

# Technical Datasheet

## Vitralit® UD 8052 F



° Preliminary Datasheet. The technical statements are only guidelines and can be changed at any time.

### Product Description

Panacol Vitralit® adhesives are one-component, solvent-free radiation-curing adhesives. The advantages are very short curing times, good adhesion to a variety of substrates, and easy handling. Vitralit® products are used in electronics, medical applications, optics and for fixing parts in general.

Vitralit® UD 8052 F is a one component, no flow, UV/visible light and humidity curing isocyanate acrylate adhesive. The base material is transparent and slightly yellow. Customized versions with various colors are possible and make process control easier.

Vitralit® UD 8052 F is specially designed as a flexible encapsulant for local circuit board protection. Its jetting dispensability and fast cure properties make it especially suitable for applications in consumer electronics, where high UPH value is required. Thanks to the humidity curing mechanism, Vitralit® UD 8052 F can also be cured in shadowed areas. UV cure provides initial properties and the humidity post cure leads to an increasing performance over time.

### Curing Properties

UV-A	VIS	Secondary heat cure	Secondary humidity cure
✓	✓	-	✓

✓ suitable      - not suitable

The product cures within seconds with radiation in the UV-A - range (320 nm - 390 nm). For rapid and high quality crosslinking we recommend the UV devices manufactured by Dr. Hoenle AG, which complement our adhesive technology. Humidity may only be used as a secondary cure for shadowed areas after the product has been cured with UV.

Curing with UV and LED devices from Dr. Hönle AG		
Curing unit	Intensity [mW/cm <sup>2</sup> ]	Curing time * [sec]
LED Spot 100, 405 nm	250	3
LED Spot 100, 365 nm	200	2
UVA Lamp, Fe-doped	120	5

\* Curing time for material with a thickness of 0.5 mm. For thicker adhesive layer more time is necessary.

To obtain full cure at least one substrate must be transparent to the recommended wavelength. The curing speed will depend on the intensity of light, light source, the exposure time, and the light transmittance of the substrate.

Please note that UV cure only provides initial bonding strength and the humidity post cure leads to an increasing bonding strength and Shore hardness over time.

### Technical Data

Resin  
Appearance

isocyanate acrylate  
transparent, slightly yellow

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### Uncured material

Viscosity [mPas] (Kinexus Rheometer, 5s <sup>-1</sup> , 25°C) <i>PE-Norm 064</i>	8 000 - 11 000
Viscosity [mPas] (Kinexus Rheometer, 50s <sup>-1</sup> , 25°C) <i>PE-Norm 064</i>	1 500 - 3 000
Density [g/cm <sup>3</sup> ] <i>PE-Norm 004</i>	1,1
Flash point [°C] <i>PE-Norm 050</i>	>100
Refractive index [nD20] <i>PE-Norm 018</i>	1,4946

### Cured material

Temperature resistance [°C]	-40 - 150
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	Shore Hardness D	Bonding Strength (N per Die)*
Initial, after UV cure**	17	21
+ 1 day humidity cure***	19	49
+ 2 days humidity cure	25	59
+ 3 days humidity cure	31	65
+ 4 days humidity cure	39	72
+ 5 days humidity cure	43	74
+ 6 days humidity cure	43	73

\* Ceramic resistance die 1206 (3.2mm x 1.6mm). The ceramic die which has no light transmission is bonded to PCB with adhesive, UV only cures the adhesive on edge and fixes the die. The adhesive under the die is then cured with humidity over time.

\*\* UV cure: UVA lamp, Fe-doped, 60 mW/cm<sup>2</sup>, 30 s.

\*\*\* Humidity cure: 25 °C, 50 % RH.

Glass transition temperature DSC [°C] (UV + 7 days humidity cure @ 25 °C, 50 % RH) <i>PE-Norm 009</i>	35 - 45
Coefficient of thermal expansion [ppm/K] above Tg (UV + 7 days humidity cure @ 25 °C, 50 % RH) <i>PE-Norm 017</i>	60 - 80
Coefficient of thermal expansion [ppm/K] below Tg (UV + 7 days humidity cure @ 25 °C, 50 % RH) <i>PE-Norm 017</i>	220 - 260

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Young's modulus [MPa] <i>PE-Norm 056</i>	74
Tensile strength [MPa] <i>PE-Norm 014</i>	2 - 8
Elongation at break [%] <i>PE-Norm 014</i>	40 - 50

### Transport/Storage/Shelf Life

Trading unit	Transport	Storage	Shelf-life*
Cartridge	0°C - 10°C	0°C - 10°C	At delivery max. 3 months
Other packages			

**\*Store in original, unopened containers!**

### Instructions for Use

#### Surface preparation

The surfaces to be bonded should be free of dust, oil, grease or other dirt in order to obtain an optimal and reproducible bond.

For cleaning we recommend the cleaner IP® Panacol. Substrates with low surface energy (e.g. polyethylene, polypropylene) must be pretreated in order to achieve sufficient adhesion.

#### Application

Our products are supplied ready to use. Depending on packaging they can be applied by hand directly from the container or semi or fully automatically. With automated application from the cartridge the adhesive is conveyed by a compressed air-operated displacement plunger via a valve in the needle. When metering low viscosity materials from bottles the adhesive is transported by a diaphragm valve. If help is required, please contact our application engineering department.

Adhesive and substrate may not be cold and must be warmed up to room temperature prior to processing.

After application, bonding of the parts should be done quickly. Vitralit® adhesives cure slowly in daylight. Therefore, we recommend expose the material to as little light as possible and the use of opaque hose lines and dispensing needles.

For safety information refer to our safety data sheet.

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### Disclaimer

The product is free of heavy metals, PFOS and Phthalates and is conform to the EU-Directive 2017/2102/EU "RoHS III".

**THE VALUES NOTED IN THIS TECHNICAL DATA SHEET ARE TYPICAL PROPERTIES AND ARE NOT MEANT TO BE USED AS PRODUCT SPECIFICATIONS.**

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