An ISO 9001 Registered Company

Technical Datasheet
OPTOCAST
AC-3715

OPTOCAST AC-3715 is a 100% solids, one component acrylate based laminating adhesive for glass, aluminum and various polymeric substrates. It is cured to a hard solid upon exposure to UV light from 320-390 nm wavelength range. There are two **OPTOCAST AC-3715** versions with different cure options.

	AC-3715	**AC-3715-HM**
Curing Condition:	UV Cure Only	UV and Heat cure @ 125°C
Shelf Life/Storage:	12 month at 20-25°C	6 months @ 0°C or less
Shipping Condition:	Ambient	Recommended Frozen
Pot Life @ 20-25°C:	12 months	21 days
Viscosity:	6000-8000 cps	6000-8000 cps
Color:	Clear	Clear

Properties Cured

Color:	Clear in very thin sections
Hardness:	45-55
Tg:	<0°C
Liquid Refractive Index:	Not determined

Cure Profile

OPTOCAST AC-3715 can be cured with UV light wavelengths from 320 to 390 nm. Surfaces exposed to air may remain tacky.

- ♦Minimum light intensity using a spot cure is 500 mW/cm2. Minimum light intensity using a flood cure is 40 mW/cm2.
- ♦Minimum light cure times start at 2-3 seconds.
- ♦Minimum heat cure temperature is 125°C. Minimum heat cure time is 5 minutes.
- ♦Always wear proper eye protection when working with UV light.

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Shipping and Unpacking Procedure

AC-3715-HM are packed and shipped in dry ice at –75°C. It is a stable material but should be refrigerated at 0°C or less upon receipt.
AC-3715 is packed and shipped at ambient temperature. Store away from heat and light at 20-25°C upon receipt.

♦ It is critical that the shipping container is not opened in transit and is expedited to its final destination.
♦ DO NOT ALLOW THE SHIPMENT TO BE LEFT ON LOADING DOCKS, IN CUSTOMS WAREHOUSES, OR ON FREIGHT TRUCKS FOR EXTENDED TIME PERIODS.
♦ Maintaining temperature at 5°C or less upon receipt is critical to maintain the functionality and performance of the material.
♦ Failure to maintain these temperatures will void any warranties and will adversely affect the materials performance.
♦ Upon receipt, the syringes should be transferred from the shipping container to a freezer at 5°C or less.
♦ Care must be taken during this step as a sudden increase in temperature can cause irreversible air voids due to the thermal expansion of the syringe barrels.

Storage and Thawing
Prior to application, the material must be allowed to thaw naturally to room temperature (ideally 20-25°C) by placing the syringes in a vertical position with dispense tip facing downward. This is a critical step for obtaining optimum dispensing performance.

♦ Under no circumstance should artificial heat sources be used to increase thaw speed.
♦ Do not place the syringes in, or near, any heat source including ovens, hot plates, hot air guns, etc. to speed thawing.
♦ Thaw time varies by package style, size, and ambient temperature, but is typically 30 to 120 minutes.
♦ Do not attempt to dispense the material before it reaches ambient temperature.
♦ Wipe all excess moisture or condensation from the syringes prior to use.
♦ A small amount of air in the tip area is normal. Carefully remove the tip cap and manually extrude a small amount of material. This will displace any air that may be in the tip area.
♦ A small amount of air may accumulate at the rear of the syringe near the piston. This is also normal and this air can easily be removed by manually placing a light amount of pressure on the piston near the location of the visible air with the tip cap in place. This will force the air to by-pass the piston and exit the rear of the syringe. Mount the syringe onto the dispense equipment and purge material through the system until an unbroken flow of material is extruded.

3/2010
Rev.004

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