

**CURE DATA**

Lamp	PC-3 Ultra	2000-EC	Bond Box	5000-EC
Light Type	UV/Visible	UV/Visible	UV/Visible	UV/Visible
Lamp Type	3/16" Spot	8" X 8" Flood	8" Rotating Stage	5" X5" Flood
Maximum Lamp Intensity @365 nm	4,000 mW/cm <sup>2</sup>	50 mW/cm <sup>2</sup>	150 mW/cm <sup>2</sup>	300 mW/cm <sup>2</sup>
Intensity @ time of Test @ 365nm	2,500 mW/cm <sup>2</sup>	20 mW/cm <sup>2</sup>	50 mW/cm <sup>2</sup>	150 mW/cm <sup>2</sup>
Adhesive Absorption Range (nm)	300-400	300-400	300-400	300-400
Equipment Output Range (nm)	300-500	300-500	300-500	300-500
Typical Cure Speed (seconds)				
Fixture between glass slides	1	1	1	1
Tack-free surface cure	nm	nm	nm	nm
1/16-inch bead	nm	nm	nm	nm

**DISPENSING & HANDLING ADHESIVE**

Dymax GB 341-UV adhesive is available in syringes, cartridges, or pails. Machine ready syringes may be dispensed from a variety of automatic bench-top syringe applicators or other equipment as required. Any questions relating to dispensing and curing systems for specific applications should be referred to the Dymax Technical Center at (860) 482-1010.

**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.

**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; for eyes, get medical attention. Wash clothing before reuse. Keep out of the reach of children. Do not take internally. If swallowed, vomiting should be induced at once and a physician called. For specific information, refer to the Material Safety Data Sheet before use.

© 2001 Dymax Corporation

The data contained in this bulletin is of a general nature and is based on laboratory test conditions. Dymax does not warrant the data contained in this bulletin. Any warranty applicable to the product, its application and use is strictly limited to that contained in Dymax's standard Condition of Sale. Dymax does not assume responsibility for test or performance results obtained by users. It is the users responsibility to determine the suitability for the product application and purposes and the suitability for use in the users intended manufacturing apparatus and methods. The user should adopt such precautions and use guidelines as may reasonably be advisable or necessary for the protection of property and persons. Nothing in this bulletin shall act as a representation that the product use or application will not infringe a patent owned by someone other than Dymax or act as a grant of a license under any Dymax Corporation Patent. Dymax recommends that each user adequately test its proposed use and application before actual repetitive use, using the data contained in this bulletin as a general guide.

DYMAX CORPORATION \* 51 GREENWOODS ROAD, CT 06790 \* TEL: 860-482-1010 \* FAX:8604960608  
DYMAX EUROPE \* TRAKEHNER STRASSE 3 \* D-60487 FRANKFURT a. M. GERMANY \* TEL: 49-69-7165-3568 \* FAX: 49-69-7165-3830  
Dymax, Light Weld, Light-Welder, Ultra Light-Weld and Multi-Cure are registered trademarks of Dymax Corporation  
DYMAX USA E-Mail: [info@dymaxcorp.com](mailto:info@dymaxcorp.com) \* Internet: <http://www.Dymax.com> \* DYMAX EUROPE E-Mail: [dymaxinfo@dymax.de](mailto:dymaxinfo@dymax.de)

Distributed by: Dewey Associates International, Inc. 459 Main Street, Suite 102, New Rochelle, NY 10801. Ph: 800.448.2306 / 914.633.4081 Fax: 914.633.4175 e-mail: [deweyint@glassbond.com](mailto:deweyint@glassbond.com) [www.glassbond.com](http://www.glassbond.com)

**INTRODUCTION**

Dymax adhesives cure upon exposure to UV light in seconds and are designed to increase productivity, lower assembly costs and enhance worker safety. These results were obtained using Dymax flood lamps. Dymax lamps deliver optimum speed and performance for a variety of optical applications.

**DESCRIPTION**

Ultra Light-Weld GB 341-UV was designed for laminating large pieces of thin glass. GB 341-UV is a clear, UV or visible light-curing adhesive with high transmission across the optical spectrum. GB 341-UV is very soft, low modulus and is designed for thermal cycling of fragile optical components. Its high Newtonian viscosity makes it useful for filling irregular or hand-made glass while minimizing air bubbles in the bond line.

SUBSTRATES BONDED:	• Glass • Ceramics • Plastics • Metal
FEATURES:	• Low Shrinkage UV Cure (<0.5%) • Thick, Flowing Viscosity to Fill Gaps • Fast, Total Cure in Seconds with UV or Visible Light
APPLICATIONS:	• Laminating Glass • Bonding Non-flat Glass

**TYPICAL UNCURED PROPERTIES**

Solvent Content	None-100% Reactive Solids	
Composition	Urethane Acrylate	
Appearance	Optical Clear	
Solubility	Alcohols/Keytones/Chlorinated Solvents	
Toxicity	Low	
Flash Point	Over 93° C (>200° F)	
Viscosity	21,000 cP (nominal)	ASTM D-1084

**TYPICAL CURED PROPERTIES**

Refractive Index, n <sup>20</sup> <sub>D</sub>	1.505	ASTM D-1218
Durometer Hardness	D55	ASTM D-2240
Modulus of Elasticity	3,000 psi	ASTM D-638
Elongation at Break	120%	ASTM D-638
Tensile at Break	1,500 psi	ASTM D-638
Thermal Range (brittle/degrades)	-55° to +180°C (-65° to 350°F)	DSTM D-200*
24 hr Water Absorption	1.0%	ASTM D-570
2 hr Boiling Water Adsorption	2.0%	ASTM D-570
Linear Shrinkage	<0.5%	ASTM D-2566

\*DSTM Refers to Dymax Standard Test Method.