

Uni-Weld™ 1404 UV/Visible/LED Curable Multi-Substrate (Plastics) General Bonder

PRODUCT DESCRIPTION

InCure Uni-Weld™ 1404 is a medium viscosity UV/Visible/LED light curing, acid-free form-in-place gasket and sealant. Cures on demand and tack-free, it is based on a 100% solids urethane acrylates compound formulation and does not contain VOCs or acids. It is very low in linear shrinkage during cure, and is ideal for optical positioning/alignment application. InCure 1404 bonds well to many different substrates such as glass, metals, ceramics and plastics, and exhibits good thermal and moisture resistance, making it a desired choice for bonding, sealing and gasketing applications.

UNCURED PROPERTIES

| | | | | |
|---|--|------------------|---------------------|------------|
| Chemical Type | Urethane Acrylate, 100% Solids, No Solvents | | | |
| Appearance | Single Component, Slight Yellowish Tint, Clear | | | |
| Density, g/ml | 1.04 | Refractive Index | 1.48 | @20°C |
| Flash Point, °C | > 93 | Toxicity | Low (Refer to MSDS) | |
| Viscosity, cP (rpm) | 20 | 2,000 - 3,800 | Spindle | 4 |
| Other viscosities are available upon request. If the viscosity range requested is not our standard offering, this product may be produced with a small lab fee. | | | | ASTM D2556 |
| Email us at: support@uv-incure.com or your nearest local distributor for more information. | | | | |

¹ Viscosity (cP) taken at 25°C - Call to enquiry for other viscosities.

CURED PROPERTIES

| | | |
|--|---------------|----------------------------|
| Shore Hardness, Durometer | D67 to D77 | ASTM 2240 |
| Linear Shrinkage | 0.10% | ASTM 570 |
| Water Absorption at 24hrs | 1.90% | ² ISTM D2566 |
| Tensile (PSI) <small>* PC-PC / SS-SS / S-S / AL-AL * PC Substrate Failure</small> | PC-PC / PC-SS | 7,100 ³ / 2,400 |
| | PC-S / PC-AL | 3,300 / 3,600 |
| Surface After Full Cure | Tack-Free | ² ISTM D189 |
| Elongation at Break | 73% | ASTM 638 |
| Thermal Range (Brittleness / Degrades) °C | -55 to 150 | ² ISTM D366 |
| Young's Modulus of Elasticity, MPa (PSI) | 108 (15700) | ³ ASTM 638 |
| Average Linear CTE, ppm/°C | 85 | ² ISTM D696 |

² ISTM - refers to InCure Standard Test Method.

³ ASTM 638 Young's Modulus test speed @5mm/min for rigid and semi-rigid materials, @50mm/min for non-rigid materials, unless otherwise specified.

RECOMMENDED UV CURE SCHEDULE (FULL CURE)

| Full Surface Cure | | UVA | UVB | UVC | UVV | |
|-----------------------------------|--------------------|-------------------|-------|-----|-------|-------|
| Fixture Time between glass slides | mJ/cm ² | 150 | 43 | 5 | 140 | |
| Exposure Time (s) | 1.0 | mWcm ² | 150 | 43 | 5 | 140 |
| S20™ Spot w/ 4-Pole LG @ 0.4" | mJ/cm ² | 3,000 | 530 | 50 | 3,400 | |
| Exposure Time (s) | 1.0 | mWcm ² | 3,000 | 530 | 50 | 3,400 |
| L9000™ LED Spot @ 0.67" | mJ/cm ² | 5,600 | 84 | 24 | 204 | |
| Exposure Time (s) | 2.0 | mWcm ² | 2,800 | 42 | 12 | 102 |
| F200P™ Flood @ 3.75" | mJ/cm ² | 3,000 | 860 | 100 | 2,800 | |
| Exposure Time (s) | 20.0 | mWcm ² | 150 | 43 | 5 | 140 |
| F500™ Focused @ 3.0" | mJ/cm ² | 3,000 | 960 | 90 | 2,880 | |
| Exposure Time (s) | 6.0 | mWcm ² | 500 | 160 | 15 | 480 |

Above table is for reference only. Fixture Time using F200P @100% intensity, 3.75" distance. Moderate intensity conveyor systems C9000-F100x1AC/200x1AB/400x1AC/500x1AC with lamp height set at 2.5". U8000-F300x1D conveyor lamp height set at 2.1" focal point. Please consult InCureLab™ for belt speed recommendations.

UV INTENSITY REFERENCE TABLE

| InCure UV Curing Lamp Model | Curing Distance in inches (mm) | | | | | |
|---|------------------------------------|------------|------------|------------|-------------|-----------|
| | 0.5" (12.6) | 1" (25.4) | 1.5" (38) | 2" (50.8) | 2.5" (63.5) | 3" (76.2) |
| ARC / LED Spot | | | | | | |
| S20 ARC (mW/cm ²) / Spot (ø mm) | 1,400 (3) | 1,500 (4) | 650 (6) | 360 (8) | 240 (10) | 175 (12) |
| L9000 LED (mW/cm ²) / Spot (ø mm) | 7,500 (9) | 5,000 (10) | 2,300 (17) | 1,200 (20) | 700 (25) | 450 (30) |
| ARC / LED Flood/Focus Beam | UV Intensity (mW/cm ²) | | | | | |
| F200 ARC Flood (6" x 8") | 325 | 280 | 245 | 215 | 190 | 165 |
| F400 ARC Flood (4" x 4") | 860 | 570 | 440 | 345 | 270 | 215 |
| F500 ARC Focused (3" x 5") | 1,040 | 685 | 530 | 415 | 325 | 260 |
| L1000-365 LED Flood (4" x 4") | 2,675 | 2,380 | 1,900 | 1,625 | 1,430 | 1,280 |
| L1000-405 LED Flood (4" x 4") | 2,950 | 2,625 | 2,150 | 1,900 | 1,650 | 1,450 |

⁴ Curing Distance is defined by the tip of light-guide or base of lamp housing to the bond area. All values are nominal with ±10% variation, with LED Flood Static Uniformity at ±78% and Dynamic Uniformity at ±90%. Recommended curing distances in grey.

CURING SCHEDULE FOR THIS PRODUCT (Not Applicable for this Product)

If you are unable to fully cure this product for some reasons, pls email us for assistance with your curing information. Below are the curing parameters:

| | | | |
|--|--|---|--|
| UVA (320-400nm) = 3,000 mW/cm ² | UVB (290-320nm) = 960 mW/cm ² | UVC (290-220nm) = 90 mW/cm ² | VUV (400-700nm) = 2,880 mW/cm ² |
|--|--|---|--|

Note: This product has been thoroughly tested to cure with F200P™ UV Flood Lamp. Intensity wavelengths (shaded) are crucial for curing this product. All measurements are made with EIT UV PowerPuck II.

SHELF-LIFE, STORAGE, USE AND HANDLING OF THIS PRODUCT

Shelf-Life of this unopened product is ONE (1) year from date of manufacture. Avoid direct exposure of bottle to visible light at all times. Containers should remain covered when not in use. Product should be stored in a dark cool place of 10°C to 28°C. Transfer of product into other packages void all warranties. Users should ensure all bonding surfaces are free of grease, mold release, or any contaminants, as bonding performance will be compromised. All tests for cured bonds should be carried out at ambient temperature. For safe handling of this product, please read Material Safety Data-sheet (MSDS) prior to use. Organic solvents, such as IPA, may be used to wipe away uncured material from surfaces.

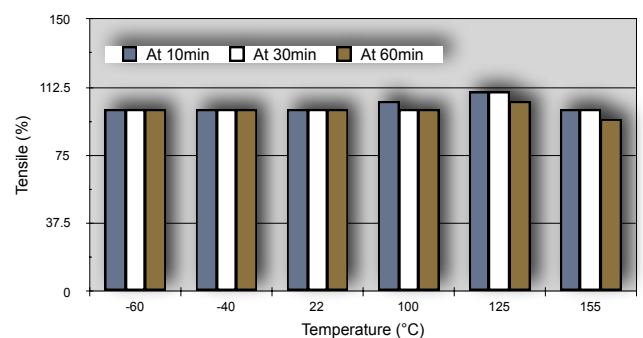
EtO and GAMMA STERILIZATION (Not Applicable for this Product)

All InCure Medical products are formulated to subject to standard sterilization methods, such as EtO and Gamma Radiation of 25 to 50 kGrays (cumulative). Enhanced moisture and thermal resistance of this product show excellent adhesion and bonding strength after one cycle of steam auto-clave test. Depending on bond design and structure of the application, users should test specific assemblies after subjecting them to the test requirements. Please consult InCure Support Team for assistance, if your devices are subjected to more than one sterilization cycles.

NOTE

The data contained in this document are furnished for information only. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any production methods mentioned herein. INCURE will not be liable for any indirect, special, incidental or consequential loss or damage arising from this INCURE product, regardless of the legal theory asserted. INCURE recommends that each user adequately test its proposed use and application before repetitive use, using this data as a guide.

TENSILE STRENGTH VS TEMPERATURE



SECONDARY HEAT CURE (Not Applicable)

| Continuous Oven Bake | Duration |
|----------------------|----------|
| 95°C (203°F) | 120 mins |
| 110°C (230°F) | 60 mins |
| 125°C (257°F) | 30 mins |

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