



# Technical Data Sheet

Light-Curable Adhesives, Sealants, and Masks

## Product 6162

### Low durometer, LED curable medical device adhesive for bonding flexible plastics and stainless steel.

**Tangent Product 6162** is a UV / Visible light curable material that is very flexible after cure. This product adheres to polyurethane, PVC, and other high elongation plastics as well as dissimilar materials including stainless steel and ceramic. When properly cured, Product 6162 is clear and highly resistant to moisture and yellowing. Interfacial bonds cure quickly with broad spectrum UV lamps (320-450nm), as well as monochromatic LED systems. For optimal curing with LED systems, outputs of 365nm or 405nm are recommended. Product 6162 has passed the testing required for USP Class VI biocompatibility approval. This product is compatible with typical sterilization methods including gamma, ethylene oxide, and limited autoclave.

#### UNCURED PROPERTIES

COMPOSITION	Urethane Acrylate / Monomer Blend
VISCOSITY	400-800 cps at 25° C.
APPEARANCE	Clear liquid with slight yellow tint
SPECIFIC GRAVITY	1.1 - 1.2 at 25° C.
FLASH POINT	200° F.
TOXICITY	Refer to Material Safety Data Sheet
SHELF LIFE	One Year

#### CURED PROPERTIES

SHORE HARDNESS, DUROMETER	D 25 - 35
WATER ABSORPTION, % 24 hour immersion at 22° C	<1%
TEMPERATURE RANGE	- 40° C to +140° C

#### OTHER CURED PROPERTIES

<b>BIOCOMPATIBILITY TESTING, USP Class VI</b> (certificate copies on file)	Cytotoxicity	Pass
	Irritation/Intracutaneous	Pass
	Acute Systemic Toxicity	Pass
	Implantation-14 day	Pass

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

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.

**THE VALUES NOTED IN THIS TECHNICAL DATA SHEET ARE TYPICAL PROPERTIES AND ARE NOT MEANT TO BE USED AS PRODUCT SPECIFICATIONS.** The information contained in this data sheet is believed to be accurate and is provided for information only. Tangent Industries, Inc. makes no representation or warranties of any kind concerning this information. **It is the user's responsibility to determine the suitability of this product for any intended use.**

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