

ULTRA LIGHT-WELD[®] RUGGEDIZING ADHESIVE

9-20790

INTRODUCTION

Dymax Ultra Light-Weld adhesives can be cured with UV or visible light. Ultra Light-Weld adhesives faster, deeper cures, increase productivity, lower assembly costs and enhance worker safety. When cured with Dymax Light-Welder[®] UV lamps, these adhesives provide optimum process flexibility. They allow the user to select the optimum combination of adhesive and cure mechanism to meet individual process and performance requirements.

DESCRIPTION

Ultra Light-Weld 9-20790 is solvent free. Lasting bonds form in seconds to both flexible and rigid substrates. Bond strength on polycarbonate and PVC usually exceed the strength of those substrates. DYMAX 9-20790 is highly thixotropic and ideal for applications where the material needs to retain its profile prior to curing.

TYPICAL UNCURED PROPERTIES

Solvent Content	None - 100% solids	
Composition	Urethane Oligomer/(Meth) Acrylate Monomer Blends	
Appearance	Clear/Light Amber Liquid	
Flash Point	>93°C (200°F)	
Solubility	Alcohols/Chlorinated Solvents/Ketones	
Toxicity	Low	
Refractive Index	1.478 (20°C)	
Density	1.05 g/mL	
Viscosity (20 rpm)	38,000 cP	ASTM D-2556

TYPICAL CURED PROPERTIES

PHYSICAL

Durometer Hardness	D55	ASTM D-2240
Tensile at Break	1,700 psi	ASTM D-638
Elongation at Break	175%	ASTM D-638
Water Absorption (24 h)	1.8%	ASTM D-570
Boiling Water Absorption (2 h)	1.3%	ASTM D-570

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TYPICAL LIGHT CURE DATA

Lamp	2000-EC	5000-EC	UVCS-12/F
Light Type Lamp Type	UV/VIS 8"x8" Flood	UV/VIS 5"x5" Flood	UV/VIS Conveyor
Intensity (mW/cm ²) at Peak Wavelength	70 @ 365 nm	275 @ 365 nm	2,500 @ 365 nm
Wavelength (nm) Working Range	300-500	300-500	300-500
Cure Speed (sec)			
Between Glass	1	1	Not Tested
1/8" Bead	<60	<30	Not Tested
Tack Free Surface Cure	N/A	45	Not Tested

DISPENSING THE ADHESIVE

This material 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, should be referred to the DYMAX Applications Engineering at (860) 482-1010.

STORAGE AND SHELF LIFE

Store the material in a cool, dark place when not in use. Do not expose to visible or UV light. This product may polymerize upon prolonged exposure to ambient light. Keep covered when not in use. This material has a one-year shelf life when stored between 10°C (50°F) and 32°C (90°F) in the original, unopened container.

CLEAN UP

Uncured material may be removed from dispensing components and parts with organic solvents. Cured material will be impervious to many solvents and difficult to remove. Clean up of cured material may require mechanical methods of removal.

GENERAL INFORMATION

This product is intended for industrial use only. Keep out of reach of children. Avoid breathing vapors. Avoid contact with skin, eyes, and clothing. Wear impervious gloves. Repeated or continuous skin contact with uncured material may cause irritation. Remove material from skin with soap and water. Never use organic solvents to remove material from skin and eyes. For more information on the safe handling of this material, please refer to the Material Safety Data Sheet before use.

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The data contained in this bulletin which represents typical results, is furnished for information only, and is believed to be reliable. We cannot assume responsibility for results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any product or method mentioned herein and to adopt such precautions as may be advisable for the protection of property and persons against any hazards that may be involved in the handling and use thereof. Nothing in this bulletin is to be interpreted as a representation of freedom from domination of patents owned by others or a license under a Dymax Corporation patent. We recommend that each prospective user test the proposed application before repetitive use, using the data as a guide. For specific information, refer to Material Safety Data Sheet before use.

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