

Ultra Light-Weld® 954 Valox® Potting and Encapsulating Resin

Dymax Ultra Light-Weld® 954 is a one-component material which can be cured to >1/4" within seconds upon exposure to UV/Visible light. Ultra Light-Weld® 954 provides rapid potting and sealing of Valox® PBT, ABS, acrylic, polyurethane, styrene, and other plastic substrates. Dymax Ultra Light-Weld® products contain no nonreactive solvents and cure upon exposure to light. Their ability to cure in seconds enables faster processing, greater output, and lower assembly costs. When cured with Dymax light-curing spot lamps, focused-beam lamps, or flood lamps, they deliver optimum speed and performance for maximum efficiency. 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.

TYPICAL UNCURED PROPERTIES

Solvent Content	None - 100% reactive solids	
Chemical Class	Urethane (Meth) Acrylate	
Appearance	Colorless	
Solubility	Alcohols/Chlorinated Solvents/Ketones	
Flash Point	>93°C (200°F)	
Viscosity (20 rpm)	6,000 cP	ASTM D-2556

TYPICAL CURED PROPERTIES

PHYSICAL

Durometer Hardness	D60	ASTM D-2240
Elongation at Break	200%	ASTM D-638
Tensile at Break	3,000 psi	ASTM D-638
Modulus of Elasticity	60,000 psi	ASTM D-638
Water Absorption (24 h)	0.5%	ASTM D-570
Boiling Water Absorption (2 h)	2.0%	ASTM D-570
Linear Shrinkage	1.6%	DSTM D-101*
Glass Transition T _g	69°C [160°F]	DSTM 256*

*DSTM refers to Dymax Standard Test Method

TYPICAL CURED DATA

Using 365 nm UV light ^[1]:

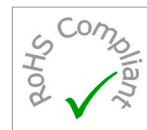
	Cure Time (seconds)	Intensity ^[2] mW/cm ²	Dymax Lamps
Nominal cure depth (0.250)	15	150	5000-EC
Tack Free	60	150	5000-EC

NOTES

[1] Do not recommend lamps that emit high levels of shortwave light (for example, more than 15% 200-300 nanometer UV light).

[2] Nominal intensity. This reading does not reflect the maximum intensity capabilities emitted from each unit.

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Technical Data Collection Prior to 1997

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DISPENSING AND HANDLING ADHESIVE

This material may be dispensed with a variety of automatic bench-top syringe applicators or other equipment as required. Questions relating to dispensing and curing systems for specific applications should be referred to Dymax Applications Engineering.

Wear impervious gloves and/or barrier cream. Repeated or continuous skin contact with liquid adhesive will cause irritation and should be avoided. Do not wear absorbent gloves. Remove adhesive from skin with soap and water. Never use solvents to remove adhesive from skin or eyes.

STORAGE AND SHELF LIFE

Store the material in a cool dark place when not in use. Do not expose to visible or UV light. Material may polymerize upon prolonged exposure to ambient light. Replace lid immediately after 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.

CAUTION

For industrial use only. Avoid breathing vapors. Avoid contact with eyes and clothing. In case of contact, immediately flush with water for at least 15 minutes; get medical attention. Wash clothing before reuse. Keep out of reach of children. Do not take internally. If swallowed, induce vomiting at once and call a physician. Repeated or continuous skin contact with liquid adhesive will cause irritation and should be avoided. For specific information, refer to the product Material Safety Data Sheet.

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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