

UV/Visible Light/LED Curable High Strength Metal-Glass Optical Bond

PRODUCT DESCRIPTION

Incure Cast-Max™ 1049 UV/Visible Light/LED curable, medium viscosity structural bonder/coating. As a bonder, it exhibits bonding strength of up to 12,000 PSI on metals and it is suitable for use in furniture-making, equipment and fixture fabrication and construction industries. Used as a coating, it cures in seconds to form a very sleek clear dome. With enhanced moisture and temperature resistance, Incure 1049 exhibits extra-ordinary high bonding strength on glass, metals and ceramics. It is 100% solids, it contains no volatiles and it is ideal for product requiring thermal cycling.

UNCURED PROPERTIES

Chemical Type	Urethane Acrylate, 100% Solids, No Solvents			
Appearance	Single Component, Clear Transparent			
Density, g/ml	1.09	Refractive Index	1.48	@20°C
Flash Point, °C	> 93	Toxicity	Low (Refer to MSDS)	
Viscosity, cP	4,500 - 7,500	@20rpm	Spindle	5
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.				

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

CURED PROPERTIES

Shore Hardness, Durometer	D80 to D90	ASTM 2240
Linear Shrinkage / Expansion (-ve)	0.63%	ASTM D2566
Water Absorption at 24hrs	0.28%	² ISTM D570
Tensile (PSI)	PC-PC / SS-SS	N.A. / 10,800*
	S-S / AL-AL	12,600* / 10,100*
* PC-PC / SS-SS / S-S / AL-AL * PC Substrate Failure		ASTM 638
Surface After Full Cure	Tack-Free	² ISTM D189
Elongation at Break	38%	ASTM 638
Thermal Range (Brittleness / Degrades) °C	-55 to 150	² ISTM D366
Young's Modulus of Elasticity, MPa (PSI)	329 (47,800)	³ ASTM 638
Linear CTE (α1 & α2), ppm/°C	α1=42, α2=88	² ISTM D696
Glass Transition Temperature (Tg), °C	N.A.	² ISTM D696

² ISTM - refers to Incure Standard Test Method.

³ 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 ² 223	56	4	215
Exposure Time (s)	2.0	mJ/cm ² 446	112	8 430
F200P™ @3.75" Dist	4.0	mW/cm ² 223	56	4 215
Belt Speed (ft/min)	14.0	mJ/cm ² 892	224	15 860
F500™ @3.0" Dist	2.0	mW/cm ² 436	127	12 390
Belt Speed (ft/min)	9.0	mJ/cm ² 872	254	23 780
S20™ Spot (4-Pole LG) 0.4" Dist	1.0	mW/cm ² 3,000	530	50 3,400
Exposure Time (s)	1.0	mJ/cm ² 3,000	530	50 3,400
L9000™ LED Spot @ 0.67" Dist	2.0	mW/cm ² 2,800	42	12 102
Exposure Time (s)	2.0	mJ/cm ² 5,600	84	24 204

Cure times on 8mm α 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	⁴ Curing Distance vs UV Intensity					
Spot Curing (Diameter)	0.5" (12.6)	1" (25.4)	1.5" (38)	2" (50.8)	2.5" (63.5)	3" (76.2)
S20™ ARC (mW/cm ²) / (α mm)	1,400 (3)	1,500 (4)	650 (6)	360 (8)	240 (10)	175 (12)
L9000™ LED (mW/cm ²) / (α 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 ²)					
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

⁴ 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)	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.
Minimum Intensity	223 mW/cm ²	56 mW/cm ²	4 mW/cm ²	215 mW/cm ²	
Total Energy Required	892 mJ/cm ²	224 mJ/cm ²	15 mJ/cm ²	860 mJ/cm ²	

SHELF-LIFE, STORAGE, USE AND HANDLING OF THIS PRODUCT

Shelf-Life of this unopened product is a minimum of ONE (1) year 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 10°C to 32°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)

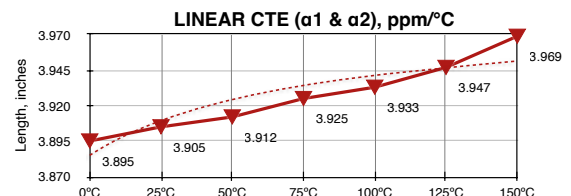
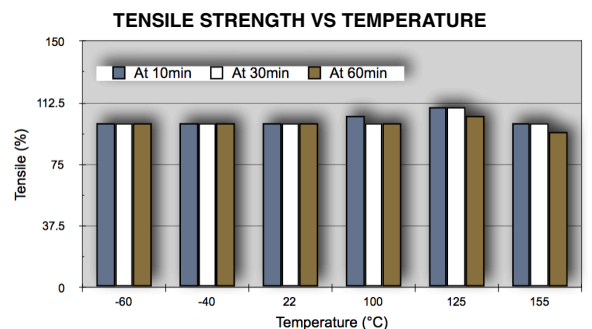
All Incure medical products are formulated to subject to standard sterilization methods, such as EtO and Gamma Radiation of 25 to 50 kGrays (cumulative). Enhanced moisture and thermal resistance of this product show excellent adhesion and bonding strength after one cycle of steam auto-clave test. Depending 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.

Incure, Inc.
1 Hartford Square, Box 16 West,
Suite C-3, New Britain,
CT 06052, USA
Tel: (860) 748 2979
support@uv-incure.com

Incure Adhesives Manufacturing Pte Ltd
33 Ubi Avenue 3 #04-23,
Vertex Tower B,
Singapore 408868
Tel: (65) 6509 3670
www.uv-incure.com



SECONDARY HEAT CURE (Not Applicable)

Continuous Oven Bake	Duration
95°C (203°F)	120 mins
110°C (230°F)	60 mins
125°C (257°F)	30 mins