

21 September 2004

ACRYLIC & POLYCARBONATE HEADLAMP ADHESIVE ULTRA LIGHT-WELD[®] 3-20469

DESCRIPTION

Ultra Light-Weld[®] 3-20469 adhesive rapidly bonds acrylics, polycarbonate, and metallized plastic substrates with UV/Visible light. The visible light curing ability allows it to cure through UV-blocked plastics. Due to its high strength and toughness, bonds generally exceed the strength of substrates bonded. 3-20469 is a field-proven adhesive that has been used on over 10 million vehicles.

TYPICAL UNCURED PROPERTIES (not specifications)

Solvent Content	None - 100% reactive solids	
Chemical Class	Urethane (Meth) Acrylate	
Appearance	Clear	
Solubility	Alcohols/Chlorinated Solvents/Ketones	
Toxicity	Low	
Flash Point	>95°C (200°F)	
Viscosity (20 rpm)	10,000 cP	ASTM D-2556

TYPICAL CURED PROPERTIES (not specifications)

Headlamp Performance Tests	Pass	Ford WSS-M11P28-B2
Polycarbonate Tongue & Groove Laps		
Initial Strength	2,100 psi	Ford WSS-M11P28-B2
Salt Spray, 500 h, wet pull	1,550 psi	Ford WSS-M11P28-B2
4 Thermal cycles, 88°/-30°C	1,550 psi	Ford WSS-M11P28-B2
Durometer Hardness	D60	ASTM D-2240
Elongation at Break	100%	ASTM D-638
Tensile at Break	5,000 psi	ASTM D-638
Boiling Water Absorption (2 h)	8%	ASTM D-570
Thermal Range (brittle/degrades)	-55° to 175°C (-65°/+350°F)	DSTM D-200*

*DSTM Refers to DYMAX Standard Test Method

TYPICAL CURE DATA

Curing Lamp	2000-EC	5000-EC
Light Type	UV	UV
Lamp Type	Flood	Flood
Intensity (mW/cm ²) at 365 nm	50	150
Wavelength (nm) Working Range	300-500	300-500
Cure Speed (sec)		
Between Glass Slides	1	1
1/8" Bead	7	3
Cure Depth in 1 Minute (inch)	3/16	9/16

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DISPENSING AND HANDLING ADHESIVE

Dymax 3-20469 is available in various packages such as syringes, cartridges, bottles, and pails. It may be dispensed with a variety of automatic bench-top syringe applicators or other equipment as required. Direct questions relating to dispensing and curing systems for specific applications to Dymax Technical Representatives at 860-482-1010.

Wear impervious gloves and/or barrier cream. Repeated or continuous skin contact with liquid adhesive will cause irritation and should be avoided. Do not wear absorbent gloves. Remove adhesive from skin with soap and water. Never use solvents to remove adhesive from skin or eyes.

STORAGE AND SHELF LIFE

Store material in a cool, dark place when not in use. Do not expose to UV light or sunlight. Material may polymerize upon prolonged exposure to ambient light. Replace lid immediately after use. Product has a one-year shelf life when stored below 90°F in the original, unopened container.

CAUTION

For industrial use only. Avoid breathing vapors. Avoid contact with eyes and clothing. In case of contact, immediately flush with water for at least 15 minutes; get medical attention. Wash clothing before reuse. Keep out of reach of children. Do not take internally. If swallowed, induce vomiting at once and call a physician. Repeated or continuous skin contact with liquid adhesive will cause irritation and should be avoided. For specific information, refer to the product Material Safety Data Sheet.

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