

## PRODUCT DATA SHEET

# Casco<sup>®</sup> Express Glas

UV-CURING HIGH VISCOSITY ADHESIVE FORMULATED FOR BONDING GLASS TO GLASS AND GLASS TO METAL.

### DESCRIPTION

UV-curing high viscosity adhesive formulated for bonding glass to glass and glass to metal.

### USES

Suited to applications requiring a tough cured polymer and a rapid bonding, typical usages include gluing glass ornaments, jewellery assembly, wine glasses, glass handles and bonding glass furniture and displays.

### CHARACTERISTICS / ADVANTAGES

- Cures rapidly
- Clear bond line
- Especially good adhesion to glass
- Excellent resistance to heat ageing
- Exhibit excellent chemical resistance to most oils and solvents including alcohols, methylated spirit water.
- Very good long term performance

### PRODUCT INFORMATION

Composition	Urethane acrylate ester
Packaging	2 ml blistered syringe
Colour	Clear
Shelf life	At least 1 year in closed package in a cool area out of direct sunlight. 0 - 5 °C gives optimum storage stability.
Storage conditions	
Density	Approx. 1090 kg/m <sup>3</sup>
Solid content by weight	100 %
Consistency	Liquid

### TECHNICAL INFORMATION

Tensile Strength	After 24 hours at 25 °C. 6 – 15 N/mm <sup>2</sup> (ASTM D2095-69, Grit blasted mild steel to glass).
Chemical Resistance	Exhibit excellent chemical resistance to most oils and solvents including alcohols, methylated spirit water.
Service Temperature	-50 °C to +130 °C. At 130 °C the bond strength will be ~20 % of the strength at 20 °C.

## APPLICATION INFORMATION

Product Temperature	Application at +15 °C - +25 °C.
Open Time	From 10 sec to approx. 3 min depending on daylight intensity.

## APPLICATION INSTRUCTIONS

### SUBSTRATE PREPARATION

The surfaces to be glued must be clean, dry and free from grease. Degrease preferable with acetone and roughen metal surfaces with a sand paper.

### APPLICATION METHOD / TOOLS

Before applying the adhesive, check how the parts to be glued fit together.  
Apply the adhesive in a thin layer on one surface, bring parts together and expose to direct daylight (UV-light).  
The curing time on a sunny day is about 20 seconds. On a dull and cloudy weather the curing time is longer, approx. 1 – 3 minutes.  
If a controlled and repeatable cure is needed, UV-lamps can be used. Higher intensity lamps give faster cure speeds. The spectra should contain light of 365 nm, which is in the UV-A region. To cure the adhesive in 10 seconds a radiation effect of 10 mW/cm<sup>2</sup> is needed.

### LIMITATIONS

“Greasy” plastics like polyethylene, polypropylene and Teflon cannot be glued.  
It is important to apply ExpressGlas in a thin layer, the product is intended to be an adhesive and designed to cure in thin layers. ExpressGlas can be used to a maximum depth of ~ 3 mm.  
Do not use ExpressGlas in pure oxygen or chlorine environment (industrial use).

### CLEANING OF EQUIPMENT

When working with adhesive, cleanliness must be observed. Therefore always work carefully and systematically in order to avoid unnecessary spillage.  
Clean tools and dried adhesive spots with acetone, Casco Limtvätt or similar.  
Dried adhesives have to be removed mechanically.  
On skin, uncured adhesive is wiped off with a rag, then wash with soap and water.  
Keep out of reach of children.  
Do not empty into drains.

## BASIS OF PRODUCT DATA

All technical data stated in this Product Data Sheet are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

## LOCAL RESTRICTIONS

Please note that as a result of specific local regulations the declared data for this product may vary from country to country. Please consult the local Product Data Sheet for the exact product data.

## ECOLOGY, HEALTH AND SAFETY

For information and advice on the safe handling, storage and disposal of chemical products, users shall refer to the most recent Safety Data Sheet (SDS) containing physical, ecological, toxicological and other safety-related data.

## LEGAL NOTES

The information, and, in particular, the recommendations relating to the application and end-use of Casco products, are given in good faith based on Sika's current knowledge and experience of the products when properly stored, handled and applied under normal conditions in accordance with Sika's recommendations. In practice, the differences in materials, substrates and actual site conditions are such that no warranty in respect of merchantability or of fitness for a particular purpose, nor any liability arising out of any legal relationship whatsoever, can be inferred either from this information, or from any written recommendations, or from any other advice offered. The user of the product must test the product's suitability for the intended application and purpose. Sika reserves the right to change the properties of its products. The proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users must always refer to the most recent issue of the local Product Data Sheet for the product concerned, copies of which will be supplied on request or on the website [www.casco.eu](http://www.casco.eu).

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