



APTEK LABORATORIES, INC.

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TECHNICAL DATA & INFORMATION

UVIBOND™ 7100

Semi-rigid, UV-Curing Urethane Adhesive

PRODUCT DESCRIPTION

UVIBOND™ 7100 is an unfilled, one component, electrically insulating, transparent, semi-rigid urethane adhesive designed for bonding polycarbonate, ABS, glass and other various substrates.

UVIBOND™ 7100 is fully curable when exposed to the proper UV light radiation.

KEY FEATURES AND BENEFITS

- U.V. curable for extremely fast production output.
- Semi-rigid for high strength bonds with a degree of flexibility
- Low viscosity for easy handling and substrate wetting
- Low ionic impurities for electrical/electronic applications.
- Thixotropic version available for doming and staking applications designated as APTEK 97034

HANDLING INFORMATION

UVIBOND™ 7100 is a room temperature stable system. However, unlike conventional urethane systems, needs an oxygen/air environment to maintain stability. After opening factory sealed containers DO NOT PURGE with dry nitrogen or argon before resealing. Also, do not fill containers to top before resealing - leave approximately 15% of air space.

CURE SCHEDULE

Two passes under Fusion systems "D" bulb (300 W/in) at rate of 5 feet per min. Bulb height above coating surface should be adjusted to expose the coating to approximately 1.30 joules/cm² of radiation per pass.

The above cure schedule is typical for flat surfaces. Adjustments to the cure schedule may be necessary depending on the application, shape of surface, bulb type and wattage, etc. Customer should perform sufficient testing to determine completeness of cure for each application.

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TYPICAL PROPERTIES
(not for specification purposes)

<u>CHARACTERISTICS</u>	<u>UVIBOND™ 7100</u>	<u>TEST METHOD</u>
Color	Clear pale yellow green	Visual
Specific Gravity	1.01	ASTM D-1475
Viscosity @25°C,cps	4000	ASTM D-1824
Shelf life, months @25°C, in factory sealed containers	3*	JMTP C-100
Hardness, Durometer A (taken one hr. after U.V. exposure, 1/16" casting)	95	ASTM D-2240

* Study in progress to determine if shelf life can be extended.

SAFETY AND FIRST AID

UVIBOND™ 7100 is an unfilled blend of urethane oligomers and various acrylated monomers which are generally considered safe for use. No ingredients used are suspected or known carcinogens. As with all chemicals use these systems in well-ventilated areas and avoid breathing vapors.

In case of eye contact, flush with fresh clean water for at least 15 minutes; for skin contact, wash thoroughly with soap and water. If swallowed drink at least one pint of water and call a physician.