

# LOCTITE ABLESTIK UV300X

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**PRODUCT DESCRIPTION**

LOCTITE ABLESTIK UV300X provides the following product characteristics:

<b>Technology</b>	Acrylate
<b>Appearance</b>	Opaque slightly colored liquid gel
<b>Product Benefits</b>	<ul style="list-style-type: none"><li>• Fast cure</li><li>• One component</li></ul>
<b>Cure</b>	Ultraviolet (UV) light
<b>Application</b>	Assembly
<b>Typical Assembly Applications</b>	Disk drive assembly
<b>Typical Applications</b>	Conformal coating and Component tracking

LOCTITE ABLESTIK UV300X single component, photocurable adhesive is designed for disk drive assembly applications such as conformal coating and component tracking. This product also contains a secondary thermal cure mechanism for applications that contain shadowed areas where light is unable to penetrate.

**TYPICAL PROPERTIES OF UNCURED MATERIAL**

Viscosity, Brookfield SP #27, 25 °C, :	
Speed 2.5 rpm	70,000
Thixotropic Index (0.5/5 rpm)	3.8
Shelf Life @ 10°C, days	91
Flash Point - See SDS	

**TYPICAL CURING PERFORMANCE****Recommended UV Cure**

Light Source and Condition:

Ultraviolet (UV) light:

Irradiance, mW/cm <sup>2</sup>	>50
UV Wavelength, nm	365
UV Fixture Time, second	1
UV Tack-Free Time, seconds	5

**Secondary Thermal Cure**

1hour @ 100°C or  
2hours @ 85°C

**Depth of Cure**

The above cure profiles are guideline recommendations. Cure conditions (time and temperature) may vary based on customers' experience and their application requirements, as well as customer curing equipment, oven loading and actual oven temperatures.

**TYPICAL PROPERTIES OF CURED MATERIAL****Physical Properties :**

Hardness, Shore D	78
Glass Transition Temperature (Tg) by DMTA, Tan Δ Max, °C	88
Coefficient of Thermal Expansion , TMA expansion mode:	
Below Tg, ppm/°C	45
Above Tg, ppm/°C	188
Tensile Modulus, DMTA:	
N/mm <sup>2</sup>	2,027
(psi)	294,000
Refractive Index	1.52

**TYPICAL PERFORMANCE OF CURED MATERIAL****Die Shear Strength:**

Alumina to Glass	N/mm <sup>2</sup>	25
	(psi)	(3,600)

**GENERAL INFORMATION**

For safe handling information on this product, consult the Safety Data Sheet, (SDS).

**DIRECTIONS FOR USE**

1. Packages removed from storage should be allowed to return to ambient temperature before use.
2. Safe light is recommended during handling prior to curing. Dimmed light may be used, if the adhesive is only being handled for short periods of time.
3. This adhesive is designed to cure upon exposure to UV light. UV curing is particularly advantageous where a very rapid cure or curing of a thin section of the assembly is required.
4. Wide ranges of light systems are available for UV cure, permitting curing of bond profiles in seconds, coupled with a tack-free surface.
5. This adhesive contains a secondary thermal cure initiator to allow cure of bond areas shadowed from light.

**AVAILABILITY**

1. This adhesive is available in a variety of syringes, ranging from 3.0ml to 30ml.

**STORAGE:**

Store in original, tightly covered containers in clean, dry areas. Storage information may be indicated on the product container labeling.

**Optimal Storage : 10 °C**

Material removed from containers may be contaminated during use. Do not return product to the original container. Henkel Corporation cannot assume responsibility for product which has been contaminated or stored under conditions other than those previously indicated. If additional information is required, please contact your local Technical Service Center or Customer Service Representative.

**Conversions**

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$

$\text{kV/mm} \times 25.4 = \text{V/mil}$

$\text{mm} / 25.4 = \text{inches}$

$\text{N} \times 0.225 = \text{lb}$

$\text{N/mm} \times 5.71 = \text{lb/in}$

$\text{psi} \times 145 = \text{N/mm}^2$

$\text{MPa} = \text{N/mm}^2$

$\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$

$\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$

$\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$

$\text{mPa}\cdot\text{s} = \text{cP}$

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The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. The product can have a variety of different applications as well as differing application and working conditions in your environment that are beyond our control. Henkel is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product.

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