

## UV3605H

### Heat-soluble Photo-curing Adhesive

UV3605H is the photo-curing adhesive that can be peptized by heating. Originally, the normal photo-curing adhesive develops high temperature resistance adhesive for temperature resistance. Nevertheless, heat-soluble resin is composed of the material with poor heat resistance. This product is recommended to be applied on glass processing industry. This product can temporarily fix glass substrates and then continue to glass process. After the glass processing and peptized the resin, users can get the finished glass products.

### FEATURES

- Cured product exhibits hard but brittle property and low toughness which is suited for mechanical processing.
- This product can pass 10~30min / 30% hydrochloric acid soaking test.

### TYPICAL UNCURED PROPERTIES

Properties	UV3605H
Chemical composition	Acrylic resin
Appearance	Liquid
Color	Opaque
Viscosity *, 25°C, S14 30rpm, cps	8200 - 140000
Refractive Index nD @25.2°C	15021
Recommended application	Dispensing

\*This value is for reference. Please refer to COA for the actual value

### TYPICAL CURING PROPERTIES \*

Properties	UV3605H
Recommended Wavelength , nm	310-365
Minium light intensity, mW/cm <sup>2</sup>	>50
Minium light enegy, mJ/cm <sup>2</sup>	500-1000
Curing equipment : LED light	
Recommended Wavelength , nm	365
Minium light intensity, mW/cm <sup>2</sup>	50-300
Minium light enegy, mJ/cm <sup>2</sup>	1000-3000

\*The recommended light energy is for reference, use with GLUDITEC FUV-100 Curing Oven

### DIRECTION OF USE

1. It should be applied to a clean surface which is free of dirt, grease or mold release. In many cases, a simple solvent wipe is sufficient.
2. For maximum bonding strength apply adhesive evenly to both surfaces to be jointed.
3. Cure time on the real part will depend on factors, such as part geometry, materials to be bonded, bondline thickness and efficiency of the UV light. Cure schedule should be confirmed with actual production parts and equipment.
4. Please standardize the UV lamp intensity and illumination. Over exposure will not affect the resin properties, but the resin properties will be changed if there is not enough exposure. The resin may have lower reaction rate and may not pass the environmental test experiments.
5. This product may cause skin irritation to sensitive personnel.

### TYPICAL CURED PROPERTIES

Durometer Hardness, ATSM D2240-03 Shore D 24  
Durometer Hardness, ATSM D2240-03 Shore D 74

### FINISHED PRODUCT ADVANCE TESTING \*

Item	Area	Test condition
Heat – soluble Resin Properties	5.5-9.8cm	110°C/5-10min

\*Heat-soluble Test Method:

Fix the area 5.5 × 9.8cm glass sheet with the resin  
Curing Energy= 1000±100mJ/cm<sup>2</sup> in the 110°C oven



After 5~10min, glass sheet will be automatically peptized and fall off.

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*Heat-soluble Photo-curing Adhesive*

### STORAGE AND SHELF LIFE

This product should be stored in cool and dark place. It should be kept without any possibility of sunlight or ultraviolet exposure. Replace the lid immediately after use. Keep without any possibility of light exposure. Shelf life of this product is 6 months when stored at 2~13°C in the original and unopened containers. Before use, this product should be placed at 14~34°C for 1 to 2 hours. Use it up as soon as possible. The properties of this product will be changed when placing it at 14~34°C for too long time.

### CAUTION

Some findings indicate a lack of potential for carcinogenicity with the compositions of this product by long term recurrent application to the skin. However, contact with skin is likely to produce mild transient reddening. It is important to remove adhesive from skin with soap and water thoroughly. DO NOT use solvents for cleaning hands. This product is of moderate acute toxicity by swallowing. If swallowed, call a physician. Avoid contact with eyes. In case of contact, flush with water for at least 15 minutes and get medical attention immediately. For specific information on this product, consult the Safety Data Sheet.

The data contained in this bulletin is provided only as a guide for evaluation/consideration. These material characteristics are typical properties that are based on a limited number of samples tested in the laboratory. We cannot assume responsibility for 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 product or method. We recommend that each prospective user test his proposed application before repetitive use, using this data as a guide.