

# SAF-T-LOK®

## TRI-CURE™ UV ADHESIVE

## Technical Data Sheet

GENERAL INFORMATION: TRI-CURE bridge bonding and potting adhesive cures with UV light sources as well as with heat or activator and thus conforms to specific assembly requirements. The optional use of SA Activator allows cure in areas shadowed to UV light. Temperatures above 200°F will also cure this product. TRI-CURE provides high tensile strength bonds as well as high impact, peel and fatigue resistance on steel, galvanized steel, glass, ferrite, aluminum, nylon, epoxy board, fiberglass, and phenolics.

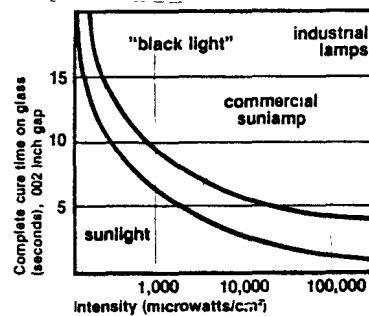
### PRODUCT CHARACTERISTICS:

Color	Hazy amber
Specific Gravity	1.05 gm/cc
Viscosity	3,000 cps
Flash point	200° F
Storage Stability	6 months

### PERFORMANCE CHARACTERISTICS:

UV cure*	10 sec.
Activator fixture**	20 sec.
Heat cure @300°F	15 min.
Temp range	-65° to +400° F
Tensile shear	3,000 psi

### Typical Cure Speed



\* 2 mil gap on glass, 7,000 microwatts/cm long wave ultraviolet light (black light)

\*\* 2 mil gap cold rolled steel, cure at room temperature after 24 hours.

UV SOURCE: Long wave (300-400 nanometers) of at least 7,000 microwatts/cm<sup>2</sup> intensity. Speed of cure and tack free surface are a function of the light used as shown in the above plot. For gaps over .05 inches, a 100,000 microwatt/cm<sup>2</sup> light is recommended. Potting depths over .15 inches require multiple applications.

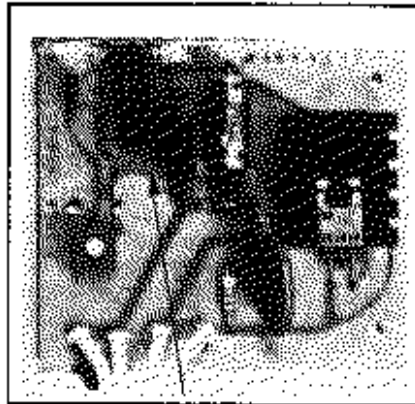
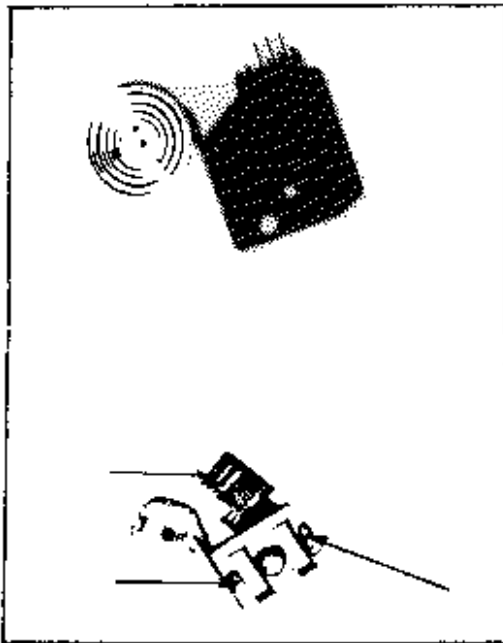
ACTIVATOR cure may be used to supplement UV cure where this light source is shadowed. Apply SA Activator liberally and allow solvent to evaporate. Assemble. Apply UV light to accelerate surface cure.

HEAT cure for 1 hour at 200°F or for 15 minutes at 300°F may prove an advantage in particular applications. UV light and heat may be combined, or heat and activator where heat sinks occur in assembly parts.

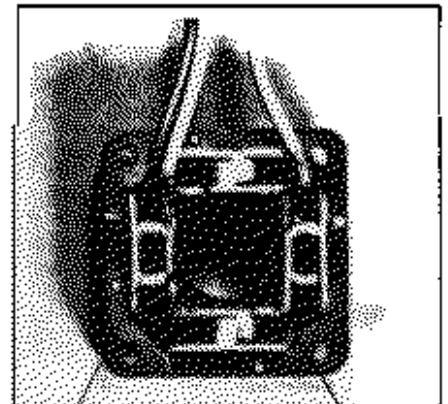
**IMPORTANT NOTICE:** All statements and technical data contained herein are based on tests we believe to be reliable, but the accuracy of completeness thereof is not guaranteed. It is recommended that the buyer test this product to determine its suitability for his application before use. SAF-T-LOK Corporation is not responsible for loss, claim or damages resulting from use of its products.

## APPLICATIONS: BRIDGING, POTTING TACKING, & SEALING

- \* Ferric magnet bridge bonding
- \* Terminating wire coils
- \* Tacking parts to PC boards
- \* Insulating exposed wires
- \* Capacitor end potting
- \* Lens bonding
- \* Polycarbonate bonding
- \* Auto head lamp lead potting
- \* Jewelry assembly
- \* Chip bonding
- \* Sealing electronic assemblies
- \* Glass / metal wear strips



Tacking parts to printed circuit board



Cap termination      Covering leads on electrical motor

Dry surfaces can be obtained using full spectrum lamps (sun lamp) with an incident intensity of 10,000 watts/cm<sup>2</sup> for 1 to 2 minutes. Higher intensity lamps give dry surfaces in shorter intervals. For example a lamp which delivers 50 milliwatts of intensity per cm<sup>2</sup> yields a dry surface in 1-5 seconds. A useful property of TRI-CURE is that it fluoresces to optimum brightness only upon completion of cure, providing a visual end point determination.

**CAUTION:** For industrial use only. Avoid prolonged breathing of vapors. Avoid contact with eyes and clothing. In case of contact, immediately flush with plenty of water for at least 15 minutes; for eyes, get medical attention. Wash clothing before re-use. Keep out of reach of children. Do not take internally. If swallowed, vomiting should be induced at once and a physician called.