

# DYMAX CORPORATION

## PRODUCT DATA SHEET

### FAST, TACKING ADHESIVES ULTRA LIGHT-WELD® 3095 SERIES

#### INTRODUCTION

DYMAX Ultra Light-Weld® structural adhesives can be cured with UV or Visible light. Ultra Light-Weld's faster, deeper cure, increases productivity, lowers assembly costs and enhances 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 3095 Series are designed for the fastest bonding, tacking, and sealing possible with photocurable adhesives. Solvent-free, visible and UV curing adhesives, 3095 Series dispense easily and cure "on demand" for precise bonding and placement of components. Excellent adhesion to common PCB substrates, fabric and other porous surfaces, and their shock absorbing capabilities makes them excellent choices for a variety of potting and tacking applications.

#### TYPICAL UNCURED PROPERTIES (not specifications)

Solvent Content		None - 100% Reactive Solids	
Chemical Class		Urethane (Meth) Acrylate	
Appearance		Straw	
Solubility		Alcohols/Chlorinated Solvents/Ketones	
Toxicity		Low	
Flash Point		>95°C (200°F)	
Viscosity (20 rpm)	3095-LV	1,200 cP (nominal)	ASTM D-1084
	3095	2,500 cP (nominal)	ASTM D-1084
	3095-T	6,400 cP (nominal)	ASTM D-2556
	3095-Gel	25,000 cP (nominal)	ASTM D-2556

#### TYPICAL CURED PROPERTIES (not specifications)

##### PHYSICAL

Durometer Hardness	D65	ASTM D-2240
Elongation at Break	20%	ASTM D-638
Tensile at Break	2,600 psi	ASTM D-638
Modulus of Elasticity	100,000 psi	ASTM D-638
Water Absorption (24 h)	5.0%	ASTM D-570
Boiling Water Absorption (2 h)	5.0%	ASTM D-570

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3095 SERIES, 03/31/04

### TYPICAL LIGHT CURE DATA

Lamp	2000-EC	5000-EC	CureSpot 50	BlueWave™ 200
Light Type Lamp Type	UV Flood	UV Flood	UV Spot	UV Spot
Maximum Intensity (mW/cm <sup>2</sup> )	50	250	4,000	20,000
Intensity Taken at Time of Test (mW/cm <sup>2</sup> )	35	150	2,500	12,000
Measured at Peak Wavelength	365nm	365nm	365nm	365nm
Wavelength (nm) Working Range	300-500	300-500	300-500	300-500
Cure Speed (seconds)				
Between Glass	<1	<1	<1	<<1
1/8" Bead	20-30	10-15	1-3	1
Surface Cure	30	15	2	1
Cure Depth in 1 Minute (inch)	0.33	0.33	0.35	0.4

### DISPENSING AND HANDLING ADHESIVE

DYMAX 3095 Series adhesives are available in various packages such as syringes, cartridges, bottles, and pails. They 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 a 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. Products have 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.

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