

# Technical Datasheet

## Vitralit<sup>®</sup> 4735 HC



### Product Description

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

Vitralit<sup>®</sup> 4735 HC is a UV/visible light curable material that bonds to a variety of substrates including metal, ceramic, glass and many plastics. Additionally it has a thermal initiator to cure the product with thermal heat in shadowed areas. The cured product is optically clear and resistant to yellowing. Vitralit<sup>®</sup> 4735 HC will cure to a tack free surface. After curing Vitralit<sup>®</sup> 4735 HC has a certain flexibility which allows tension and shock uptake. Vitralit<sup>®</sup> 4735 HC is able to resist reflow process.

### Curing Properties

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

✓ suitable      - not suitable

The product cures within seconds with radiation in the UV-A - (320 nm - 390 nm) and visible range (405 nm). For rapid and high quality crosslinking we recommend the UV devices manufactured by Dr. Hoenle AG, which complement our adhesive technology.

UV-curing (Hoenle Discharge lamp, 320-450nm)		
Intensity [mW/cm <sup>2</sup> ]	Layer thickness [mm]	Time [sec]
60	0,05	2

VIS-curing (Hoenle LED Spot 100, 405nm)		
Intensity [mW/cm <sup>2</sup> ]	Layer thickness [mm]	Time [sec]
100	0,05	10

Thermal curing	[min]
Time at 105°C	30

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 12 hours.

### Technical Data

Resin	acrylate
Appearance	transparent

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### Uncured material

Viscosity [mPas] (Brookfield LVT, 25°C, Sp 3, 30rpm) <i>PE-Norm 001</i>	700 - 1 000
Density [g/cm³] <i>PE-Norm 004</i>	1,15
Flash point [°C] <i>PE-Norm 050</i>	>93
Refractive index [nD20] <i>PE-Norm 018</i>	1,474

### Cured material

Hardness shore D <i>PE-Norm 006</i>	20 - 40
Temperature resistance [°C]	-40 - 120
Shrinkage [%] <i>PE-Norm 031</i>	<3
Water absorption [mass %] <i>PE-Norm 016</i>	<1

Glass transition temperature DSC [°C] <i>PE-Norm 009</i>	30 - 40
Coefficient of thermal expansion [ppm/K] below Tg <i>PE-Norm 017</i>	13

Young's modulus E [MPa] <i>PE-Norm 056</i>	10
Tensile strength [MPa] <i>PE-Norm 014</i>	1
Elongation at break [%] <i>PE-Norm 014</i>	275
Lap shear strength (glass/PC) [MPa] <i>PE-Norm 013</i>	4
Lap shear strength (Al/PC) [MPa] <i>PE-Norm 013</i>	3
Lap shear strength (Al/glass) [MPa] <i>PE-Norm 013</i>	3

### Transport/Storage/Shelf Life

Trading unit	Transport	Storage	Shelf-life*
Cartridge	at room temperature max. 25°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<sup>®</sup> 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<sup>®</sup> 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.

### Disclaimer

The product is free of heavy metals, PFOS and Phthalates and is conform to the EU-Directive 2017/2102/EU "RoHS III".

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### **Contact**

**Panacol-Elosol GmbH**  
Daimlerstr. 8  
61449 Steinbach  
Germany  
Phone.: +49 6171 6202-0  
Mail: [info@panacol.de](mailto:info@panacol.de)  
[www.panacol.com](http://www.panacol.com)

**Panacol-USA, Inc.**  
142 Industrial Lane  
Torrington CT 06790  
USA  
Phone: +1 860-738-7449  
Mail: [info@panacol-usa.com](mailto:info@panacol-usa.com)  
[www.panacol-usa.com](http://www.panacol-usa.com)

**Panacol-Korea Co., Ltd.**  
#707, Kranz Techno, 388 Dunchon-daero  
Junwon-gu, Seongnam  
Gyeonggi-do, 13403 KOREA  
Phone: +82 31 749 1701  
Mail: [info@panacol-korea.com](mailto:info@panacol-korea.com)  
[www.panacol-korea.com](http://www.panacol-korea.com)

**Eleco Panacol – EFD**  
125, av Louis Roche  
Z.A. des Basses Noëls  
92238 Gennevilliers Cdx FRANCE  
Tél.: +33 (0)1 47 92 41 80  
Mail: [eleco@eleco-panacol.fr](mailto:eleco@eleco-panacol.fr)  
[www.eleco-panacol.fr](http://www.eleco-panacol.fr)