

# GLUE RANGE



## What is Gluing?

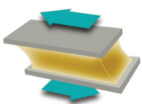
Gluing is a delicate operation which has many advantages since it makes it possible to avoid mechanical assembly by riveting, welding or screwing by allowing a continuous bond, a distribution of forces over the entire surface and a high resistance to fatigue. A reduction in the weight of the assembly due to the low mass of the adhesive and the reduction in the thickness of the materials.

The choice of adhesive will be based on the materials to be assembled and the expected mechanical and durability properties. A wide choice of chemistry is available and we will help you to find the best compromise, according to your application and the means of implementation at your disposal.

	9005UV	9111UV	9030UV
<b>Nature</b>	UV GLUE		
<b>Color</b>	Transparent Yellow	Transparent Yellow	Transparent Yellow
<b>Hardness</b>	D20	D40	D45
<b>Viscosity (cP), 25°C</b>	50/ 80 000	10 000	30 000
<b>Temperature range</b>	-50°C +130°C	-50°C +150°C	-50°C +150°C
<b>Curing</b>	UV Hg / UV LED	UV Hg / UV LED	UV Hg / UV LED
<b>Dose UVA (mJ/cm<sup>2</sup>)</b>	5 000	3 000	3 000
<b>Adhesion</b>	Glass / Alu / PMMA/ ABS	PET / Glass / Alu / PMMA/ PC	Glass / Alu / PMMA/ PC
<b>Stripper</b>	DVP	DVP	DVP
<b>Thickness maxi (mm)</b>	2	2	2
<b>UV resistance</b>	+	-	--
UV bonding allows assembly in an ultra-short process but requires that one of the faces allows UV rays to pass.			



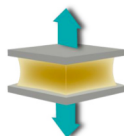
## 4 main types of mechanical stress acting statically or dynamically



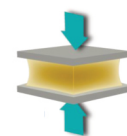
SHEAR



PEEL



TRACTION



COMPRESSION

	POLYURETHANE						EPOXY					
	A220/ A280/ A290	A 252	A236	A210	A211	072111- SB	UV20GEL	2E25	ST1626	ST1621	A140-1	H9952
	SF 490 L15/ SF 490 L10/ SF 490 L03	SF 453 L04	SF 436 L25	SF 410 L60	SF 411 L60	-	-	-	-	-	SP 740	SP 752 L120 FR
	POLYURETHANE BI				PU UV MONO		EPOXY BI					
<b>Color</b>	Black White White	Black	Beige	Grey	Green	Purple	Clear	Amber	Trans- parent	Trans- parent	Beige Black	Black
<b>Hardness shore</b>	D48	A70	D60	D50	A95	D50	A80	D70	D80	D80	D75	D85
<b>Viscosity (cP), 25°C</b>	150 000	600 000	Paste	5 500	Paste	22 500	Thixo- trope	12 000	15 000	45 000	430 000	180 000
<b>Pot Life min</b>	15/10/3	8	30/90/ 120	45	40	UVA 4000mj + moisture RT 24h	UVA395 3500mj	60	6	6	40	120
<b>Packaging</b>	50ml/ 400ml Bidon	50ml/ 400ml Bidon	400ml/ Bidon	50ml	50ml	900g	55ml/ 340ml	50ml	50ml	50ml/ 200ml/ Bidon	50ml/ 400ml/ Bidon	50ml/ 420ml/ Bidon
<b>Application</b>	Structural bonding, absorbs vibrations, impact resistance 30N/mm	Adhesive, Paste, non sliding for irregular space, high flexibility, impact resistance 70N/mm	Assembly of parts with large clearances (<40mm)	Bonding of body-work, bonding of metallic structures (racing vehicles aeronautics) bonding of insert and composite structure	Dielectric adhesive for electronic components, <b>UL94VO</b>	Structural adhesive for plastics, Nylon, Delrin, PET & Santoprene PBT/NYLON/DELIRIN/PP <b>TESLA, GM, HONDA, FORD</b>	Anti vibration for composant <b>HONDA TOYOTA</b>	For high temperature 180-200°C Application EV adhesive and Encapsulant <b>FDA</b> Compliant	Quick curing at RT, to glue composite, metal, wood, concrete	Quick curing at RT, to glue composite, metal, wood, concrete	Excellent mechanical properties, impact resistance 10N/mm	High mechanical resistance, <b>UL</b> and <b>EN45545</b>

	THERMAL MANAGEMENT	
	THERMOSINK 35-3	THERMOSINK 35-6
<b>Type</b>	RTV2	RTV2
<b>Hardness shore</b>	A50	A75
<b>Mix ratio</b>	1:1	1:1
<b>Temperature range</b>	-40 +200°C	-40 +200°C
<b>Viscosity (cP), 25°C</b>	15 000	30 000
<b>Color</b>	Grey	Grey
<b>Curing time</b>	4H RT or 15min 125°C	2h RT or 45min 100°C 45MN
<b>Thermal conductivity</b>	> 3,4WM°K/ <b>UL94VO</b>	> 3,5WM°K 3,4WM°K/ <b>UL94VO</b> <b>OUTGAS NASA</b>
<b>Packaging</b>	40kg	40kg

	SILICONE GLUE					
	R15220	R14968	S800	S802	SP7601	SP7605
<b>Color</b>	Transparent	Translu- cide	White	Trans- parent	Black	Transparent
<b>Hardness shore</b>	A20	A15	A45	A45/A30	A65	A20
<b>Viscosity Iso 1183-1 [g/cm³]</b>	7 000	40 000	Paste	Paste	Paste	7 000
<b>Skin forming 23°C/50%RH</b>	15	15	20	12	10	15
<b>Flame retardancy</b>	-	-	UL94 HB	-	UL94 V1	UL94 HB
<b>Other</b>	-	UV Tracer	-	- / -	1,7Wm°K	-
<b>Packaging</b>	310ml, 20 l, 200 l drum					
Curing at room temperature, one-component silicones allow the assembly and sealing of parts with very different coefficients of expansion.						