TECHNICAL DATASHEET

Vitralit® 6138

Vitralit® 6138 is a UV- and thermally curable adhesive. It has a good resistance to chemicals, an application range for high temperatures and an extraordinary thermal conductivity.

The incorporated spacers of 40 µm guarantee the identical space between the building components and the carrier material, even during automatic manufacturing.

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

Technical Data

Color	white
Resin	acrylat
Filler	approx. 58% Aluminiumoxid

UNCURED PROPERTIES

Viscosity (Brookfield LVT/25°C) [Pa*s]	PE-Norm P001	150 to 170
Flash point [°C]	PE-Norm P050	> 93
Density [g/cm³]	PE-Norm P051	approx. 2.05

Curing

UV(UV-A 60mW/cm² Thickn.st. 0,5mm): [sec.]	PE-Norm P002	30
Thermical Curing 140°C :[Min]	PE-Norm P035	30
Full Strength [hours]	PE-Norm P032	after 12

CURED PROPERTIES

Temperature Resistance [°C]	PE-Norm P030	-40 to 180
Hardness Shore D	PE-Norm P052	55 to 65
TG DSC [°C]	PE-Norm P009	> 44
Thermal conductivity [W/mK]	ASTM 1530	1.05

Adhesives and more...

Otherwise the guidelines for application, storage etc. in our general Data Sheet Vitralit® are valid.

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Mechanical Data

Lap Shear Strength (Alu/Alu) [MPa]	[PE-Norm P013]	approx. 14,0
Lap Shear Strength (Alu/Cu) [MPa]	[PE-Norm P013]	approx. 5,5
Lap Shear Strength (Stahl/Stahl) [MPa]	[PE-Norm P013]	approx. 11,0
Tensile Strength (Glas/Stahl) [MPa]	[PE-Norm P013]	approx. 9,0
Tensile Strength (Glass/Alu) [MPa]	[PE-Norm P013]	approx. 8,0

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 IP, 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. For glass bonding applications we have developed a special primer pen which can be easy applied to prepare the surface for best results.

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. If help is required, please consult our engineering department

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

Adhesives and more...

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