



U3320

TECHNICAL DATA SHEET

U3320 is a low-viscosity UV-curable with excellent bonding characteristics on various plastics, especially PET/ PETG and polycarbonate. U3320's thin viscosity makes it ideal for use in wicking applications, especially on components with close-fitting tolerances.

Physical Properties - Monomer (Uncured)

Base Compound	Modified Acrylate
Appearance	Light Straw Liquid
Viscosity	45 +/- 15 cps
Shelf Life	9 months
Storage Condition	8°C to 21°C in darkness
RoHS-Compliant	Yes

Physical Properties - Polymer (Cured)

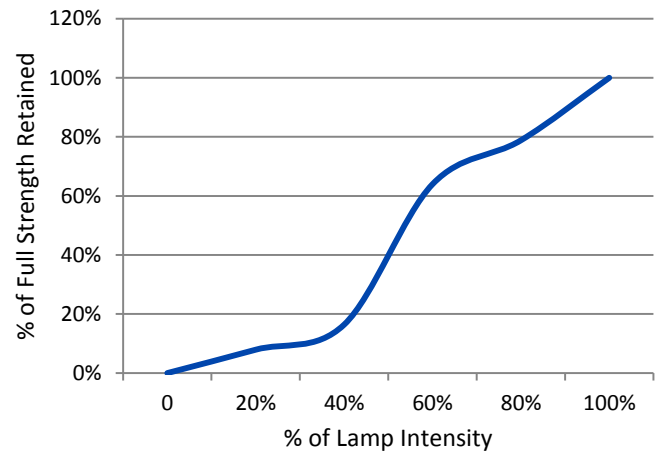
Setting Time*	< 3 seconds
Appearance	Colorless Solid
Tack-Free Surface?	Yes
Elongation	150%
Shore Hardness	63 (Shore A) 54 (Shore D)
Optimal Wavelength	300 to 420 nm

*Polymerized @ 395nm @ 50mW/cm²

Specifications and Approvals

None

% Strength Retained @ Given Dosage



Performance of Cured Adhesive

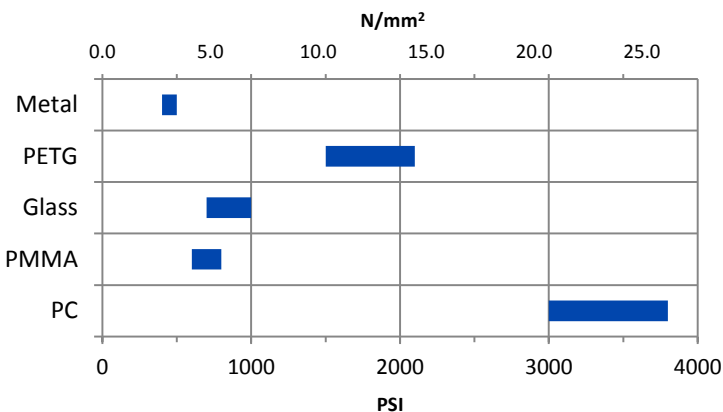
Substrate	N/mm ²			PSI		
	Min	Max	Range	Min	Max	Range
Metal	2.8	3.4	to	400	500	to
PETG	10.3	14.5	to	1500	2100	to
Glass	4.8	6.9	to	700	1000	to
PMMA	4.1	5.5	to	600	800	to
PC	20.7	26.2	to	3000	3800	to

* n/r = not recommended for use on this substrate

Solvent Resistance

Solvent	Example	Resistance
Alcohol	Ethanol, Methanol	+++
Ester (aromatic)	Ethylacetate	---
Ketone (aromatic)	Acetone, Benzophenone	---
Aliphatic hydrocarbon (alkanes)	Petrol, Heptanes, Hexane	++-
Aromatic hydrocarbons	Benzyl, Toluol, Xylol	++-
Halogenated hydrocarbons	Methylenchloride, Chloroform, Chlorobenzol	---
Weak aqueous acid	Nitrite, muriatic acid, sulphuric acid, phosphoric acid	+++ (--- if concentrated)
Weak aqueous base	sodium hydroxide solution, caustic potash	+++ (--- if concentrated)

Performance Range, by Substrate



General Instructions

Surfaces to be bonded should be clean and dry. Dispense a drop or drops to one surface only. Apply only enough to leave a thin film layer after compression. Press parts together and expose to energy when ready. An adequate bond will develop rapidly, depending on UV dose efficacy, and maximum strength is achieved when the adhesive reaches full cure. Bonds should be allowed to cool before applying any stress.

Curing Performance

Photoinitiation initiates the curing process. Handling strength is reached in a short time, and will vary based on UV dose efficacy, environmental conditions, bond line gap, and other factors.

Storage

Products should be stored unopened in a cool, dry place out of direct sunlight. Products should be kept at room temperature away from direct light. Protect from extreme heat or cold, optimum temperature is between 8°C and 21°C.

Note

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For safe handling information on this product, consult the Safety Data Sheet (SDS)

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