

# Permabond 4UV80HV

## PRELIMINARY TECHNICAL DATA SHEET

Permabond 4UV80HV is a UV curable adhesive suitable for a wide range of applications that required fast cure and good adhesion to most plastics used in the medical device industry. Permabond 4UV80HV is a very fast curing adhesive achieving full cure in a few seconds when exposed to light of the proper wavelength and intensity. The fast cure speed of this product makes it an ideal choice for high-speed production lines. It is fluorescent under black light facilitating the inspection for adhesive on the part.

PHYSICAL PROPERTIES LIQUID ADHESIVE		PHYSICAL PROPERTIES CURED ADHESIVE	
Base Compound	Methacrylate Ester	Appearance	Clear, colorless
Appearance	Translucent	Hardness, Shore D	70
Viscosity @25°C	2300 cP (mPa.s)	Dielectric Strength	12 KV/mm
Specific Gravity	1.1	Service Temperature	-55 to +120°C (-67 to 240°F)
Flash Point	100°C (181°F)	Cytotoxicity	4UV80 formula modified with a bio-inert filler
Shelf Life @5-25°C	12 months		

### ADDITIONAL INFORMATION

This product is not recommended for use in contact with strong oxidizing materials. Information regarding the safe handling of this material may be obtained from the material safety data sheet (MSDS).

### DIRECTIONS FOR USE:

This product is light sensitive; care should be taken to make sure the liquid material is not exposed to ambient light (day light, UV light and artificial light). The surfaces should be clean and dry. Cure rate is dependent on the power of the UV lamp; its spectral output, the distance between the lamp and the substrates, the depth of cure and light transmittance of the substrates used. Plastic grades should be checked for risk of stress cracking when exposed to the liquid adhesive.

No representative of ours has any authority to waive or change the foregoing provisions but, subject to such provisions, our engineers are available to assist purchasers in adapting our products to their needs and to the circumstances prevailing in their business. Nothing contained herein shall be construed to imply the non-existence of any relevant patents or to constitute a permission, inducement or recommendation to practice any invention covered by any patent, without authority from the owner of this patent. We also expect purchasers to use our products in accordance with the guiding principles of the Chemical Manufacturers Association's Responsible Care<sup>®</sup> program.

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**STORAGE & HANDLING:**

Permabond UV631 should be stored in a cool, dry place in the unopened container at a temperature between 5°C and 25°C (41°F and 77°F). Under these conditions the product has a shelf life of 12 months. Protect the adhesive from light, especially UV light.

Please refer to the MSDS for more information on the handling of this material.

**FOR INDUSTRIAL USE ONLY. KEEP OUT OF REACH OF CHILDREN**