

## UV/Visible/Heat/Activator Curable Flexible Metal-Glass Bonder

### PRODUCT DESCRIPTION

Incure Quad-Cure™ 9254 UV/Visible/Heat/Activator Cure adhesive is a medium viscosity, multi-substrate, quad-cure general bonder. High in clarity and non-yellowing, it cures in seconds with UV. With activator, it starts curing after a minute before achieving 95% of bond-strength after 72 hours. It is an excellent choice for applications requiring extra-ordinary bonding strength. Incure 9254 exhibits enhanced excellent moisture and temperature resistance. It is also an extremely tough and high elongation performance. Very low in water absorption and shrinkage, it is ideal for many industrial uses.

### UNCURED PROPERTIES

Chemical Type	Urethane Acrylate, 100% Solids, No Solvents			
Appearance	Single Component, Slight Tint			
Density, g/ml	1.04	Refractive Index	1.50	@20°C
Flash Point, °C	> 93	Toxicity	Low (Refer to MSDS)	
Viscosity, cP (rpm)	20	1,200 - 2,500	Spindle	3
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.				

<sup>1</sup> Viscosity (cP) taken at 25°C - Call to enquiry for other viscosities.

### CURED PROPERTIES

Shore Hardness, Durometer	D66 to D76	ASTM 2240
Linear Shrinkage / Expansion (-ve)	1.02%	ASTM 570
Water Absorption at 24hrs	0.70%	<sup>2</sup> ISTM D2566
Tensile (PSI)	PC-PC / SS-SS / S-S / AL-AL	600* / 10,500*
	S-S / AL-AL	16,000* / 9,500*
ASTM 638		
Surface After Full Cure	PSA Feel	<sup>2</sup> ISTM D189
Elongation at Break	600%	ASTM 638
Thermal Range (Brittleness / Degrades) °C	-55 to 150	<sup>2</sup> ISTM D366
Young's Modulus of Elasticity, MPa (PSI)	8 (1,200)	<sup>3</sup> ASTM 638
Linear CTE (α1 & α2), ppm/°C	α1=15, α2=48	<sup>2</sup> ISTM D696

<sup>2</sup> ISTM - refers to Incure Standard Test Method.

<sup>3</sup> 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 <sup>2</sup>	150	43	5	140
Exposure Time (s)	mJ/cm <sup>2</sup>	600	172	20	560
F200P™ @3.75" Dist	10.0	150	43	5	140
Belt Speed (ft/min)	9.0	1,500	430	50	1,400
F500™ @3.0" Dist	3.0	500	160	15	480
Belt Speed (ft/min)	5.5	1,500	480	45	1,440
S20™ Spot (4-Pole LG) 0.4" Dist	mW/cm <sup>2</sup>	3,000	530	50	3,400
Exposure Time (s)	mJ/cm <sup>2</sup>	3,000	530	50	3,400
L9000™ LED Spot @ 0.67" Dist	mW/cm <sup>2</sup>	2,800	42	12	102
Exposure Time (s)	mJ/cm <sup>2</sup>	8,400	126	36	306

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

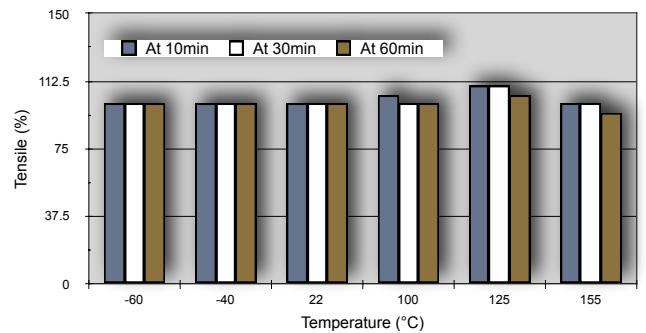
Incure UV Curing Lamp Model	<sup>4</sup> Curing Distance vs UV Intensity					
	0.5" (12.6)	1" (25.4)	1.5" (38)	2" (50.8)	2.5" (63.5)	3" (76.2)
S20™ ARC (mW/cm <sup>2</sup> ) / (Ø mm)	1,400 (3)	1,500 (4)	650 (6)	360 (8)	240 (10)	175 (12)
L9000™ LED (mW/cm <sup>2</sup> ) / (Ø mm)	7,500 (9)	5,000 (10)	2,300 (17)	1,200 (20)	700 (25)	450 (30)
Flood/Focus Beam (Area)	UV Intensity (mW/cm <sup>2</sup> )					
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

<sup>4</sup> 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.

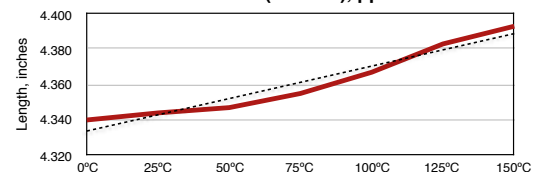
### UV CURING SCHEDULE FOR THIS PRODUCT

Wavelength λ	UVA (320 - 400nm)	UVB (290-320nm)	UVC (290-220nm)	VUV (400-700nm)
Minimum Intensity	150 mW/cm <sup>2</sup>	43 mW/cm <sup>2</sup>	5 mW/cm <sup>2</sup>	140 mW/cm <sup>2</sup>
Total Energy Required	1,500 mJ/cm <sup>2</sup>	430 mJ/cm <sup>2</sup>	50 mJ/cm <sup>2</sup>	1,400 mJ/cm <sup>2</sup>

### 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 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 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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