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910 & 912
Adhesives for Wire and Parts Tacking

Dymax UV curing tacking adhesives have been formulated to cure rapidly under long wave (365 nm) UV light at intensities above 20 mW/cm^2. Dymax 910 and 912 have been designed for wire and parts tacking on printed circuit boards. Dymax UV light-curable adhesives can also be used for a wide variety of strain relief and wire unitization applications. These products withstand thermal shock from soldering while resisting brief solvent and aqueous washes. Dymax wire tacking adhesives are thixotropic and designed for easy dispensing, yet they resist migration on the part. This product is in full compliance with RoHS directives 2015/863/EU.

DESCRIPTIONS

Light Weld® 910 is typically used as a flexible wire and parts tacking adhesive. While possessing high adhesion to boards and electronic parts, a tack can be mechanically removed. Heating the tack to 200°F or more facilitates removal.

Light Weld 912 has been formulated to cure rapidly under long wave UV light. Product 912 is designed for wire tacks on PCB's, withstands thermal shock from solder while resisting most solvent and aqueous washes.

*Meets Belcore TR-NWT-000078

UNCURED PROPERTIES

Solvent Content	None, 100% solids
Chemical Class	Urethane (Meth)Acrylate
Appearance	Light Straw
Flash Point	>200°F (95°C)
Solubility	Alcohols/Chlorinated Solvents
Toxicity	Low
Viscosity	Non flowing Thixotropic Paste

CURED PROPERTIES

	910	**912**
Durometer Hardness	A60	D85
UV Cured Film Thickness	0.5"	0.25"
Thermal Limit (brittle/degrades)	-50/300°F	-40/250°F
Tensile Strength Glass-to-Steel	500 psi	2,500 psi
Linear Coefficient of Expansion (in/in/°Cx10^{-6})	118	90
Dielectric Strength (Volts/mil)	500	1,800
Surface Resistivity (10^{12} Ohm)	60	380
Dielectric Constant at 1MHz	3.27	3.41
Dissipation Factor at 1MHz	0.05	0.03

CURE DATA

	910	912
Time to Full Cure*	<5 seconds	<6 seconds
Lamp/Lamp Dispenser	PC-3 or PC-3D	

*Individual wire tack; 1/16" bead placed on epoxy board -- intensity >100 mW/cm^2.

RoHS Compliant

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DISPENSING AND HANDLING ADHESIVE

Dymax 910 and 912 are available in various packages such as syringes, cartridges, bottles, and pails. It may be dispensed with a variety of automatic bench-top syringe applicators or other equipment as required. Direct questions relating to dispensing and curing systems for specific applications to Dymax Application Engineering.

Wear impervious gloves and/or barrier cream. Repeated or continuous skin contact with liquid adhesive will cause irritation and should be avoided. Do not wear absorbent gloves. Remove adhesive from skin with soap and water. Never use solvents to remove adhesive from skin or eyes.

STORAGE AND SHELF LIFE

Store material in cool dark place when not in use. Do not expose to UV light or sunlight. Material may polymerize upon prolonged exposure to ambient light. Replace lid immediately after useThis material has an 18-month shelf life from date of manufacture, unless otherwise specified, when stored between 10°C (50°F) and 35°C (90°F) in the original, unopened container.

CAUTION

For industrial use only. Avoid breathing vapors. Avoid contact with eyes and clothing. In case of contact, immediately flush with water for at least 15 minutes; get medical attention. Wash clothing before reuse. Keep out of reach of children. Do not take internally. If swallowed, induce vomiting at once and call a physician. Repeated or continuous skin contact with liquid adhesive will cause irritation and should be avoided. For specific information, refer to the product Material Safety Data Sheet.

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.

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