



ISO-9001-2015 Certified

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TECHNICAL BULLETIN

SetWORX™ UV-35G EPOXY/UV HYBRID ADHESIVE

SETWORX™ UV-35G is a clear epoxy adhesive and encapsulating compound designed for electronic, optical, medical, and general industrial applications. Once mixed, UV-35G will polymerize and gel instantaneously upon exposure to UV light reducing fixture time to seconds. Once gelled, UV-35G will continue to cure at room temperature or at elevated temperature until fully cured. This epoxy system has 2 to 1 mixing ratio by volume and is available in easy to use dual cartridge systems.

TYPICAL HANDLING PROPERTIES:

| | | |
|--|--|-------------|
| Color | | |
| Resin (PART-A) | | Clear |
| Hardener (PART-B) | | Clear |
| Viscosity (25°C), cps | | 4,000-7,000 |
| Mix Ratio (Resin/Hardener) | | |
| by weight | | 2:1 |
| by volume | | 2:1 |
| Pot Life at 25°C (20 grams), minutes | | 60-70 |
| Recommended Light: 250-350 mW, 320-365nm | | |
| Recommended Cure: 6-8 sec light exposure + 1 hr/65°C | | |
| Alternate Cure: 1 hr/65°C or 24 hr/25°C | | |

TYPICAL CURED PROPERTIES:

| | |
|---|--------------------|
| Color | Clear |
| Specific Gravity | 1.1 |
| Hardness, Shore D | 86 |
| Lap Shear Strength to Aluminum, psi | 3000 |
| T-peel strength to aluminum (5-8mil bondline) | 30 |
| Service Temperature range, °C | -55 to 120 |
| Glass Transition Temperature, °C | 70 |
| Coefficient of Linear Thermal Expansion, 10 ⁻⁶ /°C | |
| Below Tg | 77 |
| Above Tg | 195 |
| Dielectric Strength, Volts/mil | 500 |
| Dielectric Constant, 1 kHz | 4.28 |
| Dissipation Factor, 1 kHz | 0.4 |
| Volume Resistivity, ohm-cm | 2x10 ¹⁵ |

INSTRUCTIONS FOR USE:

To use simply insert the cartridge into the application gun and start the plunger into the cylinders using light pressure on the trigger. Next, remove the cartridge cap and expel a small amount of adhesive to be sure both sides are flowing evenly and freely. If automatic mixing of resin and hardener is desired, attach the mixing nozzle to the end of the cartridge and begin dispensing the adhesive. For hand mixing, expel the desired amount of the adhesive and mix thoroughly. Mix approximately 15 seconds after uniform color is obtained.

FOR INDUSTRIAL USE ONLY:

These materials are intended for industrial use only, and the practices of good housekeeping, safety and cleanliness should be followed before, during and after use.

WARNING!

Although the system contains low volatility materials, care should be taken in handling. Adequate ventilation of work place and ovens is essential. These materials may cause injury to the skin following prolonged or repeated contact and dermatitis in susceptible individuals. In case of skin contact, wash thoroughly with soap and water. For eyes, flush immediately with plenty of water for at least 10 minutes and seek medical attention. Refer to Material Safety Data Sheet for additional health and safety information.

STORAGE & SHELF LIFE:

Product shall be ideally stored in a dry location in unopened containers at a temperature between 20°C to 28°C unless otherwise labeled. The shelf life of these materials is 12 months when stored in unopened containers at an average temperature of 25°C.

DISCLAIMER: All data given here is offered as a guide to the use of these materials and not as a guarantee of their performance. The user should evaluate their suitability for own purposes. Properties are typical and should not be used in preparing specifications. Statements are not to be construed as recommendations to infringe any patent.