

OPTICAL GRADE ULTRAVIOLET ADHESIVE FOR PRECISION LENSES

PRODUCT DESCRIPTION

Incure Optik™ 7208 is a premium performance ultraviolet curing structural adhesive engineered for precision optical assembly applications. This highly cross-linked urethane acrylate matrix is fortified with microspheres, delivering remarkable tensile strength and rugged toughness at a reduced density. The precisely tuned thixotropic paste profile allows for excellent gap filling in wide tolerances without unwanted slumping during rapid production cycles. It vigorously resists prolonged exposure to aggressive industrial solvents, extreme environmental humidity, and rigorous operational stresses over time. Specialized rheology ensures void-free encapsulation while offering superior insulation. Incure Optik™ 7208 meets the requirements of NASA Low-Outgassing (ASTM E595) standards while complying with RoHS and REACH.

PRODUCT HIGHLIGHTS

- Ultra-fast curing speed
- Superior tensile strength
- High thixotropic paste
- High chemical resistance
- Excellent gap filling

TYPICAL APPLICATIONS

UNCURED PROPERTIES

Chemical Type	Urethane Acrylate			
Liquid Appearance	Clear			
Density, g/ml	0.75	Refractive Index	1.49	@20°C
Surface Energy (Liquid), dynes/cm	38 / 40	Toxicity	Medium	
¹ Viscosity, cP	42,000 to 84,000	Spindle	7 @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			D85 to D95		ASTM 2240
Linear Shrinkage, %			1.50		ASTM D2566
Water Absorption at 24hrs, %			0.5		² ISTM D570
Tensile (PSI)	PC-PC	450 [*]	SS-SS	2,500	ASTM 638
	S-S	2,200	AL-AL	2,000	
* PC-PC / SS-SS / S-S / AL-AL * PC Substrate Failure					
Surface After Full Cure		Clear			² ISTM D189
Elongation at Break, %			7		ASTM 638
Temperature Resistance, °C			-55 to 150		² ISTM D366
Service Temperature, °C			-55 to 80		² ISTM D366
Young's Modulus of Elasticity, PSI			449,500		³ ASTM 638
Linear CTE (α1 & α2), ppm/°C			65 / 185		² ISTM D696
Glass Transition Temp (Tg), °C			110		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)	5	mJ/cm ²	1,115	280	20	1,075
F200P @3.75" Dist	20	mW/cm ²	223	56	4	143
Belt Speed (ft/min)	4	mJ/cm ²	4,460	1,120	80	2,860
F500 @3.0" Dist	15	mW/cm ²	436	127	12	390
Belt Speed (ft/min)	2.5	mJ/cm ²	6,540	1,905	180	5,850
S20 w/4-Pole L/G @0.4" Dist		mW/cm ²	3,000	530	50	3,400
Exposure Time (s)	10	mJ/cm ²	30,000	5,300	500	34,000
L9000 LED Spot @0.67" Dist		mW/cm ²	2,800	42	12	102
Exposure Time (s)	15	mJ/cm ²	42,000	630	180	1,530

Cure times on 8mm ϕ adhesive sample. Belt speeds using C9000-F200P1AB (Flood) and C9000-F5001AC (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

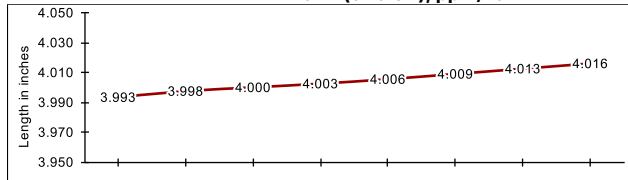
The data contained in this document are furnished for information only. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any production methods mentioned herein. Incure will not be liable for any indirect, special, incidental or consequential loss or damage arising from this Incure product, regardless of the legal theory asserted. Incure recommends that each user adequately test its proposed use and application before repetitive use, using this data as a guide.

SECONDARY HEAT CURE SCHEDULE

Continuous Oven Bake

Not Applicable

LINEAR CTE (α_1 & α_2), ppm/°C



*TENSILE STRENGTH VS TEMPERATURE

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

