

**TYPICAL CURE DATA**

<b>Lamp</b>	<b>2000-EC</b>	<b>5000-EC</b>	<b>PC-3</b>	<b>3010-EC</b>
Light Type	UV	UV	UV	UV
Lamp Type	Flood	Flood	Spot	Spot
Intensity (mW/cm <sup>2</sup> ) at Peak	50	150	1000	1800
Wavelength	@ 365 nm	@ 365 nm	@ 365 nm	@ 365 nm
Wavelength (nm) working range	300-500	300-500	300-500	300-500
Cure Speed (seconds)				
Between glass	1	1	1	1
1/8" Bead	7	3	6	7
Cure Depth in 1 Minute (inch)	3/16	9/16	1/8	3/16

**DISPENSING AND HANDLING ADHESIVE**

The Ultra Light-Weld<sup>®</sup> 3094 Series are available in various packages such as syringes, cartridges, bottles, and pails. It may be dispensed with a variety of automatic bench-top syringe applicators or other equipment as required. Direct questions relating to dispensing and curing systems for specific applications to Dymax Technical Representatives.

**SAFETY**

Repeated or continuous skin contact with liquid adhesive ("resin") will cause skin irritation or contact dermatitis, which in some cases, can be severe. Avoid this possibility by wearing impervious gloves and/or a barrier cream. Gloves made of rubber (including latex and any other rubber product) are not impervious. Nitrile (an artificial rubber) is preferred. Do not breathe the vapors from the adhesive. The user must be familiar with the Material Safety Data Sheet for the product before use. UV light can damage your eyes. Read and follow all instructions for the safe use of any UV light source that come with the device.

**STORAGE AND SHELF LIFE**

Store material in a cool dark place when not in use. Do not expose to UV light or sunlight. Material may also polymerize upon prolonged exposure to ambient light. Replace lid immediately after use. Product has a one-year shelf life when stored below 90°F in the original, unopened container. Refrigerated storage extends shelf life.

**CAUTION**

For industrial use only. Avoid breathing vapors. Avoid contact with eyes and clothing. In case of contact, immediately flush with water for at least 15 minutes; get medical attention. Wash clothing before reuse. Keep out of the reach of children. Do not take internally. If swallowed, induce vomiting at once and call a physician. Repeated or continuous skin contact with liquid adhesive will cause irritation and should be avoided. For specific information, refer to the Material Safety Data Sheet.

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The data contained in this bulletin which represents typical results, is furnished for information only, and is believed to be reliable. We cannot assume responsibility for results obtained by others over whose methods we have no control. It is the users responsibility to determine suitability for the user's purpose of any product or method mentioned herein and to adopt such precautions as may be advisable for the protection of property and persons against any hazards that may be involved in the handling and use thereof. Nothing in this bulletin is to be interpreted as a representation of freedom from domination of patents owned by others or a license under a Dymax Corporation patent. We recommend that each prospective user test the proposed application before repetitive use, using the data as a guide. For specific information, refer to the Material Safety Data Sheet before use.

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**ULTRA LIGHT WELD<sup>®</sup> 3094 SERIES  
LOW STRESS PLASTICS BONDER  
ACRYLIC • STYRENE • POLYCARBONATE****INTRODUCTION**

Dymax Ultra Light-Weld 3094 Series adhesives can be cured with UV or visible light. Ultra Light-Weld adhesives increase productivity, lower assembly costs and enhance worker safety. When cured with Dymax Light Welder<sup>®</sup> UV lamps, these adhesives provide optimum process flexibility. They allow the user to select the optimum combination of adhesive and cure mechanism to meet individual process and performance requirements.

**DESCRIPTION**

Ultra Light-Weld 3094 Series provide rapid bonding and sealing to ABS, polyacrylics, polycarbonate, polyurethane, styrene, and other plastic substrates. Solvent free, visible and/or UV curing adhesives, 3094-Series dispenses easily and cures quickly for precise quantity and placement of adhesive. Bonds generally exceed the strength of substrates bonded, including PVC alloys, which resist most other bonding methods.

**TYPICAL UNCURED PROPERTIES**

Solvent Content		None – 100% reactive solids	
Chemical Class		Urethane (Meth) Acrylate	
Appearance		Clear	
Solubility		Alcohol/Chlorinated Solvents/Ketones	
Toxicity		Low	
Flash Point		>95° C (200° F)	
Viscosity (20 rpm)	3094	1,000 cP (nominal)	ASTM D-1084
	3094-T	8,000 cP (nominal)	ASTM D-1084
	3094-Gel	25,000 cP (nominal)	ASTM D-1084

**TYPICAL CURED PROPERTIES***PHYSICAL*

Durometer Hardness	D60	ASTM D-2240
Elongation at Break	300%	ASTM D-638
Tensile at Break	5,300 psi	ASTM D-638
Modulus of Elasticity	21,000 psi	ASTM D-638
Water Absorption (24 h)	20%	ASTM D-570
Thermal Limit (brittle/degrades)	-55° to 180°C (-65° to +350°F)	* DSTM D-200
Linear Shrinkage	1.6%	ASTM D-101

\*DSTM refers to Dymax Standard Test Method