

## 1. Product Description

This UV curing adhesive is translucent but not completely clear. It is medium viscosity and must therefore be applied to the bonding surface prior to assembling the parts. Due to the very high final strength of this adhesive, it is especially suitable for statically demanding bonds.

**Glass/metal bonds** work out especially well - it is preferably used when bonding metal hinges to glass doors. Many other materials can be bonded with this adhesive: apart from metal to glass, it is also suitable to bond stone, wood and variety of thermoplastics to glass.

As not all thermoplastics can be bonded, prior trials are always recommended when working with these materials. The adhesive B 682-T also reacts without UV exposure when using the BOHLE UV activator LF (Art.-Nr. BO 52 093 65/BO 52 093 66) (e.g. for coloured glass, laminated glass, metal/metal bonds etc.).

## 2. Fields of Application

- for bonds with demanding strength requirements
- Two and three dimensional glass constructions
- Objects subject to static and dynamic force

## 3. Suitable Bonding Materials

- glass metal
- glass to wood
- temp. glass to temp. glass
- glass to glass
- glass to stone
- glass to thermoplastics

## 4. Characteristics

Material Basis	Acrylic-acid-ester
Colour	translucent
Refractive index	approx. 1.50
Density	approx. 1.10 g/cm <sup>3</sup>
Solid content	100%
Flash point	approx. 93°C
Viscosity	approx. 900 mPa·s
Consistency	medium viscous
Bond line	0.1 - 0.5 mm
Irradiation	UVA 320 - 400 nm
Hardness	approx. 80 Shore D
Shear strength	approx. 26 N/mm <sup>2</sup>
Temperature range	-40°C to +140°C
Linear shrinkage	approx. 5%
Storage	Shelf life in original container cool, dry, dark location (without UV radiation) note expiration date on bottle

## 5. Available Packaging

UV-Adhesive B 682-T	1000g bottle	Art.-No. 52 093 96
UV-Adhesive B 682-T	250g bottle	Art.-No. 52 093 95
UV-Adhesive B 682-T	100g bottle	Art.-No. 52 093 94
UV-Adhesive B-682-T	20g bottle	Art.-No. 52 093 93

## 6. Limitation of Liability

Precautions see EU Safety Data Sheet.

The preceding information as well as any technical recommendation given in writing, verbally or based on tests are provided to the best of our knowledge. However, they are non-binding recommendations only and do not affect your responsibility to determine the correctness of given recommendations and suitability of the product for your particular purposes. The application, use or processing of our products as well as the production of products based on our technical recommendations are beyond our control and therefore fall exclusively in your area of responsibility. Sales of our products are effected according to our most updated General Sales and Delivery Conditions.