

# **Industrial & Decorative Glass Assembly With UV/Visible Light Curing Adhesives**

DYMAX Light Weld<sup>®</sup> adhesives cure in seconds *even through UV blocked and tinted glass and plastic* upon exposure to UV/visible light. Environmentally friendly, solvent-free adhesives increase productivity, lower assembly costs and enhance worker safety. DYMAX Multi-Cure<sup>®</sup> products cure with light, heat or activator.



**Glass Finial Bonded to Brass Fixture  
with DYMAX Multi-Cure<sup>®</sup> 620**



**Glass Brandy Snifters Bonded with Crystal Clear,  
Dishwasher Safe DYMAX Light Weld<sup>®</sup> 425**



**Acrylic Hanger Bonded to Glass Hummingbird Feeder  
with DYMAX Light Weld<sup>®</sup> 4-20418**



**Metal Banister Bonded to Glass Panes  
with Tough, Durable DYMAX Multi-Cure<sup>®</sup> 620**

Download Product Data Sheets on These and  
Other DYMAX Adhesive Products By Logging Onto

[www.dymax.com](http://www.dymax.com)

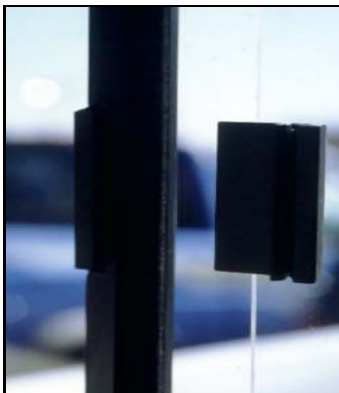
# Selector Guide and Adhesive Properties

Product Family	Features	Relative Performance †							Standard Viscosity* (cP = mPas)	Elongation %	Bond Strength	
		Clarity and Colorless	Metal Adhesion	Plastic Adhesion	Moisture Resistance	High Temperature Adhesion	Non-yellowing Heat Resistance	Hot/Cold Thermal Cycling			Glass to Glass (psi / MPa)	Steel to Glass (psi / MPa)
620	Glass metal bonding	3	5	2	3	4	2	3	650*	30	3,800 / 26‡	3,400 / 23‡
619	Glass metal bonding	3	5	2	1	3	2	3	400*	7	4,000 / 27‡	4,300 / 29‡
429	Clear, resilient glass bonder	5	4	3	4	4	4	5	2,500*	120	2,400 / 16‡	1,700 / 12‡
424A	Glass and lead crystal bonding	4	5	2	3	4	2	3	1,600	15	3,400 / 23‡	600 / 4
425	Clear, glass bonding, dishwasher resistant	5	1	1	5	4	4	2	3,500	7	4,000 / 28‡	500 / 3
4-20623	Low-stress laminating of large and thin glass sheets; gap-filling for non-flat glass	5	4	4	4	4	4	5	17,000	120	2,000 / 14‡	1,450 / 10‡
4-20418	Glass to acrylic, polycarbonate and mirrors	3	3	5	3	2	3	4	450*	130	2,750 / 19‡	2,240 / 15‡
4-20586	UV epoxy glass metal bonding	1	5	Surface Treat, 5	5	5	2	3	1,200	3	3,400 / 23‡	1,350 / 9‡
4-20651	UV/visible epoxy, glass bonding	3	5	Surface Treat, 5	5	5	5	3	500*	2	2,200 / 15‡	525 / 3

† 5 = highly recommended, 4 = recommended, 3 = often recommended, 2 = sometimes recommended, 1 = not recommended

‡ Bond strength exceeds the strength of the glass

\* Non-flowing gel grades and possibly other viscosities are available



Window Fixture Mounted with DYMAX 620



Glass Trophy Bonded with DYMAX Light Weld® 429



Acrylic Bonded to Glass Table with DYMAX Light Weld® 4-20418

## General Purpose Glass to Glass & Glass to Metal Adhesives

Adhesive	Substrates	Characteristics
619	Glass and steel	Cures with UV light or activator 501 (see product data sheet)
620	Glass, aluminum, steel, plated metals, thermoset plastics	Good moisture resistance; good impact resistance; a range of viscosities available; cures with UV light or activator 501-E



Stainless Steel Trim Bonded to Crystal with DYMAX Light Weld® 619

## High Performance, Clear Glass and Crystal Adhesives

Adhesive	Characteristics
425	Excellent bonds to glass and crystal stemware; dishwasher safe; good for fountains
424A	Excellent adhesion to lead crystal with moderate flowing viscosity; great for chandeliers and figurines
429	High strength, low stress glass bonds; bonds different metals and some plastics; high adhesion during large temperature changes; also useful in shatterproof laminations



Crystal Figurines Bonded with DYMAX Light Weld® 424A

## Laminating Adhesives

Adhesive	Characteristics
4-20418	Bonds glass and mirrors to acrylic and polycarbonate; cures through UV blocked and tinted glass and plastics
4-20623	Low-stress laminating of large and thin glass sheets; gap-filling for non flat glass

## UV Epoxies\* for Glass to Glass, Metal and Plastic Bonding

Adhesive	Characteristics
4-20586	Hard, clear bonds; slick surface; resists yellowing when heated; good cure depth
4-20651	Bonds many plastics to glass; resists yellowing when heated; good depth of cure; cures through UV blocked plastics

\*With surface treatment, UV epoxies form excellent bonds to difficult to bond to plastics and provide excellent solvent resistance



Glass to Plastic Assembly with DYMAX Light Weld® 4-20586 UV Epoxy



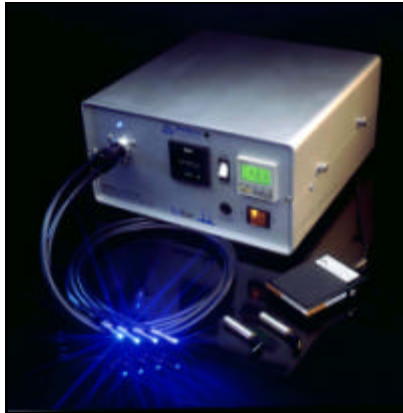
Metal Emblems Bonded to Glass with DYMAX Light Weld® 619



Headlamp Leads Bonded to Glass Housing with DYMAX Multi-Cure® 625 Rev. A

# UV Light Curing Systems for Automated and Hand Assembly

Everything you need for safe, efficient curing and process control



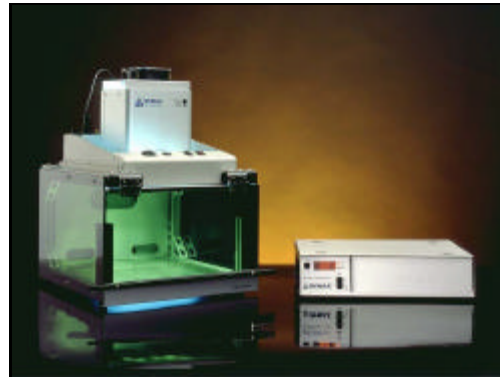
Spot Wand Lamps



UV Protective Eyewear



Radiometers



Enclosed Flood Curing Chambers

## Challenge us to find the right solution for your unique application...

If you don't find exactly what you are looking for, call the DYMAX Technical Service Centers in the United States and Europe. Our staff is experienced in both adhesive selection and process recommendation.

If our standard products don't meet your needs, we can custom formulate one that does.

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