

See-Cure 1-20793 Ultra-Red™ Fluorescing Adhesive for Plastics

APPLICATIONS	FEATURES	RECOMMENDED SUBSTRATES	BIOCOMPATIBILITY
<ul style="list-style-type: none"> Tube Sets Reservoirs Catheters 	<ul style="list-style-type: none"> Blue to Clear upon Exposure to UV/Visible Light UV/Visible Light Cure Ultra-Red™ Fluorescing 	<ul style="list-style-type: none"> PC PVC PU ABS PET PEBA 	<ul style="list-style-type: none"> ISO 10993-5 Cytotoxicity

Dymax MD® Medical Device Adhesive 1-20793 is designed for rapid bonding of a variety of rigid and flexible plastics typically used in the manufacture of medical devices. The blue color of Dymax See-Cure products disappears when they are fully cured. This product also fluoresces bright red under low-intensity "black" light (365 nm). The bright red fluorescence contrasts extremely well on plastics that naturally fluoresce blue in color (like PVC), and greatly assists with visual inspection of the bond-line area. Dymax MD® Medical Device Adhesives contain no nonreactive solvents and cure upon exposure to light. 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	Blue Transparent Liquid	N/A
Soluble in	Organic Solvents	N/A
Density, g/ml	1.00	ASTM D1875
Viscosity, cP (20 rpm)	550 nominal	ASTM D1084

CURED MECHANICAL PROPERTIES *		
Property	Value	Test Method
Durometer Hardness	D60	ASTM D2240
Tensile at Break, MPa [psi]	14 [2,000]	ASTM D638
Elongation at Break, %	170	ASTM D638
Modulus of Elasticity, MPa [psi]	120 [17,000]	ASTM D638

OTHER CURED PROPERTIES *		
Property	Value	Test Method
Appearance	Clear	N/A
Refractive Index (20°C)	1.50	ASTM D542
Boiling Water Absorption, % (2 hr)	4.3	ASTM D570
Water Absorption, % (25°C, 24 hr)	4.8	ASTM D570
Linear Shrinkage, %	2.4	ASTM D2566

* Not Specifications
N/A Not Applicable

ADHESION	
Substrate	Recommendation
ABS acrylonitrile-butadiene-styrene	✓
PA polyamide	o
PC polycarbonate	✓
PEBA polyether block amide	✓
PET poly(ethylene terephthalate)	✓
PMMA poly(methyl methacrylate)	o
PU polyurethane	✓
PVC poly(vinyl chloride)	✓

✓ Recommended Adhesive o Limited Applications
st Requires Surface Treatment (e.g. plasma, corona treatment, etc.)

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Dymax Corporation
+1.860.482.1010 | info@dymax.com | www.dymax.com

Dymax Europe GmbH
+49 611.962.7900 | info_de@dymax.com | www.dymax.de

Dymax Engineering Adhesives Ireland Ltd.
+353 21.237.3016 | info_ie@dymax.com | www.dymax.ie

Dymax Oligomers & Coatings
+1.860.626.7006 | 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.
+65.6752.2687 | info_ap@dymax.com | www.dymax-ap.com

Dymax Korea LLC
+82.2.784.3434 | info_kr@dymax.com | www.dymax.com/kr



CURING GUIDELINES

The blue color of Dymax See-Cure products disappears when they are fully cured. Full cure is achieved when additional light exposure does not improve cured properties. The charts below provide information on how long it takes to complete the transition from blue to clear, using different light sources and adhesive thicknesses.

Dymax Curing System (Intensity)	5000-EC (200 mW/cm ²) ^A
Adhesive Thickness, mm [mil]	Time to complete transition, sec ^B
0.10 [4.0]	15
0.20 [8.0]	17
0.41 [16]	19
0.81 [32]	30

Dymax Curing System (Intensity)	BlueWave® 200 (10.0 W/cm ²) ^{A, C}
Adhesive Thickness, mm [mil]	Time to complete transition, sec ^B
0.10 [4.0]	3
0.20 [8.0]	3
0.41 [16]	3
0.81 [32]	5

Dymax Curing System (Intensity)	UVCS Conveyor with Fusion F300 (2.5 W/cm ²) ^D
Adhesive Thickness, mm [mil]	Belt speed to complete transition, m/min [ft/min] ^B
0.10 [4.0]	1.8 [6]
0.20 [8.0]	1.5 [5]
0.41 [16]	0.9 [3]
0.81 [32]	0.6 [2]

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

B Curing through light-blocking substrates may limit the ability of See-Cure adhesives to transition from blue to clear and may require longer light exposure at critical wavelengths (320-400 nm for UV light curing; 320-450 nm for UV/Visible light curing). These times/speeds are typical for curing through 100% light-transmitting substrates.

C Due to the distance between the end of the lightguide and adhesive, intensity at the curing area was measured as 4.0 W/cm².

D 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™ 100 Radiometer.

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, and other contaminants prior to dispensing the adhesive.
3. Cure and color transition speed are 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 (>150 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. Copies of the test reports are available upon request. In all cases, it is the user's responsibility to determine and validate the suitability of these adhesives in the intended medical device. 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. Customers using these materials for such applications do so at their own risk and take full responsibility for ensuring product safety and biocompatibility.

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 12-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.

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