

**CE3317M-6 UV****PRODUCT DESCRIPTION**

CE3317M-6 UV

provides the following product characteristics:

Technology	Epoxy/Acrylate
Appearance	Amber
Product Benefits	Dual cure
Cure	Ultraviolet (UV) light, Heat cure
Application	Assembly
Typical Assembly Applications	Image sensor module assemblies

CE3317M-6 UV dual cure adhesive is designed for use in the assembly of temperature sensitive electronic components. The maximum performance of this material is achieved by exposure to UV light of sufficient intensity, followed by thermal cure.

**TYPICAL PROPERTIES OF UNCURED MATERIAL**

Viscosity, mPa • s (cP):

@ 25° C 8,000

Specific Gravity 1.2

Pot life @ 25 ° C, days 7

**TYPICAL CURING PERFORMANCE**

Recommended UV Cure

Light Source and Condition:

Medium pressure mercury lamp

UV Wavelength, nm 220 to 260

Light Intensity, mW/cm<sup>2</sup> 100

UV Tack-Free Time, seconds 1

**Recommended Heat Cure**

30 minutes @ 60° C

25 minutes @ 70° C

20 minutes @ 80° C

The above cure profile is a guideline recommendation. Cure rate and ultimate depth of cure depend on light intensity, spectral distribution of light source, exposure time and the light transmittance of the substrate.

**CE3317M-6 UV**

With all fast cure systems, the minimum required time for cure depends on the rate of heating. Cure rate depends on the mass of the material to be heated and intimate contact with the heat source. Use suggested cure conditions as general guidelines. Other cure conditions may yield satisfactory results.

**TYPICAL PROPERTIES OF CURED MATERIAL**

Sample cured 5 secs @ 100 mW/cm<sup>2</sup> plus 30 min @ 80° C

Physical Properties:

Hardness, Shore D, ASTM D2240	88
Glass Transition Temperature (T <sub>g</sub> ) by TMA, ° C	85
Coefficient of Thermal Expansion :	
Alpha 1, cm/cm/°C	49×10 <sup>-6</sup>
Alpha 2, cm/cm/°C	175×10 <sup>-6</sup>
Volume Shrinkage on Cure, %	2.4
Linear Shrinkage on Cure, %	1.3

**TYPICAL PERFORMANCE OF CURED MATERIAL**

Sample cured 2 secs @ 100 mW/cm<sup>2</sup> plus 30min @ 80° C

Lap Shear Strength :

Polycarbonate	N/mm <sup>2</sup>	1.8
	(psi)	(261)

**Storage**

Store product in the unopened container in a dry location. Storage information may be indicated on the product container labeling.

**Optimal Storage : 2 to 8 ° C**

Material removed from containers may be contaminated during use. Do not return product to the original container. Longain Corporation cannot assume responsibility for product which has been contaminated or stored under conditions other than those previously indicated. If additional information is required, please contact your local Technical Service Center or Customer Service Representative.