

Ultra Light-Weld® 3-20741

DESCRIPTION

DYMAX® Ultra Light-Weld® 3-20741 is a solvent-free, UV/Visible curable adhesive. It is a clear, flexible adhesive specifically designed for bonding a variety of plastics such as PET, R-PET, PVC, etc. Ultra Light-Weld adhesive 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.

TYPICAL UNCURED PROPERTIES (not specifications)

Solvent Content	None - 100% Reactive Solids	
Chemical Class	Urethane (Meth) Acrylate	
Appearance	Light straw, clear, liquid	
Solubility	Alcohols/Chlorinated Solvents/Ketones	
Toxicity	Low	
Flash Point	>95C (200F)	
Viscosity (20 rpm)	1250 cP (nominal)	ASTM D-1084

TYPICAL CURED PROPERTIES (not specifications)

PHYSICAL

Peel Strength	26 lb/in (465 g/mm)	ASTM D-903
Durometer Hardness	A75	ASTM D-2240
Elongation at Break	200%	ASTM D-638
Modulus of Elasticity	2,500 psi	ASTM D-638
Water Absorption (24 h)	10.6%	ASTM D-570
Boiling Water Absorption (2 h)	11.6%	ASTM D-570
Thermal Limit (brittle/degrades)	-55 to 180C (-65/+350F)	DSTM D-200*
Linear Shrinkage	1%	ASTM D-2566

*DSTM refers to DYMAX Standard Test Method

TYPICAL CURE DATA

Lamp	2000-EC	5000-EC
<u>Light Type</u>	UV	UV
<u>Lamp Type</u>	Flood	Flood
Intensity (mW/cm ²) at Peak Wavelength	50 @ 365 nm	200 @ 365 nm
Wavelength (nm) Working Range	300-500	300-500
Cure Speed Between Glass (0.25" cure depth)	<1 sec	<1 sec

DISPENSING AND HANDLING ADHESIVE

Ultra Light-Weld[®] 3-20741 adhesive 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. 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. Product has a one-year shelf life when stored below 32°C (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's Material Safety Data Sheet.