

## Ultra Light-Weld® 9-20269 Fast-Tacking Adhesive

Dymax Ultra Light-Weld® structural adhesives can be cured with UV or visible light. Ultra Light-Weld® materials' faster, deeper cure increases productivity, lowers assembly costs, and enhances worker safety. When cured with Dymax light-curing spot lamps, focused-beam lamps, or flood lamps, they deliver optimum speed and performance for maximum efficiency. Dymax lamps offer the optimum balance of UV and visible light for the fastest, deepest cures. This product is in full compliance with RoHS directives 2015/863/EU.

### DESCRIPTION

Ultra Light-Weld® 9-20269 adhesive is designed for the fastest bonding, tacking, and sealing possible with photocurable adhesives. Solvent-free, UV/Visible light-curable 9-20269 adhesive dispenses easily and cures "on demand" for precise bonding and placement of components. Excellent adhesion to common PCB substrates, fabric, and other porous surfaces, and its shock-absorbing capabilities make it an excellent choice for a variety of potting and tacking applications.

### TYPICAL UNCURED PROPERTIES (not specifications)

|                    |                                       |            |
|--------------------|---------------------------------------|------------|
| Solvent Content    | None - 100% Reactive Solids           |            |
| Chemical Class     | Urethane (Meth) Acrylate              |            |
| Appearance         | Straw                                 |            |
| Solubility         | Alcohols/Chlorinated Solvents/Ketones |            |
| Flash Point        | >95°C (200°F)                         |            |
| Viscosity (20 rpm) | 2,500 cP (nominal)                    | ASTM D1084 |

### TYPICAL CURED PROPERTIES (not specifications)

#### PHYSICAL

|                                      |             |            |
|--------------------------------------|-------------|------------|
| Durometer Hardness                   | D65         | ASTM D2240 |
| Elongation at Break                  | 20%         | ASTM D638  |
| Tensile at Break                     | 2,600 psi   | ASTM D638  |
| Modulus of Elasticity                | 100,000 psi | ASTM D638  |
| Water Absorption (24 h)              | 5.0%        | ASTM D570  |
| Boiling Water Absorption (2 h)       | 5.0%        | ASTM D570  |
| Glass Transition T <sub>g</sub> , °C | 135         | DSTM 256*  |

\*DSTM refers to Dymax Standard Test Method

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Technical Data Collection Prior to 2004



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**TYPICAL LIGHT-CURE DATA**

| Lamp  | 2000-EC | 5000-EC | Cure Spot 50 | BlueWave <sup>®</sup> 200 |
|---|---------|---------|--------------|---------------------------|
| Light Type  | UV      | UV      | UV           | UV                        |
| Lamp Type   | Flood   | Flood   | Spot         | Spot                      |
| Maximum Intensity (mW/cm <sup>2</sup> )               | 50      | 250     | 4,000        | 20,000                    |
| Intensity Taken at Time of Test (mW/cm <sup>2</sup> ) | 35      | 150     | 2,500        | 12,000                    |
| Measured at Peak Wavelength                           | 365 nm  | 365 nm  | 365 nm       | 365 nm                    |
| Wavelength (nm) Working Range                         | 300-500 | 300-500 | 300-500      | 300-500                   |
| Cure Speed (seconds)                                  |         |         |              |                           |
| Between Glass   | <1      | <1      | <1           | <1                        |
| 1/8" Bead   | 20-30   | 10-15   | 1-3          | 1                         |
| Surface Cure  | 30      | 15      | 2            | 1                         |
| Cure Depth in 1 Minute (inch)                         | 0.33    | 0.33    | 0.35         | 0.4                       |

**DISPENSING AND HANDLING ADHESIVE**

This material may be dispensed with a variety of manual and automatic applicators or other equipment as required. Questions relating to dispensing and curing systems for specific applications should be referred to Dymax Application Engineering.

Wear impervious gloves and/or barrier cream. Repeated or continuous skin contact with liquid adhesive will cause irritation and should be avoided. Do not wear absorbent gloves. Remove adhesive from skin with soap and water. Never use solvents to remove adhesive from skin or eyes.

**STORAGE AND SHELF LIFE**

Store the material in a cool, dark place when not in use. Do not expose to visible or UV light. This product may polymerize upon prolonged exposure to ambient and artificial light. Keep covered when not in use. This material has an 18-month shelf life from date of manufacture, unless otherwise specified, when stored between 10°C (50°F) and 35°C (90°F) in the original, unopened container.

**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; get medical attention. Wash clothing before reuse. Keep out of reach of children. Do not take internally. If swallowed, induce vomiting at once and call a physician. Repeated or continuous skin contact with liquid adhesive will cause irritation and should be avoided. For specific information, refer to the product Material Safety Data Sheet.

**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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