

UV Light Curing Lens-Bonding Adhesives

Precision Bonding, Mounting, and Fixturing

DYMAX OP Series of optically clear, high-strength, low-stress optical assembly adhesives cures in seconds upon exposure to UV/Visible light. DYMAX optical adhesives are single component, low outgassing, low shrinkage, and have a gap filling capability to ¼ inch or more, as well as long room-temperature shelf life. UV-curing optical adhesives are ideal for applications such as lens mounting, fiber optic bonding and splicing, lens laminating, optoelectronic assembly, and the attachment of ceramic, glass, quartz, metal, and plastic components.



Lens Curing



Lens Positioning

FEATURES and BENEFITS

- Higher strength with low stress
- Low shrinkage/no movement
- Environmentally resistant
- Fast UV/Visible curing
- Low odor
- Single component, no mixing is required
- Cure only when exposed to light
- Room temperature storage
- Low outgassing
- Gap filling to 6.4 mm [0.25 in] or more
- No VOCs

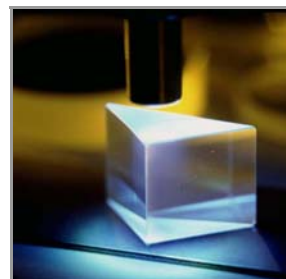
DYMAX offers a complete line of high-performance UV adhesives and light curing equipment for optical applications for the industrial, commercial, medical, military, aerospace, and electro-optical markets. With a library of over 3,000 formulations, we can match adhesive characteristics to particular application needs. Over 25 years of experience in this industry has led to a superior product line of adhesives, applicators, and UV-curing sources.



Diode Curing



Lens Bonding



Prism Curing



Lens Laminating

Want to learn more?

Visit www.dymax.com to register to download the white paper *"Advances in Light-Curing Adhesives"*

Product Selector Guide

Products	Characteristics	Recommended Substrates			Additional Uses			ASTM D542
		Metal	Glass	Plastic	Doublets	Lens Mounting	Fiber Optic Splicing	Refractive Index (cured)
Doublet (glass to glass) Bonding/Excellent Transmission								
OP-29*	Multi-purpose	✓	✓	✓	✓	✓	✓	1.504
OP-29V*	Multi-purpose, visible light curing	✓	✓	✓	✓	✓	✓	
OP-29V-Gel	Multi-purpose, visible light curing	✓	✓	✓	✓	✓	✓	
OP-30*	Low stress, flexible, multi-purpose; visible light curing	✓	✓		✓	✓	✓	1.507
OP-21* OP-21G	Multi-purpose plastic bonder; high viscosity		✓ ✓	✓ ✓	✓ ✓	✓ ✓		1.501
Lens, Prism, Optic Mounting								
OP-29V*	Multi-purpose; visible light curing	✓	✓	✓	✓	✓	✓	1.504
OP-30*	Low stress; flexible; multi-purpose	✓	✓		✓	✓	✓	1.507
OP-61-LS*	Metal/glass bonding; low shrinkage, low outgassing for alignment stability	✓	✓			✓		White Opaque
OP-67-LS	Low shrinkage for alignment stability	✓	✓	✓		✓		Beige Opaque
OP-24-Rev.B (501-E)	Multi-cure; UV/light/heat/activator; tack and bond with UV or with heat or activator where light won't reach	✓	✓			✓		1.502
Flexible Laminating								
OP-40	Eyeglass lens laminating; potting in metal mounts; glass/metal, CR-39	✓	✓	✓				1.495
OP-44	Plastic sunglass lens laminating; bonds to PVA, CR-39 & CAP		✓	✓				1.477
OP-45	Flexible lens bonder; provides UV blocking to 410 nm.		✓	✓				1.478
Fiber Optic Adhesives								
OP-52	Medium viscosity grade for butt bonding, bundling and splitting	✓	✓				✓	1.520
OP-54*	Low viscosity wicking grade for butt bonding, bundling and splitting	✓	✓				✓	1.506
Temporary Fixturing								
OP-18	Temporary fixturing; peels off easily; replaces tape, waxes for blocking or fixturing	✓	✓	✓		✓		1.501
OP-19 OP-19G	Water soluble for temporary fixturing and polishing	✓	✓	✓	✓	✓		N/A

*Available in Adhesive Assortment Kit. Cyanoacrylates are available upon request. See Product Data Sheets for curing suggestions.

Typical Adhesive Properties

Products	Viscosity (cP)	Linear Shrinkage	Durometer (hardness)	ASTM E595-77 Outgassing Data 85°C at 5x10 ⁶ Torr for 24 hours TWL ¹ /CVCM ²	ASTM D638 Adhesive Film % Elongation	ASTM D638 Adhesive Film Tensile (psi)	ASTM D638 Adhesive Film Modulus (psi)	DSTM 251 Lap Shear glass-to-glass compression/**tensile (psi)	DSTM 251 Lap Shear glass-to-metal compression/**tensile (psi)	ASTM D-1002 Lap Shear steel-to-steel tensile (psi)
Doublet (glass to glass) Bonding/Excellent Transmission										
OP-29* OP-29V* OP-29V-Gel	2,500 2,500 110,00	2.8%	D60	3.66% 0.25%	120%	3,000	35,000	2,300	1,700	2,100 [‡]
OP-30*	300	2.3%	D25	nm	100%	900	3,000	925	600	1,200
OP-21* OP-21G	600 25,000	2.7%	D55	nm	175%	1,700	26,000	1,200 **2,700 (Polycarbonate)	900 **1,400 (Acrylic; PMMA)	900 [‡]
Lens, Prism, Optic Mounting										
OP-29V*	2,500	2.8%	D60	nm	120%	3,000	35,000	2,300	1,700	2,100 [‡]
OP-30*	300	2.3%	D25	nm	100%	900	3,000	925	600	1,200
OP-61-LS*	60,000	<0.1%	D85	1.22% <0.02%	0.4%	7,300	2,000,000	3,800	nm	nm
OP-67-LS	135,000	<0.1%	D80	nm	6.5%	4,000	83,000	nm	nm	nm
OP-24-Rev.B (501-E)	800	3.7%	D80	5.2% 0.04%	35%	5,200	320,000	4,000	5,000	2,900
Flexible Laminating										
OP-40	135	3.4%	D40	nm	160%	1,300	3,000	1,950	1,330	2,200 [‡]
OP-44	190	2.9%	D65	nm	62%	2,300	23,000	2,900	nm	nm
OP-45	1,200	3.2%	A20	nm	150%	325	19,000	702	nm	nm
Fiber Optic Adhesives										
OP-52	5,000	1.9%	D85	3.72% 0.05%	4.5%	11,000	500,000	800	3,000	3,200 [‡]
OP-54*	100	1.8%	D82	nm	3%	7,500	500,000	2,900	570	3,100 [‡]
Temporary Fixturing										
OP-18	48,000	2.0%	A75	N/A	100%	500	850	N/A	N/A	300 [‡]
OP-19 OP-19G	6,000 20,000	N/A	D70	N/A	100%	N/A	N/A	N/A	N/A	N/A

N/A = data not applicable nm = data not measured 1 TWL=Total Weight Loss 2 CVCM = Volatile Condensable Material

[‡] = These products are commercially available for UV/Visible light curing only. Test data for comparative purposes via ASTM D-1002 was achieved by addition of a thermal initiator for activator and heat cure (15 minutes at 130°C [270°F]).

UV Light Curing Systems for Optical Adhesives

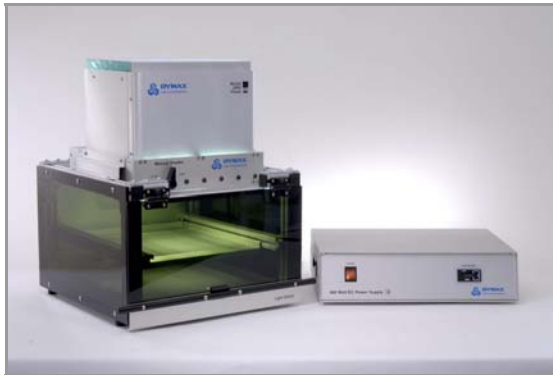
Tired of short storage and shelf life, of mixing two components, and waiting for adhesives to thaw? DYMAX UV light curing adhesives and systems cure completely in seconds. **Make automation easier!**



DYMAX BlueWave® 200 UV Curing Spot Lamp with patent-pending intensity adjustment feature provides high-intensity UV/Visible light in a concentrated area. Ideal for integration with automated equipment and multiple-output lightguides. **CE Marked.**



DYMAX BlueWave® 50 AS UV Curing Spot Lamp Shown with single lightguide and lightguide stand provides curing efficiency, low operating cost, and an auto-switching power supply to neutralize the effects of variations in line voltage.



DYMAX 2000 UV Curing Flood Lamp System Shown with Light Shield protective enclosure and manual shutter. Ideal for single-component or batch-curing processes requiring moderate intensity and an 8" x 8" (20.3 cm x 20.3 cm) cure area. **CE Marked.** PC Series Flood Systems available for European production facilities.



DYMAX 5000 UV Curing Flood Lamp System Shown with Light Shield protective enclosure and ZIP™ shutter. Ideal for single-component or batch-curing processes requiring moderate intensity and a 5" x 5" (12.7 cm x 12.7 cm) cure area. **CE Marked.** PC Series Flood Systems available for European production facilities.

For further assistance with adhesive and equipment selection, contact your DYMAX Applications Engineer.



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