Dymax MD® Medical Device Adhesive 1-CN011 is designed for fast bonding of plastics typically used in the manufacture of medical devices. This product fluoresces blue for in-line inspection under low-intensity black light (365 nm). Dymax MD® Medical Device adhesives are solvent free and cure upon exposure to UV and visible light between 300-500 nm. Their ability to cure in seconds enables faster processing, greater output, and lower processing costs. When cured with Dymax light-curing spot lamps, focused-beam lamps, or flood lamps, they deliver optimum speed and performance for medical device assembly. 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.

**APPLICATIONS**
- Tube Sets & Fittings
- Metal to Plastic
- Plastic Assembly

**FEATURES**
- UV/Visible Light Cure
- Flexible

**RECOMMENDED SUBSTRATES**
- PC
- PVC
- PU
- PA
- PMMA
- ABS
- Stainless Steel

**BIOCOMPATIBILITY**
- ISO 10993-5 Cytotoxicity

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**ACCELERATED AGING DATA**

<table>
<thead>
<tr>
<th>Glass-to-Metal lap shear: Report % of initial strength.</th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>Cured under 5000-EC @ 100 mW/cm² for 15 sec</td>
<td></td>
</tr>
<tr>
<td>23°C RT</td>
<td>Accelerated Aging @ 60°C, 0% RH</td>
</tr>
<tr>
<td>7 Days</td>
<td>100</td>
</tr>
<tr>
<td>14 Days</td>
<td>109</td>
</tr>
<tr>
<td>28 Days</td>
<td>119</td>
</tr>
<tr>
<td>56 Days*</td>
<td>110</td>
</tr>
</tbody>
</table>

*Per ASTM F1980, assuming Qfactor = 2.0, 56 Days at 60°C = approximate 2 years

**OPTIMIZING PERFORMANCE AND HANDLING**

1. This product cures with exposure to UV and visible light. Exposure to ambient and artificial light should be kept to a minimum before curing. Dispensing components including needles and fluid lines should be 100% light blocking, not just UV blocking.

2. All bond surfaces should be clean and free from grease, mold release, or other contaminants prior to dispensing the adhesive.

3. Cure speed is dependent upon many variables, including lamp intensity, distance from the light source, required depth of cure, bond gap, and percent light transmission of the substrate.

4. Oxygen in the atmosphere may inhibit surface cure. Surfaces exposed to air may require high-intensity (>100 mW/cm²) UV light to produce a dry surface cure. Flooding the bond area with an inert gas, such as nitrogen, can also reduce the effects of oxygen inhibition.

5. Parts should be allowed to cool after cure before testing and subjecting to any loads.

6. In rare cases, stress cracking may occur in assembled parts. Three options may be explored to eliminate this problem. One option is to heat anneal the parts to remove molded-in stresses. A second option is to open the gap between mating parts to reduce stress caused by an interference fit. The third option is to minimize the amount of time the liquid adhesive remains in contact with the substrate(s) prior to curing.

7. Light curing generally produces some heat. If necessary, cooling fans can be placed in the curing area to reduce the heating effect on components.

8. At the point of curing, an air exhaust system is recommended to dissipate any heat and vapors formed during the curing process.

**TRAMP績質**

UNSCURED MATERIAL MAY BE REMOVED FROM DISPENSING COMPONENTS AND PARTS WITH ORGANIC SOLVENTS. CURED MATERIAL WILL BE IMPERVIOUS TO MANY SOLVENTS AND DIFFICULT TO REMOVE. CLEANUP OF CURED MATERIAL MAY REQUIRE MECHANICAL METHODS OF REMOVAL.

**BIOCOMPATIBILITY**

Polymerized Dymax MD® Medical Device adhesives are biocompatibility tested in accordance with ISO 10993 and/or USP Class VI. The completed tests are listed on each product data sheet. These adhesives have not been tested for prolonged or permanent implantation, and are only intended for use in short-term (<29 days) or single-use disposable-device applications. Dymax does not authorize their use in long-term implant applications.

**STERILIZATION**

Compatible sterilization methods include gamma irradiation and ethylene oxide. Sterilization by autoclaving may be limited to certain applications. It remains the user's obligation to ascertain the effect of sterilization on the cured adhesive.

**STORAGE AND SHELF LIFE**

Store the material in a cool, dark place when not in use. Do not expose to 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.
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.

The data provided in this document are based on historical testing that Dymax performed under laboratory conditions as they existed at that time, and are for informational purposes only. The data are neither specifications nor guarantees of future performance in a particular application. Dymax does not guarantee that this product’s properties are suitable for the user’s intended purpose.

Numerous factors—including, without limitation, transport, storage, processing, the material with which the product is used, and the ultimate function or purpose for which the product was obtained—may affect the product’s performance and/or may cause the product’s actual behavior to deviate from its behavior in the laboratory. None of these factors are within Dymax’s control. Conclusions about the behavior of the product under the user’s particular conditions, and the product’s suitability for a specific purpose, cannot be drawn from the information contained in this document.

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