

### PRODUCT DESCRIPTION

**SEALTEC 1312** is odorless light-curing cyanoacrylate adhesive. It is designed for bonding applications that require very rapid fixture, fillet cure or surface cure. The UV and visible light cure properties facilitated rapid curing of exposed surface area and makes it a unique product in the world of light-curing adhesive.

**SEALTEC 1312** offers the following characteristics:

<b>Technology</b>	Cyanoacrylate / UV / Visible
<b>Chemistry</b>	Alkoxyethyl Cyanoacrylate with photoinitiator
<b>Appearance</b> (uncured)	Transparent, yellow liquid
<b>Components</b>	One part – requires no mixing
<b>Viscosity</b>	Medium
<b>Cure</b>	Ultraviolet (UV) light
<b>Secondary cure</b>	Humidity

### TYPICAL PROPERTIES OF UNCURED MATERIAL

	Typical Value
<b>Specific Gravity @ 25 °C, g/cm<sup>3</sup></b>	1.13
<b>Viscosity @ 25 °C, mPa·s</b>	600 - 1200

### TYPICAL CURING PERFORMANCE

#### TACK FREE TIME

Tack Free Time is the time in seconds required to achieve a tack free surface.

#### UV/Visible Light Sources:

Electrodeless, V bulb:  
70 mW/cm<sup>2</sup>, measured @ 365 nm: < 10 s.

Electrodeless, H bulb:  
30 mW/cm<sup>2</sup>, measured @ 365 nm: < 10 s.  
100 mW/cm<sup>2</sup>, measured @ 365 nm: < 10 s.

#### Visible Light Sources:

Blue light laser:  
70 mW/cm<sup>2</sup>, measured @ 445 nm: < 10 s.

#### CURE SPEED vs. SUBSTRATE (non-UV/Vis cure)

The rate of cure will depend on the substrate used. The table below shows the fixture time achieved on different materials at room temperature. This is defined as the time at which an adhesive bond (250 mm<sup>2</sup>) is capable of supporting a 3 kg load for 10 seconds. Fixture time measurements relate to non-UV/Visible cure.

	Fixture Time (seconds)
<b>ABS</b>	15
<b>Acrylic</b>	80
<b>Polycarbonate</b>	40
<b>PVC</b>	140

### TYPICAL PERFORMANCE OF CURED MATERIAL

#### TENSILE SHEAR STRENGTH

The shear strength will depend on the substrate. The Table below shows the shear strength for different substrates using lap shears according to ISO 4587.

Data for 24-h curing in dark room and 10-second curing with UV/Vis light source.

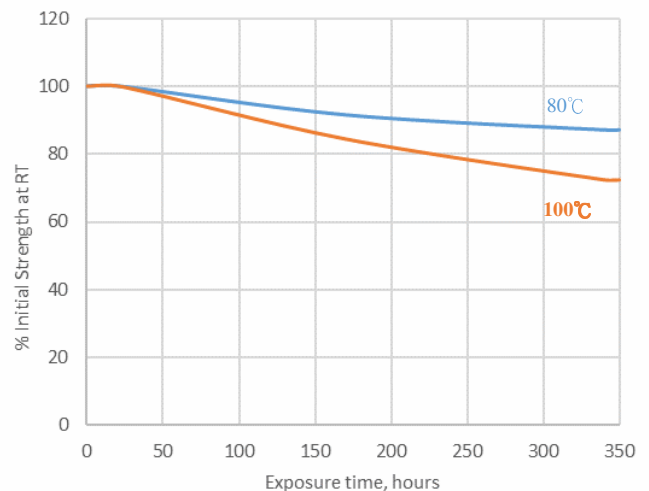
	Strength (N/mm <sup>2</sup> ) After 24 h RT Non-UV/Vis cure	Strength (N/mm <sup>2</sup> ) After 10 s curing with UV/Vis light
<b>ABS</b>	11.7*	7.3*
<b>Acrylic</b>	7.6*	8.3*
<b>Polycarbonate</b>	11.9*	7.2*
<b>PVC</b>	6.5*	5.9*

\*Substrate failure

### TYPICAL ENVIRONMENTAL RESISTANCE

#### Heat Aging

Cured @ 30 mW/cm<sup>2</sup>, measured @365nm, for 10 seconds plus 24 hours post cure @22 °C. Aged at temperature indicated and tested @22°C.



#### Chemical/Solvent Resistance

Aged under conditions indicated and tested @25°C

Environment	Temp. °C	% of initial strength		
		100 hrs	500 hrs	1000 hrs
Water	25	87	75	60
Ethanol	25	93	88	88
Isopropanol	25	100	101	101
Water/Glycol	25	88	77	64
Unleaded Gasoline	25	97	94	97
Motor Oil	25	100	94	101
98% Relative Humidity	40	84	73	62

#### Chemical/Solvent Resistance

Aged under conditions indicated and tested @25°C

Lap Shear Strength, ISO 4587/ASTM D1002/JIS K6850  
PC (Polycarbonate)

Environment	Temp. °C	% of initial strength		
		100 hrs	500 hrs	1000 hrs
Air	25	101	98	102
98% Relative Humidity	40	91	86	64

\*substrate failure

#### GENERAL INFORMATION

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials. For safe handling information on this product, consult the Safety Data Sheet (SDS):

#### Directions for use:

- 1) This product is light sensitive; exposure to daylight, UV light and artificial light should be kept to a minimum during storage and handling.
- 2) For best performance bond surfaces should be clean and free from grease.
- 3) This product performs best in thin bond gaps (0.05 mm)
- 4) Excess adhesive can be dissolved with nitromethane or acetone.

#### Conversions:

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$   
 $\text{kV/mm} \times 25.4 = \text{V/mil}$   
 $\text{mm} / 25.4 = \text{in}$   
 $\mu\text{m} / 25.4 = \text{mil}$   
 $\text{N} \times 0.225 = \text{lb}$   
 $\text{N/mm} \times 5.71 = \text{lb/in}$   
 $\text{N/mm}^2 \times 145 = \text{psi}$   
 $\text{MPa} \times 145 = \text{psi}$   
 $\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$   
 $\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$   
 $\text{mPa}\cdot\text{s} = \text{cP}$

#### Storage & Handling precaution

Keep adhesive in a cool and dry place. The storage temperature is recommended at 8 °C - 24 °C. For details, consult the Material Safety Data Sheet, (MSDS). Shelf life is twelve months from the date of manufacture in the original container under the optimal conditions.

1. Avoid contact with skin and eyes.
2. If contact with skin, rinse with water.
3. If adhesive gets into eye, keep eye open and rinse with water thoroughly. Seek medical attention immediately.
4. Keep the material out of children's reach.

#### Note:

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