



U3349TX

U3349TX is a high viscosity, low/non sag, UV-curable adhesive designed for bonding a variety of plastics.

Technology / Base	Modified Acrylate
Type of Product	Structural Adhesive
Components	One Component
Curing	Ultra Violet Light
Appearance / Color	Light Straw
Consistency	Liquid

Technical Data

Rheology	Value	Condition/Method
Viscosity	20000 +/- 5000 cps @ 2.5 rpm	20°C to 25°C (68°F to 77°F)
Density Specific Gravity	1.05	
Curing Process Characteristics Flash Point Set Time and Wavelength Full Cure Time Shelf Life Storage Condition Optimum Wavelength	> 95°C <5 sec at 395nm, 50mW/cm2 24 hours 9 months 8°C to 21°C in darkness 300 to 420 nm	
Cured Material Characteristics Cured Appearance Tack Free RoHS Compliant	Colorless solid Yes Yes	
Cured Mechanical Properties Hardness Elongation to Break	Shore A 70 Shore D 32 150%	ASTM D2240 ASTM D2240 ASTM D638

General Instructions

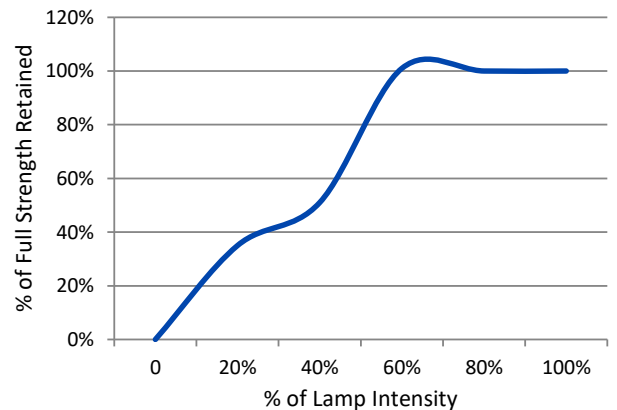
Surfaces to be bonded should be clean and dry. Dispense a drop or drops to one surface only. Apply only enough to leave a thin film layer after compression. Press parts together and expose to UV dose when ready. An adequate bond should develop rapidly, depending on UV dose efficacy, and maximum strength is attained in 24 hours. Wipe off excess adhesive from the top of the container and recap. Cyberlite products, if left uncapped or exposed to sunlight, may deteriorate or cure prematurely.

Curing Performance

Photoinitiation initiates the curing process. Handling strength is reached in a short time, and will vary based on UV dose efficacy, environmental conditions, bond line gap, and other factors. Product will continue to cure for at least 24 hours before full strength and solvent resistance is developed.

Specifications and Approvals

Percent Strength Retained at Given Dosage



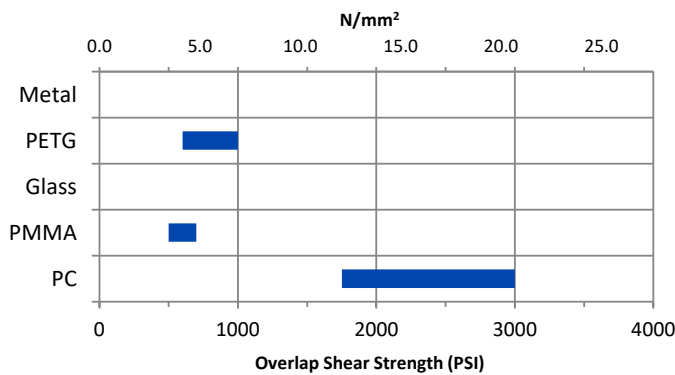


Performance of Cured Adhesive

Substrate	N/mm ²			PSI		
	n/r	to	n/r	n/r	to	n/r
Metal	n/r		n/r	n/r		n/r
PETG	4.1	to	6.9	600	to	1000
Glass	n/r	to	n/r	n/r	to	n/r
PMMA	3.4	to	4.8	500	to	700
PC	12.1	to	20.7	1750	to	3000

* n/r = not recorded on this substrate

Performance Range, by Substrate



Solvent Resistance

Solvent	Example	Resistance
Alcohol	Ethanol, Methanol	+++
Ester (aromatic)	Ethylacetate	---
Ketone (aromatic)	Acetone, Benzophenone	---
Aliphatic hydrocarbon (alkanes)	Petrol, Heptanes, Hexane	++-
Aromatic hydrocarbons	Benzyl, Toluol, Xylol	++-
Halogenated hydrocarbons	Methylenchloride, Chloroform, Chlorobenzol	---
Weak aqueous acid	Nitrite, muriatic acid, sulphuric acid, phosphoric acid	+++ (--- if concentrated)
Weak aqueous base	sodium hydroxide solution, caustic potash	+++ (--- if concentrated)

Safety and Disposal

For safe handling information and disposal information on this product, consult the Safety Data Sheet (SDS)

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Storage

Products should be stored unopened in a cool, dry place out of direct sunlight. Products should be kept at room temperature away from direct light. Protect from extreme heat or cold, do not refrigerate.

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