

628-VLV Wicking Grade Structural Adhesive

Dymax 628-VLV forms high-strength bonds to glass, metal, phenolic, filled Nylon, ferrite, ceramic, and other materials. Its low viscosity makes it suitable for use as a protective coating, or in applications requiring bonding of very close-fitting surfaces, or where wicking into cracks and crevices is desired. This product is in full compliance with RoHS directives 2015/863/EU.

TYPICAL UNCURED PROPERTIES (not specifications)

Solvent Content	None - 100% Reactive Solids	
Chemical Class	Urethane Acrylate	
Appearance	Clear/Straw Liquid	
Flash Point	>93°C (200°F)	
Solubility	Alcohols/Chlorinated Solvents/Ketones	
Viscosity	55 cP (nominal)	ASTM D-1804

TYPICAL CURED PROPERTIES (not specifications)

PHYSICAL

Durometer Hardness	D75	ASTM D-2240
Elongation at Break	30%	ASTM D-638
Tensile at Break	3,900 psi (26.8 N/mm ²)	ASTM D-638
Water Absorption (24 h)	2.8%	ASTM D-570
Linear Shrinkage	3%	DSTM D-101*

THERMAL

Coefficient of Linear Thermal Expansion	90 x 10 ⁻⁶ in/in/°C	ASTM D-696
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ELECTRICAL

Dielectric Strength	1,600 V/mil	ASTM D-1304
Volume Resistivity	7.5 x 10 ¹³ Ω*cm	ASTM D-1304
Surface Resistivity	2.2 x 10 ¹⁴ Ω	ASTM D-1304
Dissipation Factor, 1 MHz	0.06	ASTM D-1304
Dielectric Constant, 1 MHz	4.10	ASTM D-1304

*DSTM refers to Dymax Standard Test Method

CURE DATA

Using 365 nanometer UV light:

	Cure Time <u>(seconds)</u>	Intensity ⁽¹⁾ <u>mW/cm²</u>	Dymax Light-Welder® <u>Lamps</u>
Fixture between glass slides	1-5	50	2000-EC
Depth of cure (0.125 inch)	60	50	2000-EC

HEAT-CURE DATA (Secondary)

Heat may be used as a secondary cure for shadow areas, but only after product has been cured with UV. The following is a guide and is dependent on the amount of material to be cured:

<u>Minimum Temperature</u>	<u>Time</u>
110°C (225°F)	60 Minutes
120°C (250°F)	30 Minutes
150°C (300°F)	15 Minutes

DISPENSING AND HANDLING ADHESIVE

This material may be dispensed with a variety of manual and automatic applicators or other equipment as required. Questions relating to dispensing and curing systems for specific applications should be referred 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 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 has an 18-month shelf life from date of manufacture when stored 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.

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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