



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



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## **Vitralit® 7641LV – Technical data sheet**

Vitralit®7641 is a low viscosity UV and visible light curing acrylate adhesive. It is specially designed for bonding PMMA and other plastics and ideal for applications where wicking into pre-assembled parts is required. The cured adhesive is hard and provides strong bonding to many plastics.

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

### **Technical Data**

Colour	Transparent
Resin	Urethane Acrylate

### **Uncured properties**

Viscosity (Brookfield LVT/25°C) [mPa·s]	PE-Norm P001	50 to 100
Flash point [°C]	PE-Norm P050	> 93
Density [g/cm <sup>3</sup> ]	PE-Norm P003	approx. 1.1
Refractive Index [nD20]	PE-Norm P018	1.483

### **Curing**

UV(UV-A 40mW/cm <sup>2</sup> in 0.02mm) [Sec]	PE-Norm P002	8
Visible Light (UV-LED) [Sec]	PE-Norm P037	10
Full Strength [hours]	PE-Norm P032	12
Depth of Cure [mm]	PE-Norm P033	3

### **Cured properties**

Temperature Resistance [°C]	PE-Norm P030	-30 to 120
Hardness [Shore D]	PE-Norm P052	75 to 85
Shrinkage [%]	PE-Norm P031	3.7
Water Absorption [mass-%]	PE-Norm P053	< 9
Tg [°C] (DSC)	PE-Norm P009	45 to 55

## Mechanical Data

Compression Shear (PC/PC) [MPa]	PE-Norm P061	approx. 9.3
Compression Shear Strength (PC/PMMA) [MPa]	PE-Norm P061	approx. 6.1
Compression Shear Strength (PMMA/PMMA) [MPa]	PE-Norm P061	approx. 4.4
Lap Shear Strength (PMMA/PMMA) [MPa]	PE-Norm P013	approx. *3.9
Elongation at Break [%]	PE-Norm P060	approx. 75

## 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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