



U3345

U3345 is a versatile, medium-to-high viscosity UV-curable adhesive that bonds extremely well on a wide variety of substrates. It is suitable for use in a broad spectrum of UV-cure applications, where it provides a tough, flexible bond on plastic, glass and metal.

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

Technical Data

Rheology	Value	Condition/Method
Viscosity	2000 +/- 500	Brookfield, RV3, 20°C to 25°C (68°F to 77°F)
Density		
Specific Gravity	1.06	
Curing Process Characteristics		
Flash Point	> 95°C	
Set Time and Wavelength	< 6 sec at 395nm, 50mW/cm ²	
Full Cure Time	24 hours	
Shelf Life	9 months	
Storage Condition	8°C to 21°C in darkness	
Optimum Wavelength	300 to 420 nm	
Cured Material Characteristics		
Cured Appearance	Colorless solid	
Tack Free	No	
RoHS Compliant	Yes	
Cured Mechanical Properties		
Hardness	Shore A	70
	Shore D	32
Elongation to Break		275%
		ASTM D2240 ASTM D2240 ASTM D638

General Instructions

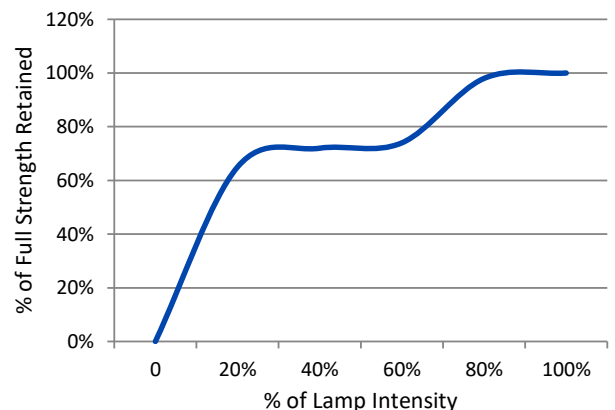
Surfaces to be bonded should be clean and dry. Dispense a drop or drops to one surface only. Apply only enough to leave a thin film layer after compression. Press parts together and expose to UV dose when ready. An adequate bond should develop rapidly, depending on UV dose efficacy, and maximum strength 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



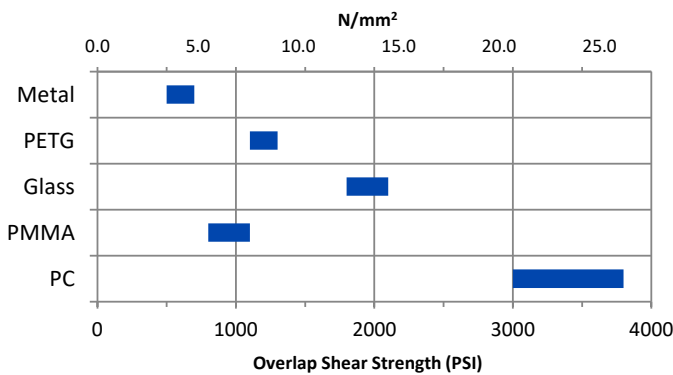


Performance of Cured Adhesive

Substrate	N/mm ²			PSI		
	Min	to	Max	Min	to	Max
Metal	3.4	to	4.8	500	to	700
PETG	7.6	to	9.0	1100	to	1300
Glass	12.4	to	14.5	1800	to	2100
PMMA	5.5	to	7.6	800	to	1100
PC	20.7	to	26.2	3000	to	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)

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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

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