



Technical Data Sheet

Light-Curable Adhesives, Sealants, and Masks

Product 7939-S-F

Fast curing, high strength, LED light curable adhesive for polycarbonate and stainless steel. Fluoresces for automated inspection.

Tangent Product 7939-S-F is a solvent-free, UV / Visible light curable adhesive. It is well suited for bonding polycarbonate, PVC, styrene, and polyester, as well as dissimilar materials including stainless steel, ceramic and glass. Similar to Tangent Product 7939-V-F, this product has been formulated for faster curing with LED systems. When properly cured, Product 7939-S-F is clear, tack-free, and possesses a high resistance to moisture. This product is well suited for environments of recurring thermal cycling. Product 7939-S-F cures extremely fast with broad spectrum UV lamps, (320-420nm) and monochromatic LED light sources. LED output of 365nm or 405nm is recommended for curing this adhesive. Product 7939-S-F has been formulated to pass USP Class VI biocompatibility requirements. It is well suited for bonding needles, syringes, stylets, and catheters. This product is compatible with commonly used sterilization methods including gamma, EtO, and limited autoclave. Product 7939-S-F fluoresces bright blue when exposed to low intensity UV light ("black light") typically used by automated vision systems for high speed production.

UNCURED PROPERTIES

COMPOSITION	Aliphatic Urethane Acrylate / Monomer Blend
VISCOSITY	200-400 cP [Brookfield 25° C., 30 RPM]
APPEARANCE	Slight yellow to light amber colored liquid
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 60 - 65
WATER ABSORPTION, % 24 hour immersion at 25° C	< 4%
TEMPERATURE RANGE	-45° C – 140° C
FLUORESCING	Bright blue color

**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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