CURE GUIDE FOR LIGHT ACTIVATED EPOXIES

FLASHBOND™	320	365	405
UV-2910DC	-	+	++
UV-5608DC	-	+	++
UV-8701E	-	+	++
UV-8300LV	-	+	++
UV-3700F	-	++	+
UV-5402	-	+	++
UV-8504E	++	+	-
UV-6502CL	+	++	-
UV-8311	++	+	-

++ especially suitable + suitable *pre-activation possible # heat post cure possible at 150°C

Values stated herein represent typical values as not all tests are run on each lot of material produced. For formalized product specifications or specific product end uses, contact the Customer Support Center.

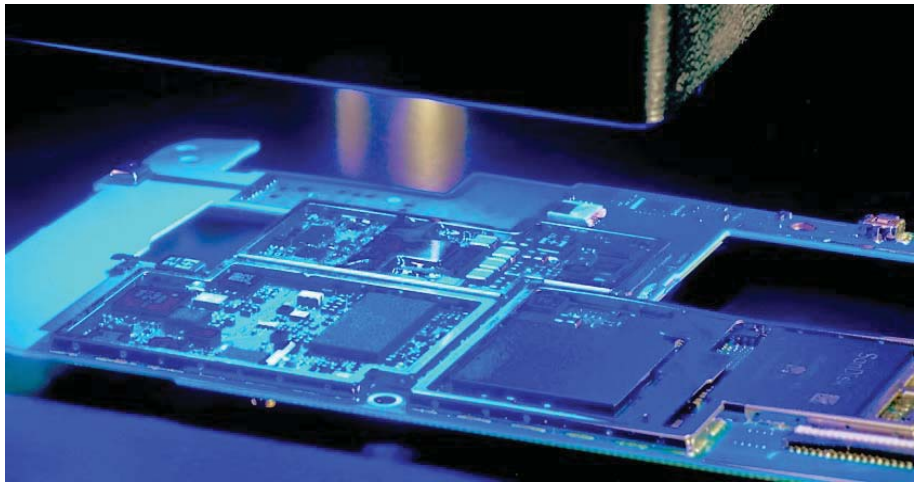
Information provided herein is based upon tests believed to be reliable. In as much as Epoxyset Inc. has no control over the manner in which others may use this information, it does not guarantee the results to be obtained. In addition, Epoxyset Inc. does not guarantee the performance of the product or the results obtained from the use of the product or this information where the product has been repackaged by any third party, including but not limited to any product end-user. Nor does the company make any express or implied warranty of merchantability or fitness for a particular purpose concerning the effects or results of such use.

Epoxyset Inc.

718 Park East Drive
Woonsocket, RI 02895 USA

Ph: +1 (401) - 726-4500
Email: info@epoxyset.com

Rev. 04 Dec. 2019



SELECTOR GUIDE

FLASHBOND™

EPOXY ADHESIVES

UV-CURING · LIGHT CURING · LIGHT ACTIVATED · LIGHT/HEAT CURING

Product	[1]UV-2910DC	[1]UV-5608DC	UV-8701E	UV-8300LV	UV-3700F	UV-5402	UV-8504E	UV-6502CL	UV8311
Application **B=bonding, S=sealing, C=coating**	B/S/C	B/S/C	B/S/C	B/C	B/S	B/S/C	B/S	B/S/C	B/S/C
Featured Properties	Delay Cure, high strength	Delay Cure, higher Tg	Color indicator, High Tg	Low Viscosity, High Tg	High Viscosity, filled, Low CTE	Flexible, low durometer, Low viscosity	Low viscosity, high Tg, low shrinkage	Remains ultra clear through thermal aging	Fast cure, high hardness
Color (cured/uncured)	Clear/Clear	Clear/Clear	Magenta/Opaque	Clear/Clear	White/White	Opaque/Opaque	Clear/Amber Clear	Clear/Clear	Clear/Amber Clear
Viscosity, cps	2800	5500	5800	2500	25000	3700	700	300	1000
Density, g/ml	1.12	1.14	1.14	1.14	1.50	1.14	1.12	1.12	1.12
Optimal Curing Conditions	365 or 405nm 150 mW/cm^2	365 or 405nm 150 mW/cm^2	365-405nm 100-200 mW/cm^2	365-405nm 100-200 mW/cm^2	365-405nm 250-350 mW/cm^2	365-405nm 150-300 mW/cm^2	315-365 100-300 mW/cm^2	315-365 100-300 mW/cm^2	315-365 100-300 mW/cm^2
[2]Pre-activation time , sec **LED 405nm, 150mW/cm^2**	6-8	6-8	-	-	-	-	-	-	-
Minimum Irradiation time, sec			5	5	10	10	30	8	10
Recommended irradiation time, sec			12	12	20	20	60	20	20
Maximum curing thickness, mm	2	2	2	3	2	2	3	3	3
[3]Tensile Lap Shear Strength, psi	2500	2500	2200	2000	2200	1200	1800	2500	2000
Elongation, %	3	3	1	1	1	45	6	5	5
Shore Hardness	D-75	D-78	D-78	D-78	D-80	D-30	D-80	D-82	D-82
Glass Transition Temperature (T_g)	45°C	81°C	135°C	135°C	138°C	30°C	125°C	135°C	125°C
Operating Temperature, °C	-55 - 150	-55 - 175	-55 - 200	-55 - 200	-55 - 200	-75 - 125	-55 - 200	-55 - 200	-55 - 200
CTE, ppm/°C (α_1/α_2)	65/180	65/180	69/150	65/180	40/150	80/220	70/180	70/180	70/180
Refractive Index **(Cured,, @589nm, 20°C)**	1.58	1.58	1.57	1.57	NA	1.58	1.57	1.51	1.57
Water Absorption, % **(24 hr submersion at 25°C)**	0.3	0.1	0.2	0.2	0.1	0.4	0.2	0.2	0.2
Volume Resistivity (Ω/cm)	>1 x 10^{14}	>1 x 10^{14}	>1 x 10^{14}	>1 x 10^{14}	>1 x 10^{14}	>1 x 10^{14}	>1 x 10^{14}	>1 x 10^{14}	>1 x 10^{14}

1. UV-5608DC & UV-2910DCcan be pre-activated with the recommended conditions and left to cure at room temperature or with slightly elevated heat. Open time once activated is 45-60 seconds. Halogen Free versions available upon request.
2. Pre-activation only possible on UV-5608DC & UV-2910DC.
3. Tested on G-10 glass epoxy substrates cured under recommended conditions.

Minimum irradiation time, recommended irradiation time, and intensities were tested internally at Epoxyset labs using Epoxyset equipment. As there may be variation among equipment, it is recommended to evaluate best curing process for each application before use.