

**LIGHT WELD® 4-20564
ONE-PART UV CURING DOME COATING
(Formerly X-391-31-D)**

DESCRIPTION

Dymax Light Weld 4-20564 is a clear, rigid dome coating that cures in seconds upon exposure to longwave (365 nm) UV light. The clear coating has a high gloss, high profile dome with adhesion to metal, glass, and many plastics. Dymax 4-20564 is best suited to doming small labels and pens.

- **Clear, Hard, High-Profile Dome**
- **Slick, Abrasion Resistant Surface**
- **Fast Curing**
- **Resists Yellowing**

TYPICAL UNCURED PROPERTIES

Solvent Content	None	
Composition	100% Solids	
Appearance	Clear	
Solubility	Isopropyl alcohol, ketones, and chlorinated solvents	
Toxicity	Low	
Flash Point	>95°C (200°F)	
Density	1.0 kg/L (8.7 lbs/gallon)	
Viscosity (@ 20 rpm)	6,000 cP (nominal)	ASTM D-1084

TYPICAL CURED PROPERTIES

PHYSICAL

Durometer Hardness	D80	ASTM D-2240
Gardner Color	1	
Refractive Index	1.50	

TYPICAL CURE DATA

UV Light - Using 365 nm wavelength UV light ^[1]:

	<u>Cure Time</u>	<u>Intensity^[2] MW/cm²</u>	<u>Dymax Light-Welder® Lamps</u>
Coating Cures, stationary lamp	15 sec	150	5000-EC
Coating Cures, conveyor	>7 ft/min	350	UVC6/12002
Coating Cures, conveyor	>5 ft/min	1000	UVC6/F300
Nominal Cure Depth (0.25 inch)	30 sec	35	2000-EC

DISPENSING AND HANDLING ADHESIVE

Dymax 4-20564 is available in various packages such as syringes, cartridges, bottles, and pails. It may be dispensed with a variety of automatic bench-top syringe applicators or other equipment as required. Direct questions relating to dispensing and curing systems for specific applications to Dymax Technical Representatives.

Wear impervious gloves and/or barrier cream. Repeated or continuous skin contact with liquid adhesive will cause irritation and should be avoided. Do not wear absorbent gloves. Remove adhesive from skin with soap and water. Never use solvents to remove adhesive from skin or eyes.

STORAGE AND SHELF LIFE

Store material in cool dark place when not in use. Do not expose to UV light or sunlight. Material may polymerize upon prolonged exposure to ambient light. Replace lid immediately after use. Product has a one-year shelf life when stored below 90°F in the original, unopened container. Refrigerated storage may extend shelf life.

CAUTION

For industrial use only. Avoid breathing vapors. Avoid contact with eyes and clothing. In case of contact, immediately flush with water for at least 15 minutes; get medical attention. Wash clothing before reuse. Keep out of reach of children. Do not take internally. If swallowed, induce vomiting at once and call a physician. Repeated or continuous skin contact with liquid adhesive will cause irritation and should be avoided. For specific information, refer to the product Material Safety Data Sheet.

NOTES

- [1] Use of lamps that emit high levels of shortwave light (for example, more than 15% 200-300 nanometer UV light) are not recommended.
[2] Nominal intensity taken at a predetermined distance. This reading does not reflect the maximum intensity capabilities emitted from each unit.

intertronics

17 Station Field Industrial Estate
Banbury Road
KIDLINGTON
Oxfordshire, OX5 1JD
Tel: 01865 842842 Fax: 01865 842172
e-mail: enquiries@intertronics.co.uk
www.intertronics.co.uk

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