applications with shaded areas. The thermal curing process completes in the shortest possible time at low temperatures.

Vitralit® 6104 was developed for rotor casting.
Processing recommendations:
The product separates and must be rolled up for at least 2 hours prior to processing (roller bracket or similar device with at least 25 RPM).

Shelf life:
Store in original, unopened containers for 6 months at max. 25°C

Technical Data

Color	translucent
Resin	acrylat
Filler	approx. 10% plastics

UNCURED PROPERTIES

Viscosity (Brookfield LVT/25°C) [mPa*s]	PE-Norm P001	3500 to 6000
Flash point [°C]	PE-Norm P050	> 100
Density [g/cm³]	PE-Norm P051	approx. 1.12

Curing

UV(UV-A 60mW/cm²): [sec.]	PE-Norm P002	30
Thermical Curing 120°C :[Min]	PE-Norm P035	15
Full Strength [hours]	PE-Norm P032	nach 12
Depth of Cure [mm]	PE-Norm P033	3

CURED PROPERTIES

Temperature Resistance [°C]	PE-Norm P030	-40 to 200
Hardness Shore D	PE-Norm P052	50 to 65
Water Absorption [Gew-%]	PE-Norm P053	< 1.3
TG DSC [°C]	PE-Norm P009	65 to 90
Dielectric Constant [10kHz]	PE-Norm P054	5.2
Thermal conductivity [W/mK]	ASTM 1530	0,4
Dielectric Strength [kV/mm]	PE-Norm P055	18.7

Adhesives and more...

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Instructions for Use

Surface Preparation

The surfaces to be adhered should be free of dust, oil, fat or any other dirt in order to optimise reproducible bonds. Lightly soiled surfaces can be cleaned with cleaner IP, whereas substrates with low surface energy (such as polyethylene, polypropylene or Teflon) need to be treated physically using plasma or corona to create a suitable working surface. For glass bonding applications we have developed a special primer pen which can be easy applied to prepare the surface for best results.

Application

Our products are delivered ready for use. As soon as you receive them, you can dispense them, be it by hand from the container, or semi/fully automatically. When applied automatically, we recommend the use of air pressure with the appropriate cartridge/piston combination to dispense the adhesive at the required speed and accuracy. If help is required, please consult our engineering department

Please read the corresponding **Safety Data Sheet** for this product.

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