

# Technical Datasheet

## Vitralit® 6108 T



### Product Description

Panacol Vitralit® 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® products are used in electronics, medical applications, optics and for fixing parts in general.

Vitralit® 6108 T is a UV/Visible light curable adhesive that bonds to glass, aluminum, ceramic, stainless steel, and some rigid plastics including polycarbonate. Vitralit® 6108 T exceptional clarity and resistance to yellowing makes it an effective adhesive for bonding cannula into glass syringes. When properly cured, Vitralit® 6108 T is clear, hard, extremely moisture resistant. Vitralit® 6108 T cures very rapidly with broad spectrum UV and visible light, 320-450 nm. High intensity is not required. Vitralit® 6108 T is also well suited for monochromatic LED arrays with output of 365nm or 405nm. Vitralit® 6108 T also contains a latent catalyst to permit thermal curing if shadowed areas prohibit curing with light. Vitralit® 6108 T has passed the testing to meet USP Class VI biocompatibility requirements.

### Curing Properties

UV-A	VIS	Secondary heat cure	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. Heat may only be used as a secondary cure for shadowed areas after the product has been cured with UV.

UV-curing (Hoenle Discharge Lamp, 320-450nm)		
Intensity [mW/cm <sup>2</sup> ]	Layer thickness [mm]	Time [sec]
70	1	5

VIS-curing (Hoenle LED Spot 100, 405nm)		
Intensity [mW/cm <sup>2</sup> ]	Layer thickness [mm]	Time [sec]
1000	2	2

Secondary heat cure	[min]
Time at 150°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  
Appearance

acrylate  
transparent

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### Uncured material

Viscosity [mPas] (Brookfield RVT, 25°C, Sp 5, 30rpm) <i>PE-Norm 001</i>	4 000 - 6 000
Viscosity [mPas] (Kinexus Rheometer, 25°C, 1s <sup>-1</sup> ) <i>PE-Norm 064</i>	10 000 - 40 000
Viscosity [mPas] (Kinexus Rheometer, 25°C, 10s <sup>-1</sup> ) <i>PE-Norm 064</i>	3 000 - 6 000
Density [g/cm <sup>3</sup> ] <i>PE-Norm 004</i>	1,1
Flash point [°C] <i>PE-Norm 050</i>	>93
Refractive index [nD20] <i>PE-Norm 018</i>	1,47

### Cured material

Hardness shore D <i>PE-Norm 006</i>	70 - 85
Temperature resistance [°C]	-40 - 150
Shrinkage [%] <i>PE-Norm 031</i>	<2

Glass transition temperature DSC [°C] <i>PE-Norm 009</i>	40 - 70
Coefficient of thermal expansion [ppm/K] below Tg <i>PE-Norm 017</i>	95
Coefficient of thermal expansion [ppm/K] above Tg <i>PE-Norm 017</i>	224

Young's modulus E [MPa] <i>PE-Norm 056</i>	800 - 1 000
Tensile strength [MPa] <i>PE-Norm 014</i>	20 - 40
Elongation at break [%] <i>PE-Norm 014</i>	8 - 13
Lap shear strength (glass/stainless steel) [MPa] <i>PE-Norm 013</i>	11
Lap shear strength (glass/Al) [MPa] <i>PE-Norm 013</i>	14
Lap shear strength (glass/steel) [MPa] <i>PE-Norm 013</i>	13

### 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® 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 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".

**THE VALUES NOTED IN THIS TECHNICAL DATA SHEET ARE TYPICAL PROPERTIES AND ARE NOT MEANT TO BE USED AS PRODUCT SPECIFICATIONS.**

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