



## Multi-Cure<sup>®</sup> 6-630

### Glass-to-Metal Bonding Adhesive with Secondary Heat Cure

#### APPLICATIONS

- Glass Fixtures and Furniture
- Automotive Latches
- Potting
- Structural Glass Assemblies
- Consumer Packaging

#### FEATURES

- UV/Visible Light Cure
- Secondary Heat Cure
- High-Temperature Resistant
- Moisture Resistant
- High Adhesion to Glass and Metal
- Activator Cure
- Clear Bonds
- Flexible

#### RECOMMENDED SUBSTRATES

- Metals
- Glass
- Plastics

Dymax Multi-Cure<sup>®</sup> 6-630 cures upon exposure to light and is designed for rapid assembly of parts made of metal, glass, ceramic, phenolic, filled polyamide, and other materials. Dymax 6-630 is specially formulated to cure with heat in applications where shadow areas exist. Dymax Multi-Cure materials contain no nonreactive solvents and their ability to cure in seconds enables faster processing, greater output, and lower processing costs. When cured with Dymax light-curing spot lamps, focused-beam lamps, or flood lamps, they deliver optimum speed and performance for industrial product assembly. Dymax lamps offer the ideal balance of UV and visible light for the fastest, deepest cures. This product is in full compliance with RoHS directives 2015/863/EU.

#### UNCURED PROPERTIES \*

| Property  | Value                        | Test Method |
|---|------------------------------|-------------|
| Solvent Content   | No Nonreactive Solvents      | N/A         |
| Chemical Class  | Acrylated Urethane           | N/A         |
| Appearance  | Colorless Transparent Liquid | N/A         |
| Soluble in  | Organic Solvents             | N/A         |
| Density, g/ml   | 1.05                         | N/A         |
| Viscosity, cP (20 rpm)  | 500                          | DSTM 502    |
| Shelf Life at Recommended Conditions from Date of Manufacture | 12 months                    | N/A         |

#### CURED MECHANICAL PROPERTIES \*

| Property                         | Value        | Test Method |
|----------------------------------|--------------|-------------|
| Durometer Hardness               | D70          | ASTM D2240  |
| Tensile at Break, MPa [psi]      | 22.4 [3,250] | ASTM D638   |
| Elongation at Break, %           | 93           | ASTM D638   |
| Modulus of Elasticity, MPa [psi] | 407 [59,000] | ASTM D638   |

#### OTHER CURED PROPERTIES \*

| Property                             | Value | Test Method |
|--------------------------------------|-------|-------------|
| Refractive Index (20°C)              | 1.48  | ASTM D542   |
| Boiling Water Absorption, % (2 h)    | 1.8   | ASTM D570   |
| Water Absorption, % (25°C, 24 h)     | 4.4   | ASTM D570   |
| Linear Shrinkage, %                  | 0.5   | ASTM D2566  |
| Glass Transition T <sub>g</sub> , °C | 96    | ASTM D5418  |
| CTE <sub>α1</sub> , μm/m/°C          | 100   | ASTM E831   |
| CTE <sub>α2</sub> , μm/m/°C          | 195   | ASTM E831   |

#### TYPICAL PERFORMANCE OF CURED MATERIAL \*

| Property  | Value        | Test Method |
|---|--------------|-------------|
| Glass-to-Stainless Steel Compression, MPa [psi] | 17.2 [2,500] | DSTM 251‡   |
| Glass-to-Glass Compression, MPa [psi]           | 20.6 [3,000] | DSTM 250‡   |

#### DISPENSE EQUIPMENT RECOMMENDATIONS \*

| Application | Manual | Semi-Automated  | Fully Automated |
|-------------|--------|-----------------|-----------------|
| Dots/Beads  | SD-100 | Model 400 Valve | eco-PEN450      |

#### ADHESION

| Substrate                           | Recommendation |
|-------------------------------------|----------------|
| ABS acrylonitrile-butadiene-styrene | ✓              |
| PA polyamide                        | ✓              |
| PI polyimide                        | ✓              |
| PS polystyrene                      | ✓              |
| PVC poly(vinyl chloride)            | ✓              |
| GL glass                            | ✓              |
| CER ceramic                         | ✓              |
| SS stainless steel                  | ✓              |
| AL aluminum                         | ✓              |

✓ Recommended      ○ Limited Applications  
 † Requires Surface Treatment (e.g. plasma, corona treatment, etc.)

\* Not Specifications

N/A Not Applicable

‡ DSTM Refers to Dymax Standard Test Method

© 2023 Dymax Corporation. All rights reserved.

All trademarks in this guide, except where noted, are the property of, or used under license by Dymax Corporation, U.S.A.

Technical Data Collected 2018 Rev.02/10/2023





## CURING GUIDELINES

Fixture time is defined as the time to develop a shear strength of 0.1 N/mm<sup>2</sup>[10 psi] between glass slides. Actual cure time typically is 3-to-5 times fixture time.

| Dymax Curing System (Intensity)                                       | Fixture Time or Belt Speed<br>A |
|---|---------------------------------|
| 2000-EC (50 mW/cm <sup>2</sup> ) <sup>B</sup>                         | 3 s                             |
| 5000-EC (200 mW/cm <sup>2</sup> ) <sup>B</sup>                        | 2 s                             |
| BlueWave® LED Prime UVA (10 W/cm <sup>2</sup> ) <sup>C</sup>          | 3.6 s                           |
| BlueWave® 75 (5.0 W/cm <sup>2</sup> ) <sup>B</sup>                    | 3.4 s                           |
| BlueWave® 200 (10 W/cm <sup>2</sup> ) <sup>B</sup>                    | 2.8 s                           |
| UVCS Conveyor with one 5000-EC (200 mW/cm <sup>2</sup> ) <sup>D</sup> | 3.6 m/min [12 ft/min]           |
| UVCS Conveyor with Fusion F300S (2.5 W/cm <sup>2</sup> ) <sup>D</sup> | 7.1 m/min [23.5 ft/min]         |

**A** Curing through light-blocking substrates may limit the ability of See-Cure adhesives to transition from blue to clear and may require longer light exposure at critical wavelengths (320-400 nm for UV light curing; 20-450 nm for UV/Visible light curing). These time s/speeds are typical for curing through 100% light-transmitting substrates.

**B** Intensity was measured over the UVA range (320-395 nm) using a Dymax ACCU-CAL™ 50 Radiometer.

**C** Intensity was measured over the UVA/Visible range (250-450 nm) using a Dymax ACCU-CAL™ 50-LED Radiometer.

**D** At 53 mm [2.1 in] focal distance. Maximum speed of conveyor is 8.2 m/min [27 ft/min]. Intensity was measured over the UVA range (320-395 nm) using the Dymax ACCU-CAL™ 160 Radiometer.

Full cure is best determined empirically by curing at different times and intensities, and measuring the corresponding change in cured properties such as tackiness, adhesion, hardness, etc. Full cure is defined as the point at which more UV exposure no longer improves cured properties.

## SECONDARY HEAT CURE

Heat can be used as a secondary cure mechanism where the adhesive cannot be cured with light. Light curing must be done prior to heat cure. The following heat cure schedule may be used:

| Temperature   | Time*      |
|---------------|------------|
| 110°C [230°F] | 60 minutes |
| 120°C [250°F] | 30 minutes |
| 150°C [300°F] | 15 minutes |

\*Note: Actual heat-cure time may vary due to part configuration, volume of adhesive applied, and oven efficiency.

## ACTIVATOR CURE

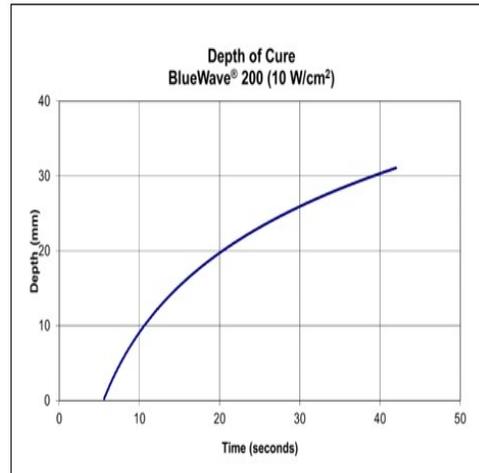
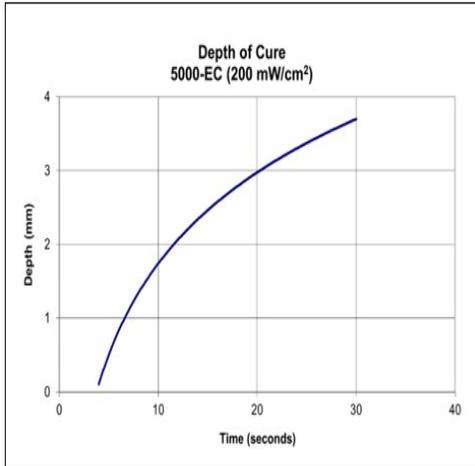
**Shadow areas can be cured with activator.**

Activator is placed on one surface and the adhesive on the mating surface. Curing takes place at room temperature when the parts are mated. Activator requires closely mated parts (up to 0.5 mm [0.02 in] gap). Closely mated parts fixture (achieve handling strength) in less than a minute. See Dymax Technical Bulletin "Guidelines for Activator Curing" for complete instructions for all activators.

Dymax recommends that customers employ a safety factor by curing longer, at higher intensity, and/or at higher temperature than required for full cure. Although Dymax Application Engineering can provide technical support and assist with process development, each customer ultimately must determine and qualify the appropriate curing parameters required for their unique application.

### DEPTH OF CURE

The graphs below show the increase in depth of cure as a function of exposure time with two different lamps at different intensities. A 9.5 mm [0.37 in] diameter specimen was cured in a polypropylene mold and cooled to room temperature. It was then released from the mold and the cure depth was measured. These depths are only due to light cure.



### OPTIMIZING PERFORMANCE AND HANDLING

1. This product cures with exposure to UV and visible light. Exposure to ambient and artificial light should be kept to a minimum before curing. Dispensing components including needles and fluid lines should be 100% light blocking, not just UV blocking.
2. All bond surfaces should be clean and free from grease, mold release, or other contaminants prior to dispensing the adhesive.
3. Cure speed is dependent upon many variables, including lamp intensity, distance from the light source, required depth of cure, bond gap, and percent light transmission of the substrate.
4. Oxygen in the atmosphere may inhibit surface cure. Surfaces exposed to air may require high-intensity (>100 mW/cm<sup>2</sup>) UV light to produce a dry surface cure. Flooding the bond area with an inert gas, such as nitrogen, can also reduce the effects of oxygen inhibition.
5. Parts should be allowed to cool after cure before testing and subjecting to any loads.
6. In rare cases, stress cracking may occur in assembled parts. Three options may be explored to eliminate this problem. One option is to heat anneal the parts to remove molded-in stresses. A second option is to open the gap between mating parts to reduce stress caused by an interference fit. The third option is to minimize the amount of time the liquid adhesive remains in contact with the substrate(s) prior to curing.
7. Light curing generally produces some heat. If necessary, cooling fans can be placed in the curing area to reduce the heating effect on components.
8. At the point of curing, an air exhaust system is recommended to dissipate any heat and vapors formed during the curing process.

### 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 shelf life is noted on page 1 of this document, when stored between 10°C (50°F) and 32°C (90°F) in the original unopened container.

### CLEAN UP

Uncured material may be removed from dispensing components and parts with organic solvents. Cured material will be impervious to many solvents and difficult to remove. Cleanup of cured material may require mechanical methods of removal.



## 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.

Numerous factors—including, without limitation, transport, storage, processing, the material with which the product is used, and the ultimate function or purpose for which the product was obtained—may affect the product's performance and/or may cause the product's actual behavior to deviate from its behavior in the laboratory. None of these factors are within Dymax's control. Conclusions about the behavior of the product under the user's particular conditions, and the product's suitability for a specific purpose, cannot be drawn from the information contained in this document.

It is the user's responsibility to determine (i) whether a product is suitable for the user's particular purpose or application and (ii) whether it is compatible with the user's intended manufacturing process, equipment, and methods. Under no circumstances will Dymax be liable for determining such suitability or compatibility. Before the user sells any item that incorporates Dymax's product, the user shall adequately and repetitively test the item in accordance with the user's procedures and protocols. Unless specifically agreed to in writing, Dymax will have no involvement in, and shall under no circumstances be liable for, such testing.

Dymax makes no warranties, whether express or implied, concerning the merchantability of this product or its fitness for a particular purpose. Nothing in this document should be interpreted as a warranty of any kind. Under no circumstances will Dymax be liable for any injury, loss, expense or incidental or consequential damage of any kind allegedly arising in connection with the user's handling, processing, or use of the product. It is the user's responsibility to adopt appropriate precautions and safeguards to protect persons and property from any risk arising from such handling, processing, or use.

The specific conditions of sale for this product are set forth in Dymax's [General Terms & Conditions of Sale](#). Nothing contained herein shall act as a representation that the product use or application is free from patents owned by Dymax or any others. Nothing contained herein shall act as a grant of license under any Dymax Corporation Patent.

Except as otherwise noted, all trademarks used herein are trademarks of Dymax. The "®" symbol denotes a trademark that is registered in the U.S. Patent and Trademark Office.

The contents of this document are subject to change. Unless specifically agreed to in writing, Dymax shall have no obligation to notify the user about any change to its content.

## CONTACT DYMAX

[www.dymax.com](http://www.dymax.com)

### Americas

USA | +1.860.482.1010 | [info@dymax.com](mailto:info@dymax.com)

### Europe

Germany | +49 611.962.7900 | [info\\_de@dymax.com](mailto:info_de@dymax.com)

Ireland | +353 21.237.3016 | [info\\_ie@dymax.com](mailto:info_ie@dymax.com)

### Asia

Singapore | +65.67522887 | [info\\_ap@dymax.com](mailto:info_ap@dymax.com)

Shenzhen | +86.755.83485759 | [dymaxasia@dymax.com](mailto:dymaxasia@dymax.com)

Hong Kong | +852.2460.7038 | [dymaxasia@dymax.com](mailto:dymaxasia@dymax.com)

Korea | +82.31.608.3434 | [info\\_kr@dymax.com](mailto:info_kr@dymax.com)