

High Temperature, Superior Strength & Vibration-Absorption Bonder

PRODUCT DESCRIPTION

Incure Epo-Weld™ 6481 (2:1) is an innovative, high temperature, two-component epoxy bonding material that offers a toughened surface with ultra-superior peel and shear strength on many substrates with bonding strength of up to 21,600 PSI between ceramics and metals. Curing starts within 30mins, with full cure after 72hrs at room temperature. Cure times may be shortened with heat at 80°C for 1hr or 100°C for 30mins. Incure 6481 has exceptional vibration absorption capability, with high impact and abrasion resistance. Exhibits excellent dimensional stability, complies to 2011/65/EU RoHS regulations.

UNCURED PROPERTIES

Chemical Type	Epoxy, 100% Solids, No Solvents			
Appearance	Two-Part Component, Clear Glossy			
Density, g/ml	1.08	Refractive Index	N.A.	@20°C
Flash Point, °C	>150	Toxicity	Very Low (Refer to MSDS)	
Viscosity, cP	5,000 - 9,000 @20rpm	Spindle	5	
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	D76 to D86	ASTM 2240
Linear Shrinkage / Expansion (-ve)	-0.05%	ASTM D2566
Water Absorption at 24hrs	0.35%	² ISTM D570
Tensile (PSI)	PC-PC / SS-SS	1,600* / 14,300*
	S-S / AL-AL	21,600* / 13,300*
Surface After Full Cure	Glossy	² ISTM D189
Elongation at Break	26%	ASTM 638
Thermal Range (Brittleness / Degrades) °C	-55 to 155	² ISTM D366
Young's Modulus of Elasticity, MPa (PSI)	946 (137,300)	³ ASTM 638
Linear CTE (α1 & α2), ppm/°C	Not Available	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 Cure Exposure Time		UVA	UVB	UVC	UVV
Fixture Time between glass slides	mW/cm ²				
Exposure Time (s)	0.0	0	0	0	0
F200P™ @3.75" Dist	0.0				
Belt Speed (ft/min)	N.A.	0	0	0	0
F500™ @3.0" Dist	TBA				
Belt Speed (ft/min)	N.A.	0	0	0	0
S20™ Spot (4-Pole LG) 0.4" Dist					
Exposure Time (s)	TBA	0	0	0	0
L9000™ LED Spot @ 0.67" Dist					
Exposure Time (s)	TBA	0	0	0	0

Cure times on 8mm Ø adhesive sample. Belt speeds using C9000-F200Px1AB (Flood) and C9000-F500x1AC (Focused Beam) conveyors for area curing. Please consult IncureLab™ for any other requirements.

UV INTENSITY REFERENCE TABLE

Incure UV Curing Lamp Model	Curing Distance vs UV Intensity					
	0.5" (12.6)	1" (25.4)	1.5" (38)	2" (50.8)	2.5" (63.5)	3" (76.2)
S20™ ARC (mW/cm ²) / (Ø mm)	1,400 (3)	1,500 (4)	650 (6)	360 (8)	240 (10)	175 (12)
L9000™ LED (mW/cm ²) / (Ø mm)	7,500 (9)	5,000 (10)	2,300 (17)	1,200 (20)	700 (25)	450 (30)
Flood/Focus Beam (Area)						
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
L1044-365™ LED Flood (4" x 4")	2,675	2,380	1,900	1,625	1,430	1,280
L1044-405™ 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 parameters in grey.

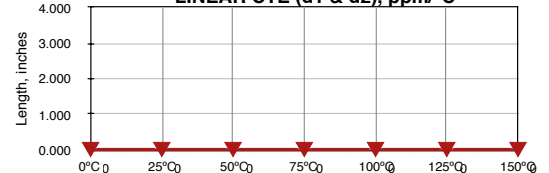
UV CURING SCHEDULE FOR THIS PRODUCT (Not Applicable for this Product)

Wavelength λ	UVA (320 - 400nm)	UVB (290-320nm)	UVC (290-220nm)	VUV (400-700nm)
Minimum Intensity	N.A. mW/cm ²	N.A. mW/cm ²	N.A. mW/cm ²	N.A. mW/cm ²
Total Energy Required	N.A. mJ/cm ²	N.A. mJ/cm ²	N.A. mJ/cm ²	N.A. mJ/cm ²

TENSILE STRENGTH VS TEMPERATURE



LINEAR CTE (α1 & α2), ppm/°C



SECONDARY HEAT CURE SCHEDULE

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

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

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

Shelf-Life of this unopened product is a minimum of SIX (6) months 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 32°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 sterilisation. 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.

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