PRODUCT SPECIFICATION

MXCUR® 011

UV Curing Adhesive (Glass)

Description:

MXCUR® 011 is a low viscosity, fast curing, single component urethane methacrylate adhesive. **MXCUR® 011** is specifically formulated for bonding and sealing clear glass. **MXCUR® 011** cures rapidly when exposed to ultraviolet radiation specifically in the UVA region. The low viscosity makes it ideal for applications where wicking of the adhesive into preassembled parts is required.

Typical Properties of Cured/Uncured Material:

Uncured State Physical Properties		Properties of Cured Materials	
Base	Acrylic	Coefficient of thermal expansion, ASTM D 696, K^{-1}	100 x 10^{-6}
Colour	Transparent, pale straw colour	Coefficient of thermal conductivity, ASTM C 177	0.1 W/(m·K)
Chemical Form	Acrylate	Glass Transition Temperature, ASTM E 228, °C	45
Cure	Ultraviolet (UV)	Volumetric Shrinkage	8%
Cure Benefit	Production – High Speed Curing	Shore Hardness, ASTM D 2240, Durometer D	68
Components	Single requires no mixing	Elongation, at break, ASTM D 882, %	160%
Viscosity	Low	Tensile Strength, at break, ASTM D 882	N/mm^2 9 (psi) (13K)
Application	Bonding	Tensile Modulus, ASTM D 882	N/mm^2 420 (psi) (13K)
Specific Gravity @ 25°C	1.03	UV Depth of Cure, 100 mW/cm^2 @ 365nm 20 secs	≤0.8Nm
Viscosity @ 25°C (Brookfield LV-40Z at 2rpm)	60 – 120 mPas	Adhesive Properties	Typical Value
Flash Point	See MSDS	Cured @ 100 mW/cm2 @ 365 nm for 40 seconds Lap Shear Strength, ISO 4587	
Adhesive Properties	Typical Value	PVC to Glass	N/m^2 1 to 5 (psi) (725 to 2175)
Tensile Strength, ISO 6922:		ABS to Glass	N/m^2 1 to 5 (psi) (725 to 2175)
Steel pin (grit blasted) to glass	N/m^2 5 to 15 (psi) (725 to 2175)	Polycarbonate to Glass	N/m^2 1 to 5 (psi) (725 to 2175)

UV Intensity:

This product is cured when exposed to UV radiation of 365nm. To obtain full cure on surfaces exposed to air, Radiation @ 250 nm is also required.

Fixture Time

Fixture Time is defined as the time to develop shear strength of 0.1 N/mm2 UV fixture time, ISO 4587, Glass Microscope slides seconds:

- 6 mW/cm2 @ 365nm ≤10
- 100 mW/cm2 @ 365nm ≤5

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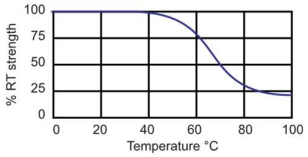
Environmental Resistance:

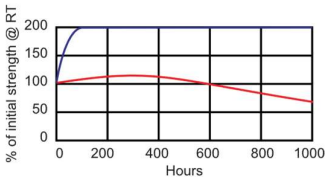
Hot Strength

Strength test procedure: ASTM D2095. DIN 53288
Substrate: Grit blasted mild steel pin to glass.
Cure procedure: 1 week 22°C after exposure for 10 seconds at 100mW/cm^2 365 nm



Heat Aging

Strength test procedure: ASTM D2095
Substrate: Grit blasted mild steel pin to glass.
Cure procedure: 1 week 22°C after exposure for 10 seconds under 365nm



Chemical/Solvent Resistance:

Environment	°C	% of initial strength		
		100 h	500 h	1000 h
Unleaded Petrol	22	85	85	85
Freon TA	22	85	75	0
Industrial methylated spirits	22	80	10	0
Heat/humidity 90% RH	40	65	40	30

Directions For Use:

1. The substrate surfaces must be clean and free from grease
2. Shake the product thoroughly before use.
3. Apply adhesive to substrate
4. Hold in position and apply recommended light source
5. The product should be allowed to develop full strength before subjecting to loads (Typically 24–72-hours dependent on substrate. Bond gap and ambient conditions)

Handling & Storage:

Storage: Keep products in the unopened container in a cool dry location. The product is best when stored at 8 to 24°C. Do not freeze. Keep the container tightly closed until ready for use.
Handling: Material removed from containers may be contaminated during use. Do not pour back any product to the original container. Misuse of product will void all warranties.

Disclaimer:

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