

Product Description

Panacol Vitralit® adhesives are one-component, solvent-free radiation-curing adhesives. The advantages are very short curing time, good adhesion to a variety of substrates, and easy handling. Vitralit® products are used in electronics, medical applications, optics and for fixing parts in general.

Vitralit® 1655 is a UV-A curing, low viscosity, flexible and transparent adhesive. Vitralit® 1655 was designed for bonding and coating of many substrates. Vitralit® 1655 provides excellent adhesion to a wide range of materials including plastics. Shadowed areas can be cured by exposure of heat. Vitralit® 1655 has met the requirements for USP Class VI and ISO 10993-5 and is suitable for use in the assembly of disposable medical devices. It is compatible with different kinds of sterilization processes.

Suitability on various substrates

PMMA	o	PP	*	glass	o	PUR	o
PC	o	ABS	✓	steel	o	PS	✓
PET-A	o	SAN	✓	Al	o	V2A	o
PET-G	o	PVC	✓				

✓ excellent o suitable * pretreatment necessary/recommended

Curing Properties

UV-A	VIS	Thermal curing	Activator curing
✓	-	✓	-

✓ suitable - not suitable

The product cures within seconds with radiation in the UV-A - range (320 nm - 390 nm). For rapid and high quality crosslinking we recommend the UV devices manufactured by Dr. Hoenle AG, which complement our adhesive technology.

Bluepoint LED/LED-spot		
Wavelength [nm]	365	405
Suitability	++	-

+ application-related ++ well-suited +++ ideal - not suitable

To obtain full cure at least one substrate must be transparent to the recommended wavelength. The curing speed will depend on the intensity of light, light source, the exposure time, and the light transmittance of the substrate. Increased mechanical properties are achieved after 24 hours.

UV-curing		
Intensity [mW/cm ²]	Layer thickness [mm]	Time [sec]
60	0,5	30

Thermal curing	[min]
Time at 105°C	30

Technical Data

Resin	epoxy
Appearance	transparent

Uncured material

Viscosity [mPas] (Brookfield LVT, 25°C, sp 2/30 rpm) <i>PE-Norm 001</i>	150 - 300
Density [g/cm ³] <i>PE-Norm 004</i>	1,1
Flash point [°C] <i>PE-Norm 050</i>	>100
Refractive index [nD20] <i>PE-Norm 018</i>	1,487

Cured material

Hardness shore A <i>PE-Norm 006</i>	70 - 80
Temperature resistance [°C] <i>PE-Norm 065</i>	-50 - 150
Shrinkage [%] <i>PE-Norm 031</i>	2,0
Water absorption [mass %] <i>PE-Norm 016</i>	0,7

Glass transition temperature DSC [°C] <i>PE-Norm 009</i>	30 - 40
Coefficient of linear expansion [ppm/K] below Tg <i>PE-Norm 017</i>	94,0
Coefficient of linear expansion [ppm/K] above Tg <i>PE-Norm 017</i>	214,0

Volume resistance [Ohm] <i>GB/T 1410-2006</i>	2,75*E9
Surface resistance [Ohm] <i>GB/T 1410-2006</i>	5,75*E9

Young's modulus [MPa] <i>PE-Norm 056</i>	44
Tensile strength [MPa] <i>PE-Norm 014</i>	16,0
Elongation at break [%] <i>PE-Norm 014</i>	14,0
Lap shear strength (PET/PET) [MPa] <i>PE-Norm 013</i>	1,3

Transport/Storage/Shelf Life

Trading unit	Transport	Storage	Shelf-life*
Cartridge	0°C - 10°C	0°C - 10°C	At delivery min. 6 months, max. 12 months
Other packages			

***Store in original, unopened containers!**

Instructions for Use

Surface preparation

The surfaces to be bonded should be free of dust, oil, grease or other dirt in order to obtain an optimal and reproducible bond.

For cleaning we recommend the cleaner IP® Panacol. Substrates with low surface energy (e.g. polyethylene, polypropylene) must be pretreated in order to achieve sufficient adhesion.

Application

Our products are supplied ready to use. Depending on packaging they can be applied by hand directly from the container or semi or fully automatically. With automated application from the cartridge the adhesive is conveyed by a compressed air-operated displacement plunger via a valve in the needle. When metering low viscosity materials from bottles the adhesive is transported by a diaphragm valve. If help is required, please contact our application engineering department.

Adhesive and substrate may not be cold and must be warmed up to room temperature prior to processing.

After application, bonding of the parts should be done quickly. Vitralit® adhesives cure slowly in daylight. Therefore, we recommend to expose the material to as little light as possible and the use of opaque hose lines and dispensing needles.

For safety information refer to our safety data sheet.

Technical Datasheet

Vitralit® 1655



Note

The product is free of heavy metals, PFOS and Phthalates and is conform to the EU-Directive 2011/65/EU "RoHS II" .

Our data sheets have been compiled to the best of our knowledge. The enclosed information describes characteristic properties, with no declaration of commitment. We recommend trials in order to confirm that our products satisfy the particular application requirements. For any additional technical support, please contact our application engineering department. For warranty claims, please refer to our standard terms and conditions.

Appendix

Environmental Resistance

The table below shows the tensile shear strength of PET/PET bonding expressed as % from initial strength.

% of initial strength	
24h isopropanol	7 days water, 21 °C
100	100

Sterilization

Vitralit[®] 1655 shows good bond strength retention after sterilization. Generally the resistance depends on the substrate material, the curing parameters and the process of sterilization. It remains the user's obligation to determine the effect of sterilization on the specific application and its requirements.