

## Tru Bond 18200 Series Plastic Bonding Adhesives

### ORDERING INFORMATION

	<u>Stock No.</u>	<u>Package Size</u>
	18201	1 Litre
	18206	1 Litre
	18210	25ml
Description	A tough UV/Visible light cure-based product that creates permanent bonds to many plastics. Adhesive cures in seconds to ABS, Polycarbonate and Acrylic. It creates a flexible resilient polymer with outstanding impact resistance and flex. Product is able to cure through most translucent substrates.	
Features	<ul style="list-style-type: none"> <li>• One component UV adhesive</li> <li>• Fast Curing</li> <li>• Available in 3 different viscosities</li> </ul>	

### PRODUCT DATA

Typical Physical Properties <b>Uncured</b>	Colour	Clear
	Viscosity cps	
	18201	810
	18206	1,700
	18210	850,000
	Non Volatile materials	99%
	Flashpoint	> 38°C
Specific Gravity g/ml	1.15	
Solubility	Alcohols, Ketones, oxygenated solvents	
Typical Physical Properties <b>Cured</b>	Tensile Strength	9.6 MPa
	Elongation	450%
	Volume Shrinkage	4.7%
	Water absorption (ASTM D570) 24 Hrs	2.4 %
	Shore Hardness	61D
	Temperature Range	-54°C – 107°C
	Adhesive Lap Shear (Acrylic)	3.3 MPa
Adhesive Lap Shear (PETG)	3.9 MPa	
Adhesive Lap Shear (Polycarbonate)	6.7 MPa	

Fixture Time and Tack-free time	<b>Light Source</b>	<b>Irradiance</b>	<b>Fixture Time/Sec</b>	<b>Tack-free Time/Sec</b>
	CT100	20 mW/cm <sup>2</sup>	<2	N/A
	Fusion® D Bulb	1,000 mW/cm <sup>2</sup>	<1	<2
	Synchron Inc. Model 400	250 mW/cm <sup>2</sup>	<1	10

Depth of cure (mm, min)	<b>Light Source</b>	<b>Irradiance</b>	<b>Exposure Time</b>
	400 W Metal Halide Bulb	20 mW/cm <sup>2</sup>	<b>30 Seconds</b> 1 mm

Unit 3, Shipton Way, Express Business Park, Northampton Road, Rushden, NN10 6GL, UK

ITW Devcon Industrial Products GmbH, Liebigstraße 21, 24145 KIEL, Deutschland/Germany



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### APPLICATION INFORMATION

Processing	ITW Devcon products are easily applied by syringe dispense or specialty valve spray units. That materials cure extremely fast in bond lines, e.g. where the surfaces are not exposed to air, with UV or visible radiation. Exposure doses range from 0.5 – 2 mJ/cm <sup>2</sup> depending on the intensity of the lamps and configuration of the assembly.
Storage and shelf life	Store away from light between 12° and 32°C Shelf life is 12 months from date of manufacture
Precaution	For complete safety and handling information, please refer to Material Safety Data Sheets prior to using this product.
Warranty	Devcon will replace any material found to be defective. Because the storage, handling and application of this material is beyond our control we can accept no liability for the results obtained.
Disclaimer	All information on this data sheet is based on laboratory testing and is not intended for design purposes. ITW Devcon makes no representations or warranties of any kind concerning this data. For product information visit <a href="http://www.devconeurope.com">www.devconeurope.com</a> alternatively for technical assistance please call +44 (0) 870 458 7388 or +49 431 718830 (Germany)