Technical Data Sheet

Uni-Seal™ 6322

UV/Visible/LED Curable Hybrid Flexible Sealing/Potting Compound

PRODUCT DESCRIPTION
Incure Uni-Seal™ 6322 UV/Visible/LED curable adhesive is an acid-free, low viscosity form-in-place/cure-in-place (FIPG/CIPG) gasket and sealant. Cures very fast with low energy LED lamps for high volume production. Often used as a sealant or temporary mask in selective conformal coating. Highly resilient (good memory retention) and high flexibility out-perform many gaskets provides air-tight sealing. Incure 6322 exhibits enhanced excellent moisture and temperature resistance. Widely used in electronics and automotive industry for its chemical resistance.

UNCURED PROPERTIES

- **Chemical Type**: Urethane Acrylate, 100% Solids, No Solvents
- **Appearance**: Single Component, Transparent
- **Density, g/ml**: 1.03
- **Refractive Index**: 1.51 @20°C
- **Flash Point, °C**: > 93
- **Toxicity**: Low (Refer to MSDS)
- **Viscosity, cP (rpm)**: 20 @ 250 - 500 Spindle 2

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.

Email us at: support@uv-incure.com or your nearest local distributor for more information.

**ASTM D2555**

RECOMMENDED UV CURE SCHEDULE (FULL CURE)

- **Full Cure Exposure Time**: 1.0 mJ/cm²
- **Flash Curing Time**: 1.0 mJ/cm²
- **Exposure time**: 1.0 mJ/cm²

Other viscosities are made available upon request. If the viscosity range requested is not our standard offering, this product may be produced with a small lab fee.

Email us at: support@uv-incure.com or your nearest local distributor for more information.

**ASTM D2555**

UV INTENSITY REFERENCE TABLE

Incur UV Curing Lamp Model | Peak UV Intensity (mW/cm²) | Reference Intensity (mW/cm²) |
--- | --- | --- |
**D17 to D27** | **ASTM 2240** | **ASTM 570** |
**Water Absorption at 24hrs** | 0.40% | **ASTM D2556** |
**Tensile (PSI)** | **ASTM 638** |
**PC/PC - SS** | 4,000 / 2,500 |
**PC - SS** | 2,800 / 2,400 |
**Surface After Full Cure** | **Tack-Free** |
**Elongation at Break** | 560% |
**Thermal Range (Brilleness / Degrades °C)** | -50 to 155 |
**Young's Modulus of Elasticity, MPa (PSI)** | 14 (2,000) |
**Average Linear CTE, ppm/°C** | 109 |
**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.**

Email us at: support@uv-incure.com or your nearest local distributor for more information.

**ASTM D2555**

UV CURING SCHEDULE FOR THIS PRODUCT

- **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, please email us for assistance with your curing information.**

**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

**TENSILE STRENGTH VS TEMPERATURE**

[At 10min, 30min, 60min]

**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 remained 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 (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 kGy (cumulative). Enhanced moisture and thermal resistance of this product show excellent adhesion and excellent 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 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.