

1-CN017

UV/Visible Light-Curable Adhesive for Multiple Substrates

APPLICATIONS

- Catheter Assembly
- Manifold Bonding

FEATURES

- UV/Visible Light Cure
- Secondary Heat Cure
- Passed ISO 10993-5 Cytotoxicity Testing
- Blue Fluorescing
- Medium Viscosity for Larger Bond Gaps

RECOMMENDED SUBSTRATES

- Plastics: ABS, NITi, PEBA, PS, PA

Dymax MD[®] Medical Device Adhesive 1-CN017 is designed for bonding various plastics typically used in the manufacture of medical devices. 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.

UNCURED PROPERTIES *

Property	Value	Test Method
Solvent Content	No Nonreactive Solvents	N/A
Chemical Class	Acrylated Urethane	N/A
Appearance	Colorless Transparent Liquid	N/A
Soluble in	Organic Solvents	N/A
Density, g/ml	1.06	ASTM D1875
Viscosity, cP (20 rpm)	600 (nominal)	ASTM D1084

CURED MECHANICAL PROPERTIES *

Property	Value	Test Method
Durometer Hardness	D80	ASTM D2240
Tensile at Break, MPa [psi]	30 [4,300]	ASTM D638
Elongation at Break, %	13	ASTM D638
Modulus of Elasticity, MPa [psi]	640 [93,000]	ASTM D638

OTHER CURED PROPERTIES *

Property	Value	Test Method
Boiling Water Absorption, % (2 hr)	5.4	ASTM D570
Water Absorption, % (25°C, 24 hr)	1.8	ASTM D570
Linear Shrinkage, %	1.6	ASTM D2566

* Not Specifications

N/A Not Applicable

CURING GUIDELINES

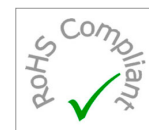
Fixture time is defined as the time to develop a shear strength of 0.1 N/mm² [10 psi] between glass slides. Actual cure time typically is 3 to 5 times fixture time.

Dymax Curing System (Intensity)	Fixture Time or Belt Speed ^A
2000-EC (50 mW/cm ²) ^B	6 s
5000-EC (200 mW/cm ²) ^B	4 s
BlueWave[®] 75 (5.0 W/cm ²) ^B	4 s
BlueWave[®] 200 (10 W/cm ²) ^B	3 s
UVCS Conveyor with one 5000-EC (200 mW/cm ²) ^C	2.1 m/min [7 ft/min]
UVCS Conveyor with Fusion F300S (2.5 W/cm ²) ^C	6 m/min [20 ft/min]

A Curing through light-blocking substrates may require longer cure times if they block wavelengths used for curing (320-450 nm). These fixture times/speeds are typical for curing thin films through 100% light-transmitting substrates.

B Intensity was measured over the UVA range (320-395 nm) using a Dymax ACCU-CAL[™] 50 Radiometer.

C At 53 mm [2.1 in] focal distance. Maximum speed of conveyor is 8.2 m/min [27 ft/min]. Intensity was measured over the UVA range (320-395 nm) using the Dymax ACCU-CAL[™] 150 Radiometer.



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Dymax Corporation
+1.860.482.1010 | info@[dymax.com](mailto:info@dymax.com) | www.dymax.com

Dymax Europe GmbH
+49 611.962.7900 | info_de@[dymax.com](mailto:info_de@dymax.com) | www.dymax.de

Dymax Engineering Adhesives Ireland Ltd.
+353 21.237.3016 | info_ie@[dymax.com](mailto:info_ie@dymax.com) | www.dymax.ie

Dymax Oligomers & Coatings
+1.860.626.7006 | info_oc@[dymax.com](mailto:info_oc@dymax.com) | www.dymax-oc.com

Dymax UV Adhesives & Equipment (Shanghai) Co. Ltd.
+86.21.37285759 | dymaxasia@dymax.com | www.dymax.com.cn

Dymax UV Adhesives & Equipment (Shenzhen) Co. Ltd.
+86.755.83485759 | dymaxasia@dymax.com | www.dymax.com.cn

Dymax Asia (H.K.) Limited
+852.2460.7038 | dymaxasia@dymax.com | www.dymax.com.cn

Dymax Asia Pacific Pte. Ltd.
+65.6752.2887 | info_ap@[dymax.com](mailto:info_ap@dymax.com) | www.dymax-ap.com

Dymax Korea LLC
+82.2.784.3434 | info_kr@[dymax.com](mailto:info_kr@dymax.com) | www.dymax.com/kr

SECONDARY HEAT CURE

Heat can be used as a secondary cure mechanism where the adhesive cannot be cured with light. Light curing must be done prior to heat cure. The following heat cure schedule may be used:

Temperature	Time*
110°C [230°F]	60 minutes
120°C [250°F]	30 minutes
150°C [300°F]	15 minutes

*Note: Actual heat cure time may vary due to part configuration, volume of adhesive applied, and oven efficiency.

Dymax recommends that customers employ a safety factor by curing longer, at higher intensity, and/or at higher temperature than required for full cure. Although Dymax Application Engineering can provide technical support and assist with process development, each customer ultimately must determine and qualify the appropriate curing parameters required for their unique application.

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.

DISPENSING THE 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.

CLEANUP

Uncured 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 a 18-month shelf life from date of manufacture for all packages except KG CYL, when stored between 10°C (50°F) and 35°C (90°F) in the original, unopened container. This material packaged in KG CYL has a 12-month shelf life from date of manufacture, 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.

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