

Product features

Modified acrylate / 1 K / solvent-free / radiation-curing UV-A / anaerobic post-curing

- Sealing of bullet and primer cap
- Increases bullet extraction force
- Various product variants depending on caliber type
- Anaerobic post-curing
- Capillary flow
- High glass transition temperature

Curing

UV-A	Suitable
LED 365 nm (recommendation 2W/cm ² , distance 15-20mm)	Suitable
LED 405 nm	Suitable
Anaerobic post-curing	Suitable

If applicable, anaerobic curing or activator curing should only be used as secondary curing for shaded areas after the product has been cured with UV radiation.

Anaerobic curing	Hand strength
Time	3 min

To achieve complete curing, at least one substrate must be transparent to the recommended wavelength. The curing speed depends on the wavelength spectrum of the light source, the light intensity, the distance to the light source, the component geometry, and the amount of adhesive. Final strength is achieved after 12 hours.

The adhesive meets the requirements of AEP-97 and STANAG 4147.

Andre offers different adhesive variants for different caliber variants.

The caliber size and type (e.g., tracer ammunition or 0.5 BMG) also require different adhesives in terms of viscosity, adhesive strength, and capillary action due to surface tension and texture.

Ask our sales department!

Technical data sheet

AS90463N



Technical data

Base	Acrylate without color pigments
Transparency/color	Transparent, green, red, blue
Fluorescence	Light blue

In uncured state

Viscosity [mPas] (Brookfield LVT, 25 °C, Sp. 1/60 rpm)	10-15
Density [g/cm ³]	1.1
Surface tension mN/m	28

In hardened state

Temperature resistance [°C]	-40 – 180
Glass transition temperature - DSC [°C] UV-A Fe-doped hand lamp, 30s	13
Block shear strength (PC) [MPa] LED 365 nm, 1500 mW/cm ² , 4s	12
Tensile shear strength (brass/brass) [MPa] Anaerobic, 3h	5

Transport/storage/shelf life

Packaging unit	Cartridge	Other containers
Transport	At room temperature max. 25°C	
Storage	At room temperature max. max. 25°C	
Shelf life	Upon delivery min. 1.5 months max. 3 months	

*Storage in unopened original container!

Processing instructions

Surface preparation

The surfaces to be bonded should be free of dust, oil, grease, mold release agents, or other contaminants.

Contaminants must be removed in order to achieve an optimal and reproducible bond. For cleaning, we recommend Andre® cleaner or a solution of isopropyl alcohol in a concentration of 95% or higher. Substrates with low surface energy (e.g., polyethylene, polypropylene) must be pretreated with in order to achieve sufficient adhesion.

Adhesive application

Our products are delivered ready for use. Depending on the packaging, they can be dispensed manually directly from the container or semi- or fully automatically.

Andre adhesives can cure slowly in daylight and after prolonged exposure to indoor lighting. We therefore recommend minimizing the adhesive's exposure to ambient light. Fluid lines and dispensing tips must be 100% light-blocking. If you have any questions about the dosage of the adhesives, please contact our application technology department. The adhesive and substrate should not be cold for a proper bond. They must be warmed to room temperature before processing. After dosing the adhesive, the parts should be bonded immediately. It is recommended to use air extraction systems during curing to remove the vapors and heat generated during the curing process. After curing, the adhesive must cool to ambient temperature before the performance of the product is tested. Safety information can be found in our Material Safety Data Sheet (MSDS).

Storage

This is light-sensitive material. Containers must remain covered when not in use. Minimize exposure of uncured material to daylight, artificial light, and UV light during storage and handling. Store uncured products in their original, closed containers in a dry place. Material removed from the original container must not be returned to the container as it may be contaminated. Andre cannot accept responsibility for products that have been improperly stored, contaminated, or repackaged in other containers.

Handling and cleaning

For information on safe handling, refer to the Material Safety Data Sheet (MSDS) for this product. Uncured material can be wiped off surfaces with organic solvents. Do not use solvents to remove material from eyes or skin!

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Notes

The product is free of heavy metals, PFOS, and phthalates and complies with the current EU RoHS directive.

The values stated in this technical data sheet are typical properties and must not be used as product specifications.

Our data sheets have been compiled based on current knowledge. The data provided therein is for the user's information only and does not describe any legally binding properties. We recommend testing our products to ensure that they are suitable for the user's intended application. Our application engineering department is available for further consultation. In general, our general terms and conditions apply, including for warranty claims.