

Ultra Light-Weld® 3-20741

APPLICATIONS

- Plastic Bonding

FEATURES & BENEFITS

- UV/Visible Light Cure
- Flexible

RECOMMENDED SUBSTRATES

- PET
- R-PET
- PVC

Dymax Ultra Light-Weld® 3-20741 is a solvent-free, UV/Visible curable adhesive. It is a clear, flexible adhesive specifically designed for bonding a variety of plastics such as PET, R-PET, PVC, etc. Ultra Light-Weld adhesive faster, deeper cures increase productivity, lower assembly costs and enhance worker safety. When cured with Dymax light-curing spot lamps, focused-beam lamps, or flood lamps, they deliver optimum process flexibility. They allow the user to select the optimum combination of adhesive and cure mechanism to meet individual process and performance requirements.

UNCURED PROPERTIES *		
Property	Value	Test Method
Solvent Content	None - 100% Reactive Solids	N/A
Chemical Class	Urethane (Meth) Acrylate	N/A
Appearance	Light Straw, Clear, Liquid	N/A
Solubility	Alcohols/Chlorinated Solvents/Ketones	N/A
Toxicity	Low	N/A
Flash Point	>95°C (200°F)	N/A
Viscosity, cP (20 rpm)	1,250 (nominal)	ASTM D1084

TYPICAL CURE DATA		
Lamp	2000-EC	5000-EC
Light Type	UV	UV
Lamp Type	Flood	Flood
Intensity at Peak Wavelength, mW/cm ²	50 @ 365 nm	200 @ 365 nm
Wavelength Working Range, nm	300-500	300-500
Cure Speed Between Glass (0.25" cure depth)	<1 sec	<1 sec

CURED MECHANICAL PROPERTIES *		
Property	Value	Test Method
Peel Strength, lb/in [g/mm]	26 [465]	ASTM D903
Durometer Hardness	A75	ASTM D2240
Elongation at Break, %	200	ASTM D638
Modulus of Elasticity, MPa [psi]	17 [2,500]	ASTM D638

OTHER CURED PROPERTIES *		
Property	Value	Test Method
Boiling Water Absorption, % (2 h)	11.6	ASTM D570
Water Absorption, % (24 h)	10.6	ASTM D570
Thermal Limit (Brittle/Degrades)	-55 to 180°C (-65/+350°F)	DSTM 200‡
Linear Shrinkage, %	1	ASTM D2566

* Not Specifications

N/A Not Applicable

‡ DSTM Refers to Dymax Standard Test Method

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3-20741 Preliminary Product Data Sheet**DISPENSING THE ADHESIVE**

Ultra Light-Weld[®] 3-20741 adhesive 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. Direct questions relating to dispensing and curing systems for specific applications to the Dymax Application Engineering.

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. This material has a 12-month shelf life from date of manufacture, unless otherwise specified, when stored between 10°C (50°F) and 35°C (90°F) in the

GENERAL INFORMATION

This product is intended for industrial use only. Keep out of the reach of children. Avoid breathing vapors. Avoid contact with skin, eyes, and clothing. Wear impervious gloves. Repeated or continuous skin contact with uncured material may cause irritation. Remove material from skin with soap and water. Never use organic solvents to remove material from skin and eyes. For more information on the safe handling of this material, please refer to the Safety Data Sheet before use.

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