U3337

U3337 is a medium-to-high viscosity, UV-curable adhesive designed for bonding a wide variety of plastics in a multitude of configurations. It is strong, flexible and well-suited to bonding dissimilar substrates and has a tack free surface finish.

Technology / Base	Modified Acrylate
Type of Product	Structural Adhesive
Components	One Component
Curing	Ultra Violet Light
Appearance / Color	Light Straw
Consistency	Liquid

Technical Data

Rheology	**Value**	**Condition/Method**
Viscosity	1000 +/- 150 cps	20°C to 25°C (68°F to 77°F)
Density		
Specific Gravity	1.06	
Curing Process Characteristics		
Flash Point	> 95°C	
Set Time and Wavelength	< 6 sec at 395nm, 50mW/cm2	
Full Cure Time	24 hours	
Shelf Life	9 months	
Storage Condition	8°C to 21°C in darkness	
Optimum Wavelength	300 to 420 nm	
Cured Material Characteristics		
Cured Appearance	Colorless solid	
Tack Free	Yes	
RoHS Compliant	Yes	
Cured Mechanical Properties		
Hardness Shore A	-	ASTM D2240
Shore D	70	ASTM D2240
Elongation to Break	175%	ASTM D638

General Instructions

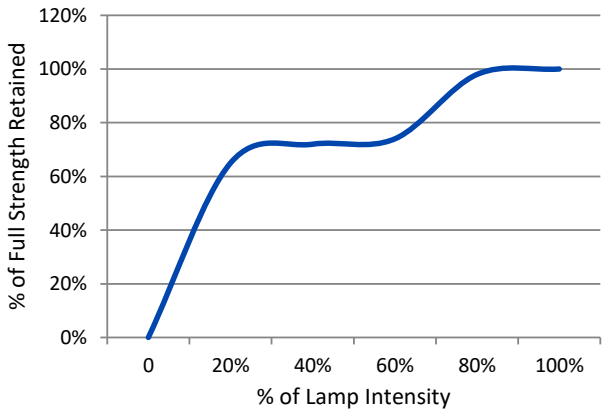
Surfaces to be bonded should be clean and dry. Dispense a drop or drops to one surface only. Apply only enough to leave a thin film layer after compression. Press parts together and expose to UV dose when ready. An adequate bond should develop rapidly, depending on UV dose efficacy, and maximum strength is attained in 24 hours. Wipe off excess adhesive from the top of the container and recap. products, if left uncapped or exposed to sunlight, may deteriorate or cure prematurely.

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. Product will continue to cure for at least 24 hours before full strength and solvent resistance is developed.

Specifications and Approvals

Percent Strength Retained at Given Dosage



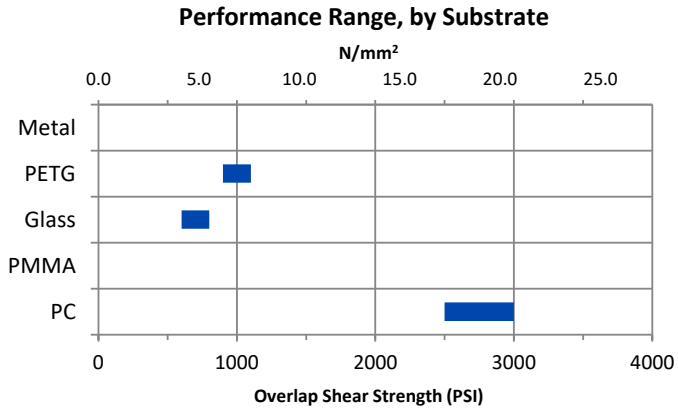
Technical Data Sheet

H.B. Fuller | Engineering Adhesives

Performance of Cured Adhesive

Substrate	N/mm²			PSI		
Metal	n/r	to	n/r	n/r	to	n/r
PETG	6.2	to	7.6	900	to	1100
Glass	4.1	to	5.5	600	to	800
PMMA	n/r	to	n/r	n/r	to	n/r
PC	17.2	to	20.7	2500	to	3000

* n/r = not recorded 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)

Safety and Disposal

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

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, do not refrigerate.

H.B. Fuller Company
9001 W. Fey Drive
Frankfort, IL 60423
+1.630.761.8900

Date Modified: 23 October 2017

www.hbfuller.com www.hbfullerengineering.com

Connecting what matters.™