

UV/Visible/LED Curable Low Shrink Multi-Substrate Superior Bonder

PRODUCT DESCRIPTION

Incure Cyro-Weld™ 5291 UV/Visible/LED curable adhesive is an acid-free bonder used for the bonding of various plastic substrates in the medical industry. Low in viscosity, it is transparent clear and cures in seconds, it is an excellent choice for applications requiring good bonding strength on various types of plastics. Used in high volume productions, Incure 5291 exhibits very good moisture and temperature resistance. With enhanced thermal and moisture resistance, it is a desired choice for surviving EtO. Product is formulated to meet ISO 10993-5 and cytotoxicity tests.

UNCURED PROPERTIES

Chemical Type	Urethane Acrylate, 100% Solids, No Solvents			
Appearance	Single Component, Slight Tint			
Density, g/ml	1.01	Refractive Index	1.48	@20°C
Flash Point, °C	> 93	Toxicity	Low (Refer to MSDS)	
Viscosity, cP (rpm)	20	150 - 300	Spindle	1
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	D72 to D82	ASTM 2240
Linear Shrinkage / Expansion (-ve)	0.50%	ASTM 570
Water Absorption at 24hrs	6.00%	² ISTM D2566
Tensile (PSI)	PC-PC / PC-SS 7,100 ^A / 3,500	ASTM 638
^A PC Substrate Failure	PC-S / PC-AL 4,800 / 4,200	
Surface After Full Cure	Slight Tack	² ISTM D189
Elongation at Break	92%	ASTM 638
Thermal Range (Brittleness / Degrades) °C	-55 to 150	² ISTM D366
Young's Modulus of Elasticity, MPa (PSI)	34 (5,000)	³ ASTM 638
Average Linear CTE, ppm/°C	Not Available	² ISTM D696

² ISTM - refers to Incure Standard Test Method.

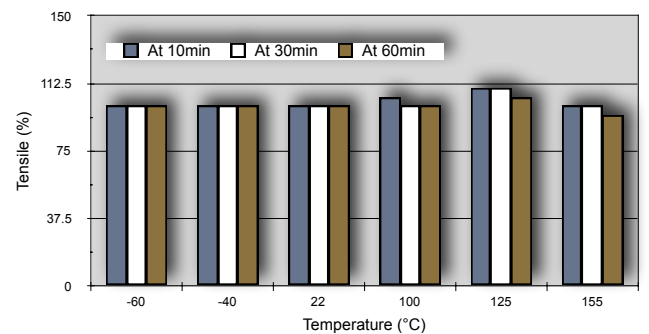
³ ASTM 638 Young's Modulus test speed @5mm/min for rigid and semi-rigid materials, @50mm/min for non-rigid materials, unless otherwise specified.

RECOMMENDED UV CURE SCHEDULE (FULL CURE)

Full Cure Exposure Time		UVA	UVB	UVC	UVV	
Fixture Time between glass slides	mW/cm ²	150	43	5	140	
Exposure Time (s)	2.0	mJ/cm ²	300	86	10	280
F200P™ @3.75" Dist	2.0	mW/cm ²	150	43	5	140
Belt Speed (ft/min)	44.0	mJ/cm ²	300	86	10	280
F500™ @3.0" Dist	1.0	mW/cm ²	500	160	15	480
Belt Speed (ft/min)	28.0	mJ/cm ²	500	160	15	480
S20™ Spot (4-Pole LG) 0.4" Dist	mW/cm ²	3,000	530	50	3,400	
Exposure Time (s)	1.0	mJ/cm ²	3,000	530	50	3,400
L9000™ LED Spot @ 0.67" Dist	mW/cm ²	2,800	42	12	102	
Exposure Time (s)	1.0	mJ/cm ²	2,800	42	12	102

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.

TENSILE STRENGTH VS TEMPERATURE



UV INTENSITY REFERENCE TABLE

Incure UV Curing Lamp Model	⁴ 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)
Spot Curing (ø mm)	1,400 (3)	1,500 (4)	650 (6)	360 (8)	240 (10)	175 (12)
S20™ ARC (mW/cm ²) / (ø mm)	7,500 (9)	5,000 (10)	2,300 (17)	1,200 (20)	700 (25)	450 (30)
L9000™ LED (mW/cm ²) / (ø mm)	UV Intensity (mW/cm ²)					
Flood/Focus Beam - Area Curing	325	280	245	215	190	165
F200™ ARC Flood (6" x 8")	860	570	440	345	270	215
F400™ ARC Flood (4" x 4")	1,040	685	530	415	325	260
F500™ ARC Focused (3" x 5")	2,675	2,380	1,900	1,625	1,430	1,280
L1044-365™ LED Flood (4" x 4")	2,950	2,625	2,150	1,900	1,650	1,450
L1044-405™ LED Flood (4" x 4")						

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.

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

Incure, Inc.
 1 Hartford Square, Box 16 West,
 Suite C-3, New Britain,
 CT 06052, USA
 Tel: (860) 748 2979
 support@uv-incure.com

Incure Adhesives Manufacturing Pte Ltd
 33 Ubi Avenue 3 #04-23,
 Vertex Tower B,
 Singapore 408868
 Tel: (65) 8509 3670
 www.uv-incure.com



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) = 500 mW/cm ²	UVB (290-320nm) = 160 mW/cm ²	UVC (290-220nm) = 15 mW/cm ²	VUV (400-700nm) = 480 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 a minimum of 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 2°C to 20°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

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.