



**U3320**

U3320 is a low-viscosity UV-curable with excellent bonding characteristics on various plastics, especially PET/ PETG and polycarbonate. U3320's thin viscosity makes it ideal for use in wicking applications, especially on components with close-fitting tolerances.

<b>Technology / Base</b>	Modified Acrylate
<b>Type of Product</b>	Structural Adhesive
<b>Components</b>	One Component
<b>Curing</b>	Ultra Violet Light
<b>Appearance / Color</b>	Light Straw
<b>Consistency</b>	Liquid

**Technical Data**

Rheology	Value	Condition/Method
Viscosity	45 +/- 15 cps	20°C to 25°C (68°F to 77°F)
<b>Density</b>		
Specific Gravity	1.06	
<b>Curing Process Characteristics</b>		
Flash Point	> 95°C	
Set Time and Wavelength	< 3 sec at 395nm, 50mW/cm2	
Full Cure Time	24 hours	
Shelf Life	9 months	
Storage Condition	8°C to 21°C in darkness	
Optimum Wavelength	300 to 420 nm	
<b>Cured Material Characteristics</b>		
Cured Appearance	Colorless Solid	
Tack Free	Yes	
RoHS Compliant	Yes	
<b>Cured Mechanical Properties</b>		
Hardness	Shore A Shore D	ASTM D2240 ASTM D2240
Elongation to Break	63 54 150%	ASTM D638

**General Instructions**

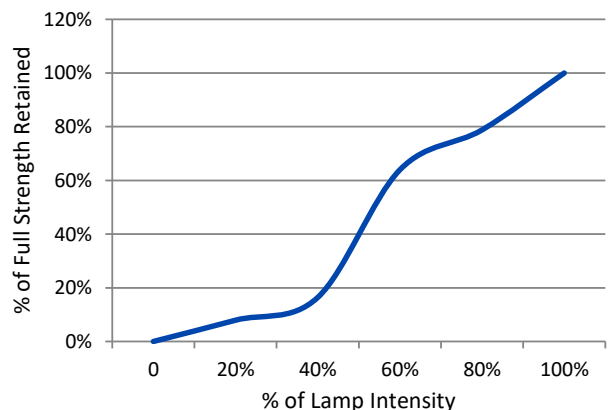
Surfaces to be bonded should be clean and dry. Dispense a drop or drops to one surface only. Apply only enough to leave a thin film layer after compression. Press parts together and expose to UV dose when ready. An adequate bond should develop rapidly, depending on UV dose efficacy, and maximum strength is attained in 24 hours. Wipe off excess adhesive from the top of the container and recap. products, if left uncapped or exposed to sunlight, may deteriorate or cure prematurely.

**Curing Performance**

Photoinitiation initiates the curing process. Handling strength is reached in a short time, and will vary based on UV dose efficacy, environmental conditions, bond line gap, and other factors. Product will continue to cure for at least 24 hours before full strength and solvent resistance is developed.

**Specifications and Approvals**

**Percent Strength Retained at Given Dosage**



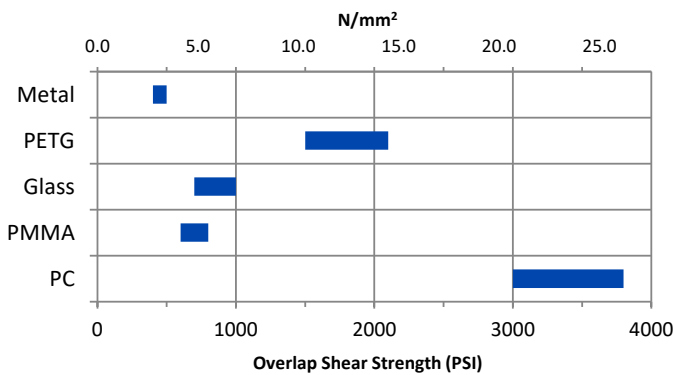


**Performance of Cured Adhesive**

Substrate	N/mm <sup>2</sup>		PSI	
	Min	Max	Min	Max
Metal	2.8	3.4	400	500
PETG	10.3	14.5	1500	2100
Glass	4.8	6.9	700	1000
PMMA	4.1	5.5	600	800
PC	20.7	26.2	3000	3800

\* n/r = not recorded on this substrate

**Performance Range, by Substrate**



**Solvent Resistance**

Solvent	Example	Resistance
Alcohol	Ethanol, Methanol	+++
Ester (aromatic)	Ethylacetate	---
Ketone (aromatic)	Acetone, Benzophenone	---
Aliphatic hydrocarbon (alkanes)	Petrol, Heptanes, Hexane	++-
Aromatic hydrocarbons	Benzyl, Toluol, Xylol	++-
Halogenated hydrocarbons	Methylenchloride, Chloroform, Chlorobenzol	---
Weak aqueous acid	Nitrite, muriatic acid, sulphuric acid, phosphoric acid	+++ (--- if concentrated)
Weak aqueous base	sodium hydroxide solution, caustic potash	+++ (--- if concentrated)

**Safety and Disposal**

For safe handling information and disposal information on this product, consult the Safety Data Sheet (SDS)

H.B. Fuller Company  
 9001 W. Fey Drive  
 Frankfort, IL 60423  
 +1.630.761.8900

**Storage**

Products should be stored unopened in a cool, dry place out of direct sunlight. Products should be kept at room temperature away from direct light. Protect from extreme heat or cold, do not refrigerate.

Date Modified: 23 October 2017

[www.hbfuller.com](http://www.hbfuller.com)

[www.hbfullerengineering.com](http://www.hbfullerengineering.com)

Connecting what matters.™

IMPORTANT: Information, specifications, procedures and recommendations provided ("information") are based on our experience, and we believe this information to be accurate. No representation, guarantee or warranty is made as to the accuracy or completeness of the information or that use of the product will avoid losses or damages or give desired results. It is purchaser's sole responsibility to test and determine the suitability of any product for the intended use. Tests should be repeated if materials or conditions change in any way. No employee, distributor or agent has any right to change these facts and offer a guarantee of performance.

© and ™ are trademarks of H.B. Fuller Company or one of its affiliated entities.



**NOTE TO USER:** by ordering/receiving product you accept the H.B. Fuller General Terms and Conditions of Sale applicable in the region. Please request a copy if you have not received these. These Terms and Conditions contain disclaimers of implied warranties (including but not limited to disclaiming warranties of fitness for a particular purpose) and limits of liability. All other terms are rejected. In any event, the total aggregate liability of H.B. Fuller for any claim or series of related claims however arising, in contract, tort (including negligence), breach of statutory duty, misrepresentation, strict liability or otherwise, is limited to replacement of affected products or refund of the purchase price for affected products. H.B. Fuller shall not be liable for loss of profit, loss of margin, loss of contract, loss of business, loss of goodwill or any indirect or consequential losses arising out of or in connection with product supply.

H.B. Fuller  
[www.hbfuller.com](http://www.hbfuller.com)