9211-W

IBOA Free Light-Curable Adhesive for CCM Barrel and Holder Bonding

APPLICATIONS

- CCM Assembly
- Camera Module Barrel Fixtures
- Plastic Assembly

FEATURES

- UV/Visible Light Cure
- Low Stress Plastic Bonder
- IBOA Free, Low Skin Sensitizing Ingredients
- Halogen Free

RECOMMENDED SURFACES

- PC
- LCP
- ABS
- FR4

Dymax 9211-W is designed for rapid bonding and sealing of a variety of plastics and ideal for CCM assembly. Dymax materials contain no nonreactive solvents and cure upon exposure to light. Their ability to cure in seconds enables faster processing, greater output, and lower processing costs. When cured with Dymax light-curing spot lamps, focused-beam lamps, or flood lamps, they deliver optimum speed and performance for plastics assembly. Dymax lamps offer the ideal balance of UV and visible light for the fastest, deepest cures. This product is in full compliance with RoHS directives 2015/863/EU.

UNCURED PROPERTIES *

Property	Value	Test Method
Solvent Content	No Nonreactive Solvents	N/A
Chemical Class	Acrylated Urethane	N/A
Appearance	Colorless	N/A
Soluble in	Organic Solvents	N/A
Density, g/ml	1.02	ASTM D1875
Viscosity, cP	25,000 (nominal)	ASTM D2556
Shelf Life at Recommended Conditions from Date of Manufacture	7 months	N/A

CURED MECHANICAL PROPERTIES *

Property	Value	Test Method
Durometer Hardness	D63	ASTM D2240
Tensile at Break, MPa [psi]	16.4 [2378]	ASTM D638
Elongation at Break, %	191	ASTM D638
Modulus of Elasticity, MPa [psi]	700 [101,540]	ASTM D638

OTHER CURED PROPERTIES *

Property	Value	Test Method
Refractive Index (20°C)	1.51	ASTM D542
Boiling Water Absorption, % (2 h)	3.50	ASTM D570
Water Absorption, % (25°C, 24 h)	2.98	ASTM D570
Linear Shrinkage, %	0.68	ASTM 2566
Glass Transition Tg, °C	120	ASTM D5418
CTEα_1, µm/m/°C	115	ASTM E831
CTEα_2, µm/m/°C	181	ASTM E831

ADHESION

Substrate	Recommendation
ABS acrylonitrile-butadiene-styrene	✓
FR4	✓
LCP liquid crystal polymer	✓
PA6 polyamide (Nylon 6)	✓
PC polycarbonate	✓
PET poly(ethylene terephthalate)	✓
PETG poly(ethylene terephthalate)glycol	✓
PI polyimide (Flex)	✓
PU polyurethane	✓
TPU thermoplastic polyurethane	✓

✓ Recommended o Limited Applications

st Requires Surface Treatment (e.g. plasma, corona treatment, etc.)

* Not Specifications

N/A Not Applicable

Technical Data Collected 01/2022 Rev.01/24/2024

CURING GUIDELINES

Fixture time is defined as the time to develop a shear strength of 0.1 N/mm^2 [10 psi] between glass slides. Actual cure time typically is 3 to 5 times fixture time.

Dymax Curing System (Intensity)	Fixture Time or Belt Speed [A]
BlueWave® 200 (10 W/cm^2)[B]	0.6 s
5000-EC (200 mW/cm^2)[B]	1 s
BlueWave® AX-550 RediCure® 365 nm (425 mW/cm2)[C]	0.8 s
BlueWave® AX-550 PrimeCure® 385 nm (800 mW/cm2)[C]	0.8 s
BlueWave® AX-550 VisiCure® 405 nm (650 mW/cm2)[C]	0.8 s
UVCS Conveyor with Fusion F300S (2.5 W/cm^2)[D]	27.6 ft/min

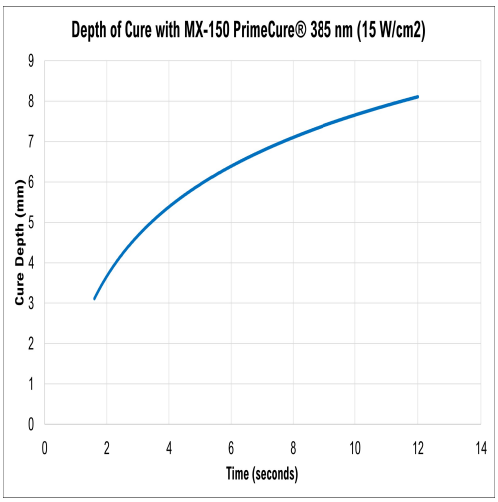
A Fixture times/belt speeds are typical for curing thin films through 100% UV and light-transmitting substrates. Light-obstructing substrates may require longer cure times.
B Intensity was measured over the UVA range (320-395 nm) using a Dymax ACCU-CAL™ 50 Radiometer.
C Intensity was measured over the UVA/Visible range (350-450 nm) using a Dymax ACCU-CAL™ 50-LED Radiometer.
D At 53 mm [2.1 in] focal distance. Maximum speed of conveyor is 8.2 m/min [27 ft/min]. Intensity was measured over the UVA range (320-395 nm) using the Dymax ACCU-CAL™ 160 Radiometer.

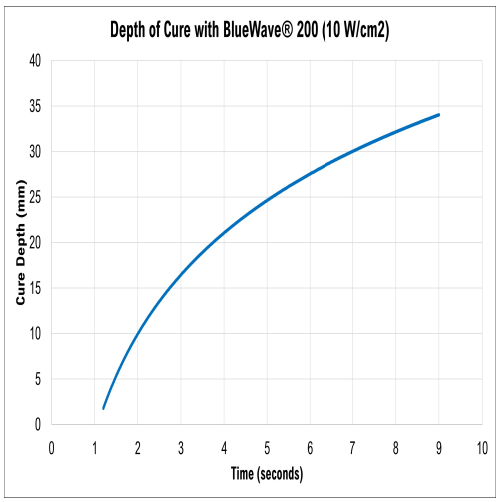
Full cure is best determined empirically by curing at different times and intensities, and measuring the corresponding change in cured properties such as tackiness, adhesion, hardness, etc. Full cure is defined as the point at which more light exposure no longer improves cured properties.

Dymax recommends that customers employ a safety factor by curing longer and/or at higher intensities than required for full cure. Although Dymax Application Engineering can provide technical support and assist with process development, each customer must ultimately determine and qualify the appropriate curing parameters required for their unique application.

DEPTH OF CURE

The graphs below show the increase in depth of cure as a function of exposure time with two different lamps at different intensities. A 9.5 mm [0.37 in] diameter specimen was cured in a polypropylene mold and cooled to room temperature. It was then released from the mold and the cure depth was measured.





OPTIMIZING PERFORMANCE AND HANDLING

1. This product cures with exposure to UV and visible light. Exposure to ambient and artificial light should be kept to a minimum before curing. Dispensing components including needles and fluid lines should be 100% light blocking, not just UV blocking.
2. All surfaces in contact with the material should be clean and free from flux residue, grease, mold release, or other contaminants prior to dispensing the material.
3. Cure speed is dependent upon many variables, including lamp intensity, distance from the light source, required depth of cure, thickness, and percent light transmission of components between the material and light source.
4. Oxygen in the atmosphere may inhibit surface cure. Surfaces exposed to air may require high-intensity (>100 mW/cm^2) UV light to produce a dry surface cure. Flooding the curing area with an inert gas, such as nitrogen, can also reduce the effects of oxygen inhibition.
5. Parts should be allowed to cool after cure before testing and subjecting to any loads or electrical testing.
6. In rare cases, stress cracking may occur in assembled parts. Three options may be explored to eliminate this problem. One option is to heat anneal the parts to remove molded-in stresses. A second option is to open any gap between mating parts to reduce stress caused by an interference fit. The third option is to minimize the amount of time the liquid material remains in contact with the substrate(s) prior to curing.
7. Light curing generally produces some heat. If necessary, cooling fans can be placed in the curing area to reduce the heating effect on components.
8. At the point of curing, an air exhaust system is recommended to dissipate any heat and vapors formed during the curing process.

DISPENSING THE MATERIAL

The Dymax Application Engineering team is ready to discuss your application requirements to provide the most appropriate dispensing and/or spraying solution. Visit our current dispensing equipment portfolio here or consult our global contact phone numbers and online chat feature (available in North America only) during normal business hours for instant support.

STORAGE AND SHELF LIFE

Store the material in a cool, dark place when not in use. Do not expose to light. This product may polymerize upon prolonged exposure to ambient and artificial light. Keep covered when not in use. This material shelf life noted on page 1 of this document, when stored between 10°C (50°F) and 32°C (90°F) in the original, unopened container.

CLEANUP

Uncured material may be removed from dispensing components and parts with organic solvents. Cured material will be impervious to many solvents and difficult to remove. Cleanup of cured material may require mechanical methods such as ultrasonic bath, water jet, vacuum tweezers, air knife, and/or warming to aid in the removal.

GENERAL INFORMATION

This product is intended for industrial use only. Keep out of the reach of children. Avoid breathing vapors. Avoid contact with skin, eyes, and clothing. Wear impervious gloves. Repeated or continuous skin contact with uncured material may cause irritation. Remove material from skin with soap and water. Never use organic solvents to remove material from skin and eyes. For more information on the safe handling of this material, please refer to the Safety Data Sheet before use.

The data provided in this document are based on historical testing that Dymax performed under laboratory conditions as they existed at that time and are for informational purposes only. The data are neither specifications nor guarantees of future performance in a particular application. Dymax does not guarantee that this product's properties are suitable for the user's intended purpose.

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