

DESCRIPTION

The PERMACOL 3540 is a capillary UV curing laminating adhesive for plastics. It is flexible and fast curing. This product is designed to have great adhesion to plastics like PMMA, PC, PET, ABS, PVC, PSU and SAN. It has good adhesion on glass, metals and ceramics.

The product has a low viscosity for capillary effect. The combination of UV stability and water resistance makes this adhesive suitable for outdoor use.

Technical details	
Chemical type	Acrylic
Color	Transparent
Viscosity	75 mPas
Specific gravity	1,04 g/cm ³
Refractive index	1,45
Hardness (Shore D)	45
Glass transition (Tg)	70°C
Tensile strength	14 MPa
Elongation at break	175%
Young's modulus	330 MPa
UV-LED wavelength	365 – 405nm
High intensity LED curing time (395nm)	< 3 seconds

USAGE INSTRUCTIONS

Preferably cured with 395nm UV-LED. Curing time depends on the spectrum and intensity of the lamp, the layer-thickness of the adhesive and the light transmittance of the substrate through which the light must pass. Due to oxygen inhibition the adhesive stays sticky at places where it is in contact with the open air. PERMACOL 3530 is our tack-free alternative.

Make sure the substrates are clean and free from dust, water, grease, fingerprints, oil, ect. Use isopropanol to clean the substrates. This product is light sensitive. Keep exposure to daylight and artificial lighting to a minimum.

BENEFITS

- Fast curing on demand
- Optically clear
- Great adhesion to a lot of plastics
- Suitable for outdoor use
- Water and UV-resistant
- 100% solids, no solvents
- CMR-free, RoHS and REACH compliant

Lapshear strenght	
PMMA / PMMA	>13 MPa
PC / PC	13 MPa
PET-G / PET-G	13 MPa
ABS / PMMA	>10 MPa
Glass / PMMA	12 MPa
Stainless steel / PMMA	8 MPa
Aluminium / PMMA	9 MPa

STORAGE

Store in its original packaging. Avoid direct exposure to light. See packaging for the expiration date. Shelf life: 12 months.

SAFETY

Use protective gloves to avoid direct contact with the skin. Check the Material Safety Data Sheet for specific safety information.

PACKAGING

The PERMACOL 3540 is available in different kinds of cartridges and bottles

SUPPORT

Contact our technical specialists to discuss your application and find the best solution. They can also adjust our products to specifications that suit your application.

EN – Legal Disclaimer

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