



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



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**Vitralit 6104 - Technical data sheet**

Vitralit® 6104 is an UV curing adhesive that provides excellent bonding on metal and sintered materials. Thanks to the option to use additional thermal curing, the product is ideally suited for applications with shadowed areas. The product can be cured in a secondary process at low temperatures in short times.

Vitralit® 6104 was developed for rotor casting. It can be cured with LED 365 nm.

Processing recommendations:

The product separates and must be rolled up for at least 2 hours prior to processing (roller bracket or similar device with at least 25 RPM).

**Shelf life** □

Store in original, unopened containers for 6 months at 5°C

**Technical Data**

Colour:	Translucent
Resin:	Acrylate
Filler:	approx. 10% plastics

**UNCURED PROPERTIES**

Viscosity (Brookfield LVT/25°C) [mPa·s]	PE-Norm P001	3500 to 6000
Flash point [°C]	PE-Norm P050	> 100
Density [g/cm³]	PE-Norm P003	approx. 1.12

**Curing**

UV(UV-A 60mW/cm²): [sec.]	PE-Norm P002	30
Thermal Curing 120°C :[Min]	PE-Norm P035	15
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 200
Hardness [Shore D]	PE-Norm P052	50 to 65
Water Absorption [mass-%]	PE-Norm P053	< 1.3
Tg [°C] (DSC)	PE-Norm P009	65 to 90
CTE [ppm/K]	PE-Norm P017	71
Dielectric Constant [10kHz]	PE-Norm P054	5.2
Thermal conductivity [W/m·K]	ASTM 1530	0.4
Dielectric Strength [kV/mm]	PE-Norm P055	18.7

## **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.

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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.

