

Light Weld® 914 Adhesive

Dymax Light Weld® 914 adhesive is a solvent-free, easy-to-use, aerobic, acrylic resin formulation designed for either manual or fully automated dispensing. Its cure speed, tack-free surface, deep cure capabilities, and insulation qualities combine to make Light Weld® 914 an excellent agent for wire tacking, coil terminating, and potting applications up to 0.63" (16 mm) deep. The product also bonds well to porous surfaces, such as paper, wood, and fabric where adhesive on the surface is fully exposed to UV light.

This 100% solvent-free, 100% solids, low-odor product requires no special venting, and cures in seconds on demand when exposed to "worker friendly", long wave (365 nanometer) UV light, and requires no extended drying or heat-curing periods.

TYPICAL UNCURED PROPERTIES (not specifications)

Solvent Content	None	
Color	Straw	
Flash Point	>93°C (200°F)	
Viscosity (1) (nominal)	25,000 cP	ASTM D-1084

TYPICAL CURED PROPERTIES (not specifications)

Maximum Cure Depth	0.63" (16 mm)	
Durometer - Hardness	D70	ASTM D-2240
Tensile Strength at Break	2100 psi	ASTM D-638
Elongation at Break	60%	ASTM D-638
Water Absorption (24 hr)	3%	ASTM D-570
Cure Speed (2)	<1 second @ 100 mW/cm ² of 365 nm	

CURE DEPTH VS. TIME

Exposure Time

Cure Depth (inches)

10 seconds	.25" (6.4 mm)
20 seconds	.38" (9.7 mm)
30 seconds	.50" (12.7 mm)
45 seconds	.63" (16mm)

STORAGE AND SHELF LIFE

Do not expose to UV light source or sunlight. 914 should be stored in a warm area 24°C (75°F) in the dark when not in use. Should product cool below 18°C (65°F), it may begin to crystallize and thicken. If this should occur, nominal viscosity can be restored by gentle warming at 38° to 49°C (100° to 120°F) with occasional stirring. This "freeze"/melt process has no effect on the product's properties. 914 has a six-month minimum shelf life when stored as above stated.

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; for eyes, get medical attention. Wash clothing before reuse. Keep out of reach of children. Do not take internally. If swallowed, vomiting should be induced at once and a physician called. For specific information, refer to the Material Safety Data Sheet before use.

NOTES

- (1) Measured at 20 rpm and 25°C using a Brookfield Model LVF Viscometer.
- (2) Film between glass slides.

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Technical Data Collection Prior to 2000

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