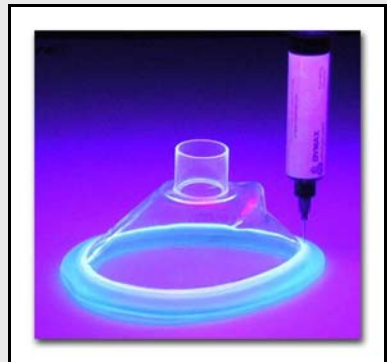
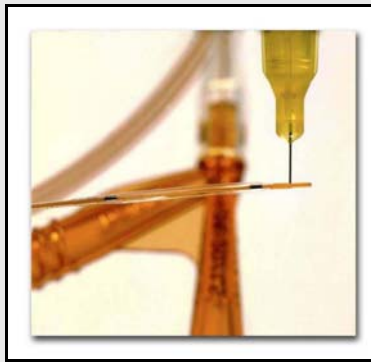
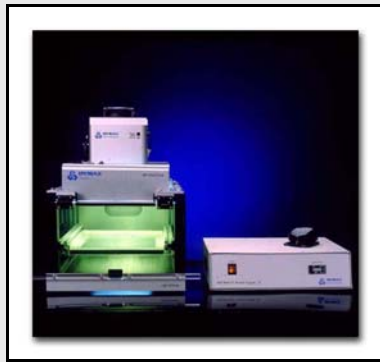
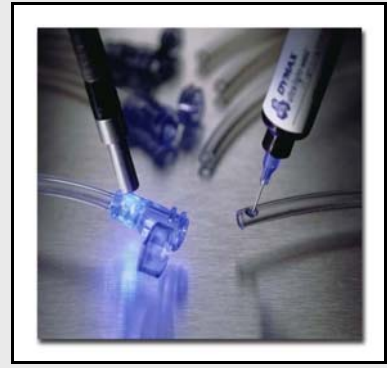
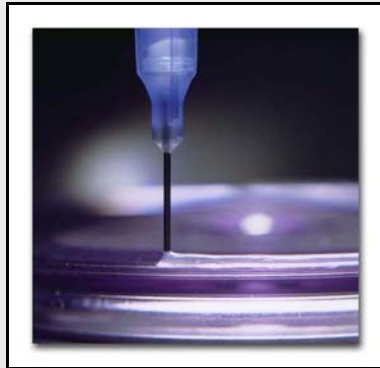


DYMAX UV Light-Curing Medical Device Adhesives



PROPERTIES*	1-CN003	1-CN004	1-CN005	1-CN006	1-CN007-F	1-CN009	1-CN011	1-CN012	1-CN013
Bondable Substrates Include:	Stainless Steel, Aluminum, Glass, PA, PMMA, PS, SAN	ABS, PC, PS, PVC, Stainless Steel	PC, PVC, PU, ABS, PS, Stainless Steel	PC, PVC, PU, ABS, PET	PC, PVC, PMMA, PU, ABS, Stainless Steel	PC, PVC, ABS, Stainless Steel, Glass	PC, PVC, PU, PA, PMMA, ABS	Surface Treated Silicone (platinum & peroxide cured), PC, PI, PPO, PVC, PU	PVC, TPE, PU, PS, ABS
Features	High strength; impact resistant; secondary thermal cure capability	Low shrink; low stress plastic bonder	Multi-purpose; moisture resistant	Flexible plastic bonder	Multi-purpose plastic and metal bonder	Low shrinkage	Flexible adhesive for multiple substrates	Very flexible	Flexible TPE bonder
Applications	Needle bonding; metal bonding	Needle bonding	Needle, reservoir, transducer assembly; medical potting	Reservoir bonding; tube sets & fittings, face masks	Tube sets & fittings; reservoirs; needle bonding	Needle bonding	Tube set & fittings, metal to plastic, plastic assembly	Tube set & fittings, face masks	Tube set & fittings, face masks
Fluorescing (U.S. Patent 6,080,450)	Yes	Yes	Yes	Yes	Yes	Yes	Yes	No	Yes
ISO 10993 – 5 Cytotoxicity	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Yes
Viscosities (cP and mPas) Brookfield 25°C	600	90	135	450	300	200	300	1,300	280
Durometer Hardness	D76	D75	D70	D55	D70	D75	D55	D30	D50
Tensile at Break , MPa [psi]	30 [4,300]	18 [2,600]	17 [2,500]	17 [2,400]	16 [2,300]	15 [2,100]	9.0 [1,300]	5.2 [750]	6.0 [
Elongation at Break , %	10	46	66	170	68	140	230	140	200
Modulus of Elasticity , MPa [psi]	620 [90,000]	380 [55,000]	330 [48,000]	170 [25,000]	280 [40,000]	390 [57,000]	68 [9,800]	5.0 [730]	70 [10,000]
Linear Shrinkage , %	1.2	0.4	0.8	2.0	0.6	0.4	0.3	1.0	0.5
CURE DATA									
Fixture Time: (0.05 mm) 0.002 Inch Depth (in seconds) Between Glass									
DYMAX BlueWave® 200 Spot Lamp (3,700 mW/cm ²)**	1.6 s	<1 s	0.2 s	0.2 s	<0.2 s	<0.2 s	0.2 s	1 s	<1 s
DYMAX 5000-EC Flood Lamp (150 mW/cm ²)***	1 s	<1 s	<2 s	<1 s	<1 s	<1 s	<1 s	1 s	<0.2 s
DYMAX UVC-6 Conveyor w/Fusion "D" bulb (2,500 mW/cm ²)****	27 fpm	>27 fpm	>27 fpm	>27 fpm	>27 fpm	>27 fpm	>27 fpm	27 fpm	27 fpm

*Customized adhesives and viscosities may be available upon request.

**3,700 mW/cm² measured 3/8" away from lightguide. Intensity at end of lightguide is 19,000 mW/cm². Measured by ACCU-CAL™ 50 radiometer.

***150 mW/cm² measured 2.5" below bottom of lamp housing. Measured by ACCU-CAL™ 50 radiometer.

****2,500 mW/cm² measured by EIT Power Puck radiometer 2.1" below lamp housing.



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