



Tru-Bond™ UB 20000

Universal Bonder, UV/Visible Light Cure Adhesive

PRODUCT DESCRIPTION

The Tru-Bond™ Universal Bonding Series of products bonds rigid substrates to flexible substrates with UV/Visible light. Tough, durable bonds are created making it possible to join glass, metals, ceramics and plastics that include; ABS, polycarbonate, PET, PETG, flexible vinyls, urethanes, acrylics and epoxy. The assemblies can survive thermal and humidity cycling while maintaining optical clarity. This formulation also cures through many translucent substrates, as well as, UV blocked plastics.

PRODUCT CHARACTERISTICS

Chemical Class	Urethane Acrylate
Appearance(uncured)	Clear liquid
Components	Single-requires no mixing
Viscosity	Medium

Optical Clarity, %	>98
Tensile strength, ASTM D412,psi(MPa)	718(4.95)
Elongation, ASTM D412,%	203
Modulus of Elasticity, ASTM D412, psi(MPa)	435(3.00)
Volume Shrinkage, %	5.8
Lineal Shrinkage, %	1.8
Water absorption, ASTM D570 (24 hrs.), %	7.5
Boiling Water, ASTM D570 (2 hrs.), %	4.3
Shore hardness	91A
Temperature range, °F(°C)	-65(-54) to 300(149)

TYPICAL PROPERTIES OF UNCURED MATERIALS

Specific gravity@23 °C	1.00
Viscosity@23 °C, Brookfield RV	
Spindle 3, 6 rpm, cP	21,000
Flashpoint, °F(°C)	171(77)
Non-Volatile Materials, %	>99
VOC, %	<1
Shelf life, mos	24
Solubility	ketones, oxygenated solvents

Adhesive Lap Shear	psi	MPa
Acrylic	584	4.03
Glass	700	4.83
Polycarbonate	663	4.57
Polycarbonate to steel	938	6.47

TYPICAL PROPERTIES OF CURED MATERIALS

Color.	Clear
Refractive Index	1.49

Fixture Time and Tack-free Time:

Light Souce	Irradiance	Fixture Time/Sec.	Tack free Time/Sec.
Fusion ® D bulb	1,000 mW/cm ²	< 1	< 4
Unvitron Intelli-Ray 600	40 mW/cm ²	< 2	N/A

Depth of Cure (inches, min):

Light Souce	Irradiance	Exposure Time 15 seconds
Unvitron Intelli-Ray 600	40 mW/cm ²	2.9 mm

PROCESSING

ITW products are easily applied by syringe dispense or specialty valve spray units. The materials cure extremely fast in bondlines, e.g. where the surfaces are not exposed to air, with UV or Visible radiation. Exposure doses range from .5 - 2 J/cm² depending on the intensity of the lamps and configuration of the assembly.

PRECAUTIONS

Please refer to the appropriate material safety data sheet (MSDS) prior to using this product.

STORAGE

Store the unopened product in a cool, dry, well ventilated location away from sources of heat. Optimal storage temperatures should range between **10 °C (50 °F) and 32 °C (90 °F)**. **Do not expose the product to light.** It may polymerize upon prolonged exposure to ambient or artificial light. Product removed from the containers during use should not be returned to original containers in order to avoid potential contamination.

**CONVERSIONS**

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$
 $\text{kV/mm} \times 25.4 = \text{V/mil}$
 $\text{mm} / 25.4 = \text{inches}$
 $\mu\text{m} / 25.4 = \text{mil}$
 $\text{N} \times 0.225 = \text{lb}$
 $\text{N/mm} \times 5.71 = \text{lb/in}$
 $\text{N/mm}^2 \times 145 = \text{psi}$
 $\text{MPa} \times 145 = \text{psi}$
 $\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$
 $\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$
 $\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$
 $\text{mPa}\cdot\text{s} = \text{cP}$

WARRANTY

ITW will replace any material found to be defective. Because the storage, handling and application of this material are beyond our control, we can accept no liability for the results obtained.

NOTE

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For technical assistance, please call: 1-800-933-8266 for NA and EU, 86-0512-63488388 for Asia

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