

ASSEMBLE CRITICAL MEDICAL DEVICES WITH SEAL TRACEABILITY

PRODUCT DESCRIPTION

Incure Cyro-Weld™ 5005F is an advanced urethane acrylate designed for precision manufacturing. It delivers exceptional elongation, providing unparalleled stress-relief and continuous dynamic flexing for maximum impact absorption. The cured polymer exhibits outstanding resistance to severe environmental conditions, harsh chemicals, and stringent medical sterilization protocols. Furthermore, it functions perfectly as a thermal shock absorber for extreme mixed-substrate joints, heavily dampens destructive vibrations, and fluoresces brightly for automated UV inspection. Incure Cyro-Weld™ 5005F meets ISO 10993-5 biocompatibility standards while ensuring validated stability under EtO (ISO 11135) and Gamma (ISO 11137) sterilization, with Tg -dependent reliability for steam autoclave performance.

PRODUCT HIGHLIGHTS

- Rapid Cure Technology
- Exceptional Elongation
- High Shock Resistance
- Active UV Traceability
- Broad Mixed Adhesion

TYPICAL APPLICATIONS

- Optical Fiber Splicing
- Wearable Electronics
- Medical Disposables
- Mixed-Substrate Joints
- Vibration Dampening

UNCURED PROPERTIES

Chemical Type	Urethane Acrylate			
Liquid Appearance	Clear, Fluorescing			
Density, g/ml	1.05	Refractive Index	1.5	@20°C
Surface Energy (Liquid), dynes/cm	38 / 40	Toxicity	High	
¹ Viscosity, cP	3,400 to 6,800	Spindle	5 @20rpm	

¹ Viscosity (cP) taken at 25°C - Other viscosities are available upon request with a small lab fee.
Email support@uv-incure.com or your nearest local distributor for more information.

CURED PROPERTIES

Shore Hardness, Durometer	D51 to D61	ASTM 2240
Linear Shrinkage, %	2.50	ASTM D2566
Water Absorption at 24hrs, %	2.32	² ISTM D570
Tensile (PSI)	PC-PC 6,900 [^] SS-SS 3,400	ASTM 638
	S-S 3,500 AL-AL 3,200	
* PC-PC / SS-SS / S-S / AL-AL * PC Substrate Failure		
Surface After Full Cure	Clear, Fluorescing	² ISTM D189
Elongation at Break, %	80	ASTM 638
Temperature Resistance, °C	-55 to 150	² ISTM D366
Service Temperature, °C	-55 to 125	² ISTM D366
Young's Modulus of Elasticity, PSI	145,000	³ ASTM 638
Linear CTE ($\alpha 1$ & $\alpha 2$), ppm/°C	65 / 180	² ISTM D696
Glass Transition Temp (Tg), °C	60	² ISTM D696

² ISTM D696 - refers to Incure Standard Test Method

³ ASTM 538 Young's Modulus test speed @5mm/min for rigid and semi-rigid materials, @50mm/min for non-rigid materials, unless otherwise specified.

RECOMMENDED UV CURE SCHEDULE (FULL CURE)

Full Cure Exposure Time			UVA	UVB	UVC	UVV
F200P (Between Glass Slides)		mW/cm ²	223	56	4	215
Exposure Time (s)	2	mJ/cm ²	446	112	8	430
F200P @3.75" Dist	10	mW/cm ²	223	56	4	143
Belt Speed (ft/min)	5.5	mJ/cm ²	2,230	560	40	1,430
F500 @3.0" Dist	6	mW/cm ²	436	127	12	390
Belt Speed (ft/min)	6	mJ/cm ²	2,616	762	72	2,340
S20 w/4-Pole L/G @0.4" Dist		mW/cm ²	3,000	530	50	3,400
Exposure Time (s)	5	mJ/cm ²	15,000	2,650	250	17,000
L9000 LED Spot @0.67" Dist		mW/cm ²	2,800	42	12	102
Exposure Time (s)	8	mJ/cm ²	22,400	336	96	816

Cure times on 8mm ϕ adhesive sample. Belt speeds using C9000-F200Px1AB (Flood) and C9000-F500x1AC (Focused Beam) conveyors for area curing. Please consult IncureLab™ for any other requirements.

UV INTENSITY REFERENCE TABLE

Incure UV Curing Lamp Model	⁴ Curing Distance vs UV Intensity					
Spot Curing (Diameter)	0.5" (12.6)	1" (25.4)	1.5" (38)	2" (50.8)	2.5" (63.5)	3" (76.2)
S20 ARC (mW/cm ²) / (ϕ mm)	1,400 (3)	1,500 (4)	650 (6)	360 (8)	240 (10)	175 (12)
L9000 (mW/cm ²) / (ϕ mm)	7,500 (9)	5,000 (10)	2,300 (17)	1,200 (20)	700 (25)	450 (30)
Flood/Focus Beam (Area)	UV Intensity (mW/cm ²)					
F200P ARC Flood (6" x 8")	325	280	245	215	190	165
F400 ARC Flood (4" x 4")	860	570	440	345	270	215
F500 ARC Focused (3" x 5")	1,040	685	530	415	325	260
L1044-365 LED Flood (4" x 4")	2,675	2,380	1,900	1,625	1,430	1,280
L1044-405 LED Flood (4" x 4")	2,950	2,625	2,150	1,900	1,650	1,450

⁴ Curing Distance is defined by the tip of light-guide or base of lamp housing to the bond area. All values are nominal with $\pm 10\%$ variation, with LED Flood Static Uniformity at $\pm 78\%$ and Dynamic Uniformity at $\pm 90\%$. Recommended curing parameters in grey

SHELF-LIFE, STORAGE, USE AND HANDLING OF THIS PRODUCT

Shelf-Life of this unopened product is a minimum of 12 from date of manufacture. Avoid direct exposure of bottle to visible light at all times. Containers should remain covered when not in use. Product should be stored in a dark cool place of 10°C to 32°C. Transfer of product into other packages void all warranties. Users should ensure all bonding surfaces are free of grease, mould release, or any contaminants, as bonding performance will be compromised. All tests for cured bonds should be carried out at ambient temperature. Organic solvents, such as IPA, may be used to wipe away uncured material from surfaces. For safe handling of this product, please read Material Safety Data-sheet (MSDS) prior to use.

EtO and GAMMA STERILIZATION (Not Applicable for this Product)

Incure medical products are formulated to withstand standard sterilization methods, such as EtO and Gamma Radiation of 25 to 50 kGrays (cumulative). Enhanced moisture and thermal resistance ensure excellent adhesion strength after one steam autoclave cycle. Depending on bond design and application structure, users should test specific assemblies after sterilization. Consult Incure Support if devices are subjected to multiple sterilization cycles.

NOTE

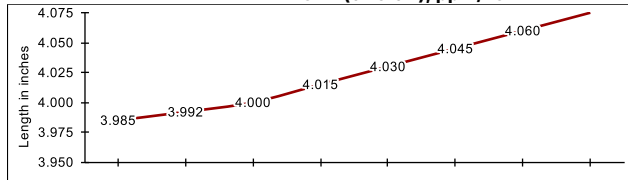
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SECONDARY HEAT CURE SCHEDULE

Continuous Oven Bake

Not Applicable

LINEAR CTE ($\alpha 1$ & $\alpha 2$), ppm/°C



*TENSILE STRENGTH VS TEMPERATURE

*Not Applicable for Uni-Prime™ 338 and Acti™ 398

