

## TECHNICAL DATA SHEET

### Altraset® 520

UV Curable Glass Laminating System

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(An ISO 9001 Certified Company)

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### Product Description

Altraset® 520 is a single component UV cure liquid adhesive used to laminate glass-to-glass for decorative applications in architecture and sound deadening uses. It is cured with low intensity ultraviolet (UV) light to provide an optically clear, transparent interlayer with excellent bond strength to glass. Once cured, typically in 30 minutes, no additional processing is required. The Altraset® 520 interlayer produces glass laminates with excellent performance.

### Key Benefits:

- ❖ One component, ready-to-use product
- ❖ Fast and consistent process
- ❖ Low start-up and operating costs
- ❖ Safety performance
- ❖ Excellent optical clarity

### Properties

|   |                 |
|---|-----------------|
| Appearance  | : Clear liquid  |
| Specific Gravity @ 25±2 °C                                    | : 0.9±0.02      |
| Viscosity Brookfield @ 25±2°C, Spindle no. 2, Speed 50 r.p.m. | : 5-15 cP       |
| Cure  | : Ultraviolet   |
| Temperature range   | : -30 to 120 °C |
| Application   | : Lamination    |

### Curing Performance

Altraset® 520 will only cure when and where it is exposed to ultraviolet light. If being used to bond parts together, UV light must be able to pass through one of the parts to reach the adhesive.

### Adhesive Properties of Cured Material

Cured @ 10 mW/cm<sup>2</sup> @ 365 nm using a UV light source

|  |             |
|--|-------------|
| Glass Laminate (10x10cm) of thickness 2.5 mm |             |
| Cure time                                    | : 20-30 min |

### Thermal Shock Test

|                |   |
|----------------|---|
| Substrate      | : Glass Laminate  |
| Test procedure | : A glass laminate is kept in a thermal shock chamber and a thermal shock is applied at 80 °C to -30 °C |
| Observation    | : No Abnormal Change  |

### Directions for Use

1. For best performance bond surfaces should be clean and free from grease.
2. Taping: Apply double-sided adhesive tape to the perimeter of one glass piece and assemble the two pieces. The tape acts as a dam and provides the required thickness for the Altraset® 520 interlayer.
3. Filling: Fill the space between the two pieces of glass with Altraset® 520. Since it is pumped in liquid form, Altraset® 520 spreads evenly – even between irregular surfaces.
4. Curing: Curing begins only when you exposure the glass to daylight, UV light and artificial lighting, giving you greater control over the process. Cure time is typically 30 minutes
5. Cure rate is dependent on lamp intensity, distance from light source, depth of cure needed or bondline gap and light transmittance of the substrate through which the radiation must pass.
6. For dry curing of exposed surfaces, higher intensity UV is required (100 mW/cm<sup>2</sup>).
7. Cooling should be provided for temperature sensitive substrates such as thermoplastics.

### Handling

- ❖ Altraset® 520 must be handled in compliance with relevant local regulations.
- ❖ Altraset® 520 can affect certain plastics or coatings. It is recommended to check all surfaces for compatibility before use.

### Storage

- ❖ Store Altraset® 520 in a cool and dry location in unopened containers at 25±2°C
- ❖ This product is light sensitive; Keep away from daylight, UV light and artificial lighting during storage and handling.

- ❖ To prevent contamination of unused product, do not return any material to its original container. For further specific shelf life information, contact our technical service Center.

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**Pack Size**

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Altraset® 520 is ideally available in 20 kg pack size.

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**Note**

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All statements, technical information and recommendations set forth herein are based on tests which Metlok Private Limited, believes to be reliable. However, Metlok Private Limited does not guarantee their accuracy or completeness. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any production methods mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof. In no case will Metlok Private Limited be liable for direct, consequential economic or other damages.

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