

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**
- One component UV adhesive
 - Fast Curing
 - Available in 3 different viscosities

PRODUCT DATA

Typical Physical Properties Uncured	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 Cured	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	Light Source	Irradiance	Fixture Time/Sec	Tack-free Time/Sec
	CT100	20 mW/cm ²	<2	N/A
	Fusion® D Bulb	1,000 mW/cm ²	<1	<2
	Synchron Inc. Model 400	250 mW/cm ²	<1	10

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

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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 ² 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 www.devconeurope.com alternatively for technical assistance please call +44 (0) 870 458 7388 or +49 431 718830 (Germany)