



Technical Data Sheet

Light-Curable Adhesives, Sealants, and Masks

Product 3881

Wicking viscosity, LED curable adhesive for glass repair and assembly.

Tangent Product 3881 is a solvent-free, UV/Visible light curable adhesive that forms resilient, high strength bonds between many materials including glass, steel, aluminum, and stainless steel. When properly cured, bonds prepared with Product 3881 are extremely clear, tack-free, and highly resistant to moisture and yellowing. The extremely low viscosity of this product is ideal for assemblies that depend on capillary action to wick the adhesive into the bond joint. This product is well suited for environments of recurring thermal cycling. Product 3881 cures rapidly with broad spectrum UV lamps, (320-450nm). High intensity is not required. Monochromatic LED light sources may also be used. LED output of 365nm or 405nm is recommended for curing this adhesive.

UNCURED PROPERTIES

COMPOSITION	Aliphatic Urethane Acrylate / Monomer Blend
VISCOSITY	10-150 cP [Brookfield 25° C., 30 RPM]
APPEARANCE	Transparent liquid with a slight yellowish tint
SPECIFIC GRAVITY	1.1 - 1.3 at 25° C.
FLASH POINT	200° F.
TOXICITY	Refer to Material Safety Data Sheet
SHELF LIFE	One year

CURED PROPERTIES

SHORE HARDNESS, DUROMETER	D 55 - 65
WATER ABSORPTION, %	
24 hour immersion at 25° C	Less than 1%
TEMPERATURE RANGE	-40° C to + 140° C
REFRACTIVE INDEX	1.504 at 220° C

**THE VALUES NOTED IN THIS TECHNICAL DATA SHEET ARE TYPICAL PROPERTIES.
THEY ARE NOT INTENDED TO BE USED AS PRODUCT SPECIFICATIONS.**

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CURE DATA / GUIDELINES [Glass substrates, 0.002-0.004 inch (0.050-0.100mm) bond gap, time in seconds]

Honle Bluepoint LED	Spot Curing System, 405 nm,	2000 mW/cm ²	1 second
Honle Spot 100 LED	Flood Curing System, 405 nm,	250 mW/cm ²	1-2 seconds
Honle Bluepoint 4	Spot Curing System, 320-450 nm,	2000 mW/cm ²	1 second

Note: Actual cure rate in a production environment is dependent upon light source intensity, bond line distance from the light source, bond line gap or required depth of cure, and percentage of light transmission through the substrate covering the bond line. Please consult with Tangent Applications Engineering for assistance with curing equipment selection and process optimization.

PACKAGING OPTIONS - Standard packaging for this product includes 10 and 30 gram syringes, 300 gram cartridges, one kilogram bottles, and 17 kilogram pails. Other packaging options may be available upon request.

STORAGE – This is light sensitive material. Containers must remain covered when not in use.

Minimize exposure of uncured material to daylight, artificial light, and UV light during storage and handling. Store uncured product in its original, closed container in a dry location. Unless otherwise indicated on the product label, optimal storage temperatures are 10 to 30°C, (50 to 86°F). Any material removed from the original container must not be returned to the container as it could be contaminated. Tangent Industries cannot assume responsibility for products that were improperly stored, contaminated, or repackaged into other containers.

HANDLING AND CLEAN-UP – For safe handling information, consult this product's **Material Safety Data Sheet (MSDS)** prior to use. Uncured material may be wiped away from surfaces with organic solvents. Do not use solvents to remove material from eyes or skin!

USING THE PRODUCT – Prior to dispensing, ensure that each surface coming in contact with this product is clean and free of grease, mold release, or other contaminants. Dispense directly from the package, or utilize appropriate dispensing equipment that is compatible with light-curable adhesives and coatings. Fluid lines and dispense tips must be 100% light blocking. Curing stations should be equipped with air exhaust systems to evacuate vapors and heat generated during the curing process. After curing, this product must be allowed to cool to ambient temperature before testing the product's performance.

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