



Product Description

Procure UV 94500 is a single component, thixotropy paste, and fast curing UV curable structural adhesive designed for bonding plastics, glass and metals to itself and to a wide variety of other substrates.

Features

- An easy-to-use one-part system that eliminates drying and heat curing.
- A Fast cure time, which is dependent upon applied quantity and the amount of UV light energy available.
- A superior bonding solution, due to its low shrinkage, high wetting and excellent adhesion.

UV Curing System

Lamp Type	5" x 5" Flood	3/16" Spot	1" x 6" Focused
Max. Lamp Intensity @ 365 nm	300 mW/cm ²	4000 mW/cm ²	8000 mW/cm ²
Adhesive Absorption Range (nm)	300 - 500	300 - 500	300 - 500
Cure Speed (Sec)			
Glass to Glass Bonding	14	12	<6
Surface Cure Speed	18	18	<6

Physical Properties

Liquid State		Cured State	
Base	Urethane Methacrylate	Tensile Strength, ASTM D882 (psi)	1,200
Colour	Clear, Amber	Elongation @ break (%)	48
Specific Gravity (25°C)	1.1	Hardness, ASTM D2240 Shore D	52
Refraction Index (25°C)	1.495	Tg, ASTM D3418-82 (°C)	103
Viscosity (cP)	40,000 – 60,000	Water Absorption, ASTM D570 (%)	8.7

Cure Conditions

Cure can be affected with both low and high intensity UV light sources. A low UV intensity of 30 mW/cm² will cure highly transmitting substrate with < 0.010" gap in 5 seconds or 0.070" to 0.090" gaps in 10 to 20 seconds. A high UV intensity of 100 mW/cm² will cure highly transmitting surfaces with < 0.010" gap in 2 seconds or 0.100" to 0.200" gaps in 10 to 20 seconds.

Directions For Use

This adhesive is UV sensitive. Exposure to daylight, UV light and artificial lighting should be kept to a minimum during storage and handling. Adhesive product should be dispensed from applicators with black feed lines. For best performance bond surfaces should be clean and free from grease.

UV cure rate is depends on lamp intensity, distance from light source, depth of cure needed or bond line gap and light transmittance of the substrate through which the radiation must pass.

Recommended intensity for cure in an adhesive application are 40-mW/cm² minimums with an exposure time of 5-6 times the fixture time at this same intensity. For tack free surface cure, as necessary in coating, potting or tacking applications, higher intensity UV is required.

General Information

For information on safe handling of this product consult the Safety Data Sheet (SDS).

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