



APTEK LABORATORIES, INC.

ISO 9001 / AS9100 Certified

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PRELIMINARY TECHNICAL DATA & INFORMATION

UVIBOND™ 7101

Flexible, UV-Curing Urethane Adhesive

PRODUCT DESCRIPTION

UVIBOND 7101 is an unfilled, one component, electrically insulating, transparent, flexible urethane adhesive designed for bonding polycarbonate, ABS, glass and other various substrates.

UVIBOND 7101 is fully curable when exposed to the proper UV light radiation.

KEY FEATURES AND BENEFITS

- Very low shrinkage during cure to minimize stress on sensitive components and substrates.
- U.V. curable for extremely fast production output.
- Low ionic impurities for electrical/electronic applications.
- Excellent adhesion to polycarbonate and other plastic substrates.
- Thixotropic version for staking and bonding components available on request.

HANDLING INFORMATION

UVIBOND 7101 is a room temperature stable system. However, unlike conventional urethane systems, UVIBOND 7101 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

Three passes under Fusion systems "D" bulb (300 W/in) at rate of 10 feet per min. Bulb height above coating surface should be adjusted to expose the coating to approximately 2.2 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 7101</u>	<u>TEST METHOD</u>
Color	Pale yellow to amber	Visual
Specific Gravity	1.14	ASTM D-1475
Viscosity @25°C,cps	5500	ASTM D-1824
Shelf life, months @25°C, in factory sealed containers	6	
Hardness, Durometer A (taken one hr. after U.V. exposure, 1/16" casting)	70	ASTM D-2240

SAFETY AND FIRST AID

UVIBOND 7101 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.

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