



U3334

U3334 is a high-viscosity UV-curable adhesive designed to bond well on a variety of substrates. It shows particular effectiveness on polycarbonate, glass and PET/PETG. Its high elongation and flexibility make it well-suited for applications requiring vibration or impact resistance.

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	6000+/- 2000 cps	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	< 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	
Cured Material Characteristics		
Cured Appearance	Colorless solid	
Tack Free	Yes	
RoHS Compliant	Yes	
Cured Mechanical Properties		
Hardness	Shore A Shore D	ASTM D2240 ASTM D2240
Elongation to Break	70 32	ASTM D638
	400%	

General Instructions

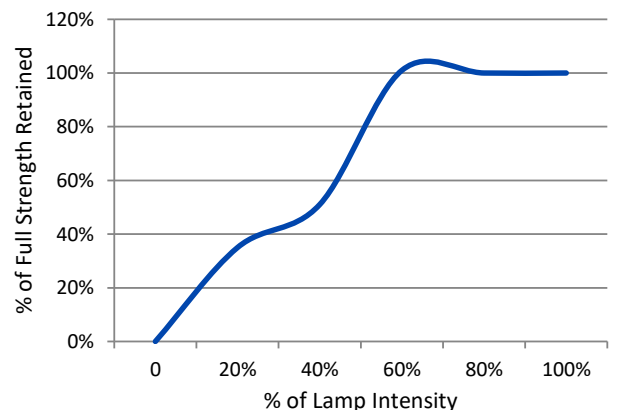
Surfaces to be bonded should be clean and dry. Dispense a drop or drops to one surface only. Apply only enough to leave a thin film layer after compression. Press parts together and expose to UV dose when ready. An adequate bond should develop rapidly, depending on UV dose efficacy, and maximum strength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



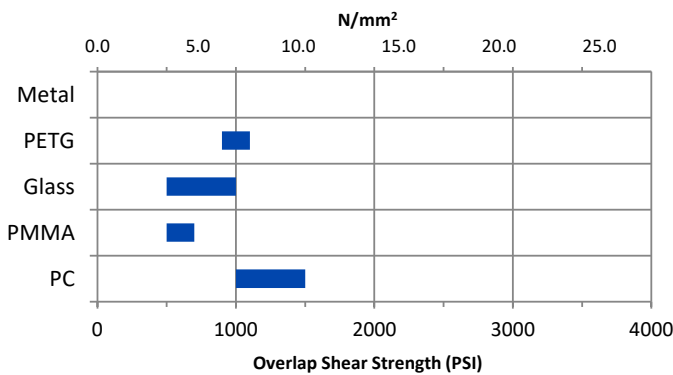


Performance of Cured Adhesive

Substrate	N/mm ²			PSI		
	n/r	to	n/r	n/r	to	n/r
Metal	n/r		n/r	n/r		n/r
PETG	6.2	to	7.6	900	to	1100
Glass	3.4	to	6.9	500	to	1000
PMMA	3.4	to	4.8	500	to	700
PC	6.9	to	10.3	1000	to	1500

* 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.

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