

DYMAX CORPORATION

PRELIMINARY PRODUCT DATA SHEET

4-20624 ULTRA LIGHT-WELD® ADHESIVE ONE-PART UV CURING LOW GLOSS COATING

DESCRIPTION

Dymax Ultra Light-Weld 4-20624 is a clear, low gloss coating that cures in seconds upon exposure to long wave UV/Visible light. The coating has a low viscosity for thin coating applications and resists many solvents. Ultra Light-Weld 4-20624 has good adhesion to plastics, metal, glass and decals. QUV tests suggest that 4-20624 may be suitable for most indoor and some outdoor applications. Users should thoroughly test 4-20624 for suitability in their application. Dymax 4-20624 is best suited to coating novelty items, such as knives and nameplates. Because 4-20624 is very shear sensitive, it dispenses more like a 100-cP coating than its 1,000 cP viscosity suggests.

Applications	Nameplates Knife Bodies Thin low gloss coating for plastics and metals
Benefits	Hard, Abrasion Resistant Surface Greater Productivity, Cures In Seconds Fewer Rejects, Lower Costs Faster Order Fulfillment Cycle, Shorter JIT Cycle 100% Automation Has Been Achieved (Dispense, Cure, Inspect & Package) Regain Floor Space, Eliminate Racks, Ovens, and Shuffling Parts No Two-Part Resin Waste or Disposal Costs Mercury-Free and Isocyanate-Free

TYPICAL UNCURED PROPERTIES (not specifications)

Solvent Content	None, Solvent-free	
Composition	100% Solids, Urethane acrylate	
Appearance	Clear	
Solubility	Isopropyl alcohol, ketones, and chlorinated solvents	
Toxicity	Low	
Flash Point	>95°C (200°F)	
Viscosity (@ 20 rpm)	1,000 cP (nominal)	ASTM D-2556

TYPICAL CURED PROPERTIES (not specifications)

Durometer Hardness	D85	ASTM D-2240
Tensile at Break	6,000 psi	ASTM D-638
Modulus of Elasticity	270,000 psi	ASTM D-638
Elongation	2%	ASTM D-638

CURE DATA

Using 365 nm wavelength UV light^[1]:

	Cure Time	Intensity ^[2] mW/cm ²	Dymax Light-Welder® Lamps
Coating Cures	20 sec	150	5000-EC
Coating Cures	8 ft/min	350	UVC6/12002
Coating Cures	15 ft/min	2,000	UVC6/F300
Nominal Cure Depth (0.12 inch)	10 sec	150	5000-EC

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4-20624, 5/2/2002

DISPENSING AND HANDLING ADHESIVE

Dymax 4-20624 is available in syringes, cartridges, bottles, and pails. It may be dispensed with a variety of automatic 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.

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] Do not recommend lamps that emit high levels of short wave light (for example, more than 15% 200-300 nm UV light). Fusion lamps should contain a D-bulb.
[2] Nominal intensity measured at a predetermined distance. This value is not the maximum intensity of the lamp.

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