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LED Lamps
for curing UV Adhesives

Curing

Bohle offers a comprehensive portfolio of UVA lamps for curing UV adhesives. The working lamp length should meet or exceed the length of the joint for bonding. In this way, extreme tensions within the bonding joint are avoided which might lead to the failure of the bond. The lamps are particularly suitable for metal bonds and short bonding distances. For longer bonding distances, tube lamps of an appropriate size should be used to minimise tensions. All Bohle UVA lamps are equipped with special filter screens.



At a glance



Technical Data	UVA-LED Hand lamp 365 nm BO 5500358	TwinLED BO 5500355
Wave lengths	365 nm	365 nm and 395 nm, switchable
Possible UV adhesives	UVA curing adhesives*	all UVA and light curing adhesives
UVA Intensity	> 200 mW/ cm ² measured with Bohle UV gauge	> 200 mW/ cm ² measured with Bohle UV gauge
Power consumption	70 W	Battery powered, energy-efficient
Size	Lamp approx. 225 x 180 x 120 mm, handle approx. 140 mm	125 x 40 x 70 mm
Weight	Lamp 1.9 kg	600 g
Temperature development	low	low
Area of application	Bonding metal parts, surface bonds up to approx. 250 x 250 mm max.	Bonding metal parts up to Ø 120 mm
Service life of light bulb	approx. 20,000 h	approx. 20,000 h
Connection	90 - 264 V, 47-63 Hz, cable-bound	100 - 240 V, 50/ 60 HZ, battery powered
Features	no transformer	4 separately programmable timers
	high performance	high performance
	short curing times	short curing times
		small
		lightweight
	energy-efficient	energy-efficient
		silent
		portable
	no warm-up or cool-down phase, can be switched on and off as often as required	no warm-up or cool-down phase, can be switched on and off as often as required

UVA-LED-hand lamp 365 nm

Thanks to its high UV performance, the UVA LED hand lamp is particularly suitable for bonding metal parts and curing bonding surfaces up to 250 x 250 mm. The positioning of the LEDs enables a uniform light exposure of the entire surface. The UVA LED hand lamp does not require warm-up or cool-down times, and is therefore suitable both for on/off and permanent operation. The service life of the LEDs amounts to 20,000 operating hours. The UVA LED hand lamp has a power consumption of only 70 watts. It does not need ballast and is suitable for connection to all standard power supply lines (110/230 V and 50/60 Hz) around the world.

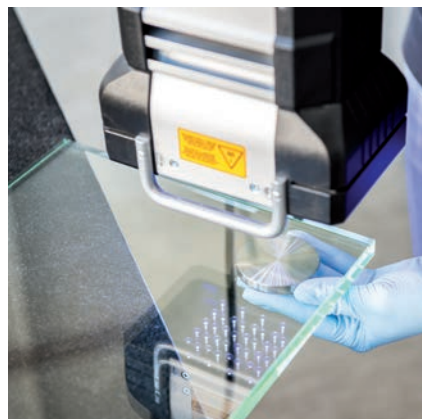
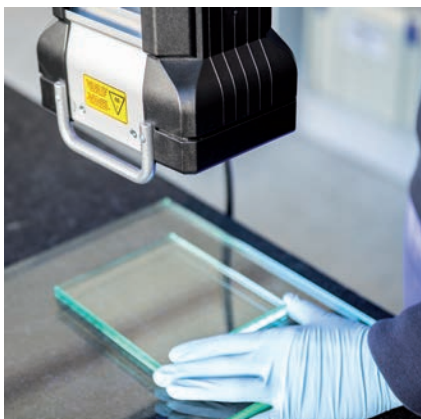
The UVA LED hand lamp operates with a wavelength of 365 nm. It is suitable for curing all UV adhesives when used on UV transmitting materials. UVA absorbing materials, such as laminated safety glass, cannot be cured with this lamp.



Benefits:

- High performance
- Short curing times
- Enables the curing of larger surfaces
- Energy-efficient
- High-durability lamp
- No warm-up or cool-down phase
- Can be switched on and off as often as required
- 110/230V and 50/60Hz

Art. No.	Description
BO 5500358	UVA-LED-hand lamp 365 nm



Verifix® TwinLED UV LED Lamp

The small and extremely powerful Bohle Verifix TwinLED UV-LED lamp is the new high-tech tool for UV bonding. It's cordless so fits into any bag and can be taken on site. The innovative lamp achieves a high uniform light intensity without getting hot thanks to the LED technology. The adjustable cone of light enables bonding up to a diameter of 120 mm. The long LED service life ensures very low operating costs with an extremely fast return on investment. This powerful device pays for itself!

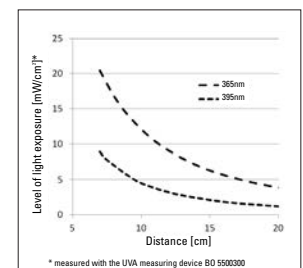
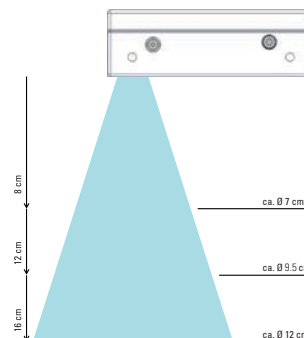


Benefits:

- Very high performance
- Short curing times
- Suitable for all adhesive types
- Small, light and easy to carry
- Energy-saving and quiet
- Good value for money
- No build-up of heat
- Instantly ready for use, no warming-up phase
- Can be fixed to objects such as a standard camera tripod

Art. No.	Description
BO 5500355	Verifix® "Twin LED" UV-LED Lamp
SP BT5559	Spare battery
BO 5500356	Handle
BO 5500357	Stand

The Bohle Verifix UV LED Lamp TwinLED is suitable for bonding up to a diameter of approx. 120 mm. The size of the beam of light is regulated by the distance of the TwinLED to the bonding surface. The light intensity is very even over the entire area, thus ensuring stress-free bonding.



Accessories for Glass/Metal bonding

▶ UV Adhesive Verifix® MV 760



Due to its outstanding properties, the UVA curing adhesive Verifix® MV 760 is extremely versatile and therefore ideal for glass/metal and glass/glass bonds. Verifix® MV 760 is mainly used for constructions that are subject to high static or dynamic forces. Its high elongation at break compensates for the expansion of different bonded materials without loss of adhesion.

Art. No	Contents
BO MV7601K	1000 g
BO MV76025	250 g
BO MV76010	100 g
BO MV76002	20 g

▶ UV Adhesive Verifix® MV 760VIS



The UVA and light curing adhesive Verifix® MV 760VIS is suitable for universal applications due to its adhesive properties. It is therefore ideal for glass/metal and glass/glass bonds. This adhesive is mainly used for glass constructions subject to high static or dynamic forces. Important: Due to its composition, Verifix® MV 760 VIS is particularly appropriate for

bonding laminated safety glass/laminated safety glass and laminated safety glass/metal.

Art. No	Contents
BO MV76V1K	1000 g
BO MV76V25	250 g
BO MV76V10	100 g

▶ UV Adhesive Verifix® B 682-T



Cures either by UV light or with Activator · medium viscosity · transparent · especially for glass / metal bonding
Characteristics: Two and three dimensional glass constructions · static and dynamic loads · for bonds with high strength requirements

Art. No	Contents
BO 5209396	1000 g
BO 5209395	250 g
BO 5209394	100 g
BO 5209393	20 g

UV Adhesive Verifix® with Spacers available

The spacers added to medium viscosity Verifix adhesives guarantee that the required minimum adhesive layer thickness is reached. This ensures that, when bonding heavy glass parts, sufficient adhesive is distributed between the bonding parts. Depending on the bonding process, this method has also proven useful when bonding metal in order to maintain the minimum adhesive layer thickness. The spacers do not interfere with the technical properties of the adhesive.

If you have any questions, our application technicians will be happy to assist you

▶ Bohle Special Cleaner



Ideal for preliminary cleaning prior to glass bonding or sealing. The Bohle Special Cleaner cleans and degreases glass, metal, ceramic and rubber. The special composition of the cleaner ensures very thorough cleaning. Particularly suitable for use with UV adhesives

Art. No	Contents
BO 5107911	Refill 1 litre
BO 5107914	Empty 250ml bottle with spray head for Special Cleaner

▶ Metal Primer



For improved adhesion on aluminium, chrome or nickel-plated surfaces for bonding with acrylate adhesives. Shelf life in original packaging: 12 months from the date of manufacture

Art. No	Contents
BO 5209488	100 ml
BO 5209489	1000 ml

▶ Pyrosil® Professional Kit



For improved long-term adhesion of challenging bonds. Especially suitable for regular use under industrial conditions, this kit has a larger burner with more contents, robust operating elements and a support base. This kit contains a burner with piezoelectric firing, 2 x 27.5 g gas cartridges, 2 x 50 ml of coupling agent and an application brush. Contents are

sufficient to pre-treat approx. 10,000 cm² of bonding surface.

Art. No	Description
BO 5209491	Pyrosil® Professional Kit

▶ Swing Hinge round



High quality stainless steel hinge suitable for inset doors - a threaded pin in the hinge enables the door to be removed after bonding

i Glass thickness up to 12 mm
Door weight max. 10 kg
Height 18.5 mm
Diameter 20 mm
Packaging unit 2 items

Art. No	Description
BO 5206260	Swing Hinge

▶ Cristallo Fix Hinge Set



With Cristallo Fix, Bohle has developed a hinge which enables glass doors to be bonded to glass cabinets and which can also be adjusted in three dimensions. The technically sophisticated product with an opening angle of 125° is equipped with a damper with spring closing mechanism and is equally suitable for inset

or overlay doors. Instead of a conventional cross plate mounting, this new product uses a cabinet bonding plate with snap-on function which was specifically developed for this purpose - infinitely adjustable - with integrated damping technology

i Opening angle 125 degrees, Glass thickness 3 - 8 mm, Mounting glass/glass, for UV bonding

Art. No	Description
BO 5206060	Cristallo Fix Hinge Set

▶ UVA Measuring Device



For measuring the intensity of UVA tube and hand lamps - suitable for UVA and UVB range. For testing the UVA transmittance of glass.

Art. No	Description
BO 5500300	0 - 200 mW/cm ²

▶ Swing Hinge square



High quality stainless steel hinge suitable for inset doors - a threaded pin in the hinge enables the door to be removed after bonding

i Mounting glass/glass
Door weight max. 10 kg
Packaging unit 2 items
Edge length 20 mm
Shape square

Art. No	Description
BO 5500281	Swing Hinge

▶ Glass Door Hinge Verifix® Clix



This hinge is a top quality stainless steel hinge for glass/glass mounting. Suitable for inset doors. It is adjustable in three dimensions and has a snap-on function for easy mounting and dismantling. Equipped with a self-closing spring mechanism, it is well suited for use with dampers BO 5500235/36.

Please be aware when opening the door that it swings approx. 30 mm to the inside. Trim shelves if necessary!

i Packaging unit 1 item
Glass thickness 6 - 8 mm
Opening angle 90 degrees
Maximum load capacity per pair 8 kg

Art. No	Description
BO 5206057	Glass Door Hinge Verifix® Clix

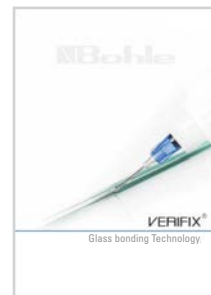
The complete range of UV-Bonding products

can be found in our online shop, along with diagrams, operating instructions etc., at www.bohle-group.com.



Further Information

You can find further information (diagrams etc.) in our glass bonding technology catalogue.



Bohle's UV bonding specialists are holding free training sessions for UV bonders of all levels during November 2017.

Introduction to UV Bonding (Level 1)

- Suitable for people who are interested in UV bonding
- An entry-level, 1-day course
- Practical demonstrations and participation - take your own bonded trophy home!
- Refreshments and lunch provided
- Level 1 Certificate of Attendance for each participant

NEW! Advanced UV Bonding seminar (Level 2)

- For those already UV bonding and/or those who have completed Level 1 training
- 4-5 hours with more in-depth insight Power point presentation, round table discussion and FAQs.
- Includes some practical participation
- Refreshments and lunch provided

Booking is essential as places are limited.

Visit www.bohle-group.com, email bizdev@bohle.ltd.uk or call 0800 616151 for more information.

Refresher courses are also available on request.

For details of 2018 courses, please contact us.

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