



UK DISTRIBUTORS OF  
**REINHARDT-TECHNIK**  
 Metering & Mixing  
 Dispensing Systems



Bonham Drive, Eurolink Industrial Estate  
 Sittingbourne, Kent. ME10 3RY  
 Tel 01795 427888 Fax 01795 479685  
 Email [sales@eurobond-adhesives.co.uk](mailto:sales@eurobond-adhesives.co.uk)  
 Web [www.eurobond-adhesives.co.uk](http://www.eurobond-adhesives.co.uk)

**Vitralit® 6128 – Technical data sheet**

Vitralit® 6128 is a UV curing adhesive, known for its variety of application possibilities. Vitralit® 6128 is used for bonding glass in connection with metals, stone and other solid materials. It can also be used as a filler with excellent bonding qualities on many thermoplastic artificial materials.

Vitralit® 6128 next to the pure uv-curing can also be used for curing in shadowed zones, when combined with heat or an activator. It is known for its excellent temperature consistency. Vitralit® 6128 can be delivered in various viscosity settings and also coloured.

**Shelf life:** Store in original, unopened containers for 6 months at max. 25°C

**Technical Data**

Colour: translucent  
 Resin acrylate: Acrylate

**Uncured properties**

Viscosity (Brookfield LVT/25°C) [mPa·s]	PE-Norm P001	800 to 1200
Flash Point [°C]	PE-Norm P050	> 95
Density [g/cm³]	PE-Norm P003	approx. 1.12
Refractive Index [nD20]	PE-Norm P018	1.473

**Curing**

UV(UV-A 60mW/cm² Thickn.st.1mm): [Sec]	PE-Norm P002	15
Thermal curing 120°C [Min]	PE-Norm P035	40
Chemical with Activator [Min]	PE-Norm P036	25
Full Strength [hours]	PE-Norm P032	after 12
Depth of Cure [mm]	PE-Norm P033	3

**Cured Properties**

Temperature Resistance [°C]	PE-Norm P030	-40 to 150
Hardness [Shore D]	PE-Norm P052	70 to 80
Shrinkage [%]	PE-Norm P031	3.3
Water Absorption [mass-%]	PE-Norm P053	< 2.8
Tg [°C] (DSC)	PE-Norm P009	40 to 60
CTE [ppm/K]	PE-Norm P017	62
Dielectric Constant [10kHz]	PE-Norm P054	6.2
Thermal conductivity [W/m·K]	ASTM 1530	0.22
Dielectric Strength [kV/mm]	PE-Norm P055	18.7

## **Mechanical data**

Compression Shear Strength (Glass/Glass) [MPa]	PE-Norm P061	approx. 12
Compression Shear Strength (Glass/Stainless Steel) [MPa]	PE-Norm P061	approx. 18
Compression Shear Strength (Glass/Alu) [MPa]	PE-Norm P061	approx. 8
Lap Shear Strength (Glass/Alu) [MPa]	PE-Norm P013	>15
Lap Shear Strength (Glas/Steel) [MPa]	PE-Norm P013	>14
Elongation at Break [%]	PE-Norm P060	approx. 8
E-Modul [MPa]	PE-Norm P056	1000

## **Instructions for Use**

### Surface Preparation

The surfaces to be adhered should be free of dust, oil, fat or any other dirt in order to optimise reproducible bonds. Lightly soiled surfaces can be cleaned with cleaner IPA, whereas substrates with low surface energy (such as polyethylene, polypropylene or Teflon) need to be treated physically using plasma or corona to create a suitable working surface.

### Application

Our products are delivered ready for use. As soon as you receive them, you can dispense them, be it by hand from the container, or semi/fully automatically. When applied automatically, we recommend the use of air pressure with the appropriate cartridge/piston combination to dispense the adhesive at the required speed and accuracy.

Please read the corresponding **Safety Data Sheet** for this product.

10.06.15

No liability is accepted for any injury, loss or damage arising directly or indirectly from the use of the Company's products or from the use of information given in our publications, which is intended to serve as a guide only. Customers should satisfy themselves by appropriate trials that the products are suitable for their intended use.