



**Product Description**

Vibra-Tite 221 is a UV curable structural paste adhesive designed for bonding and fixturing. The paste like consistency of the material allows the formation of thick bondlines for bonding of widely spaced or uneven substrates.

**Typical Applications**

Typical applications for Vibra-Tite 221 structural acrylic include bonding of a metal, ceramic and other materials to a second transparent substrate such as glass or clear plastic.

**Instructions for Use**

For best performance surfaces should be relatively free of dirt and grease. Apply Vibra-Tite 221 to one substrate and mate to the opposite substrate. Fixture as needed and expose to an appropriate UV light source. Common light sources may be fluorescent, LED, mercury arc and metal halide. For curing thick sections, emission sources in the longer UV wavelengths (around 380 nm) are preferred.

**Technical Features**

Chemical Type ..... Acrylic  
Appearance ..... Pale Yellow  
Toxicity ..... Low  
Viscosity @ 25°C ..... 150,000 cps  
Specific Gravity ..... 1.06

**Performance of Cured Material**

Depth of Cure ..... 75-100 mil  
Maximum Gap Fill ..... 2 mm  
Block Shear (ISO13445) ..... >1000 psi  
Temperature Range..... -60°F to 212°F  
(-51°C to 100°C)

**Presentation**

30 ml black EFD Cartridge  
12 oz

**General Information**

**Safe Handling and Storage**

Store unused Vibra-Tite 221 in its original container and in a cool, dry location. Avoid prolonged exposure to light.

**Shelf Life**

12 months from date of manufacture.

**Note**

The data are furnished for information only and are believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is recommended that the product be tested in the application for which it is to be used.