

# DYMAX CORPORATION

## PRODUCT DATA SHEET

### 4-20630 ULTRA LIGHT-WELD® ONE-PART UV-CURABLE, ANTI-SKID DOME COATING

#### DESCRIPTION

Dymax Light Weld 4-20630 is a flexible dome coating that cures in seconds upon exposure to UV light. This clear coating has a high dome profile. 4-20630 was designed to coat decals up to 2" on polyester, foil, paper, glass, and wood. QUV tests suggests that 4-20630 may be suitable for most indoor and many outdoor applications. Users should thoroughly test 4-20630 for suitability in their application.

Applications	Clear Medium Dome Profile, Medium Decals (to 2") Soft Dome with Springs Back From Dents Suitable for Indoor and Some Outdoor Applications
Benefits	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 Waste or Disposal Costs Mercury-Free and Isocyanate-Free

#### TYPICAL UNCURED PROPERTIES (not specifications)

Solvent Content	None, 100% Reactive Solids	
Composition	Urethane Acrylate and Acrylate Blend	
Appearance	Clear Resin	
Solubility	Isopropyl Alcohol, Ketones, Chlorinated Solvents	
Toxicity	Low	
Flash Point	>93°C (200°F)	
Viscosity (20 rpm)	800 cP	ASTM D-1084

#### TYPICAL CURED PROPERTIES (not specifications)

Durometer Hardness	A-75	ASTM D-2240
Thermal Limit (brittle/degrades)	-60° to 150°C	
Linear Shrinkage	2.0%	ASTM D-2566
Water Absorption (24h)	0.7%	ASTM D-570

#### STARTING POINT CURE SCHEDULE

The larger and more flexible the substrate, the more difficult it is to produce a flat, clear dome. Flexible substrates require using two different lamps in series. Rigid substrates need only one lamp.

Substrate	Low Intensity Conditioning Lamp	Dymax Light-Welder Lamp
Flexible Decals and Foils	4 minutes, 365 nm blacklight	10-30 seconds, stationary lamp, 5000-EC or 5 ft/min, UVC6/5002 conveyor or 10 ft/min, UVC6/F300 conveyor
Rigid Metal, Glass, Wood, Plastic	No preconditioning lamp needed	25 seconds, stationary lamp, 5000-EC or 12 ft/min, UVC6/12002 conveyor or 10 ft/min, UVC6/F300 conveyor

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4-20630, 4/2002

### DISPENSING AND HANDLING ADHESIVE

Dymax 4-20630 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 the Dymax Technical Center at 860-482-1010.

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; and 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] Nominal intensity taken at a predetermined distance. This reading does not reflect the maximum intensity capabilities emitted from each unit.

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