

ULTRA-CLEAR OPTICAL ADHESIVE FOR PRECISION PHOTONIC ALIGNMENT

PRODUCT DESCRIPTION

Incure Optik™ 7254 is an ultra-clear photonic adhesive engineered for exceptional precision in advanced lens and optoelectronic sensor assembly. It features extraordinary tensile strength and high-modulus rigidity, guaranteeing robust optical alignment under intense mechanical shock. Formulated with highly optimized flow control, it prevents migration while maintaining excellent surface wetting on automated high-speed lines. The durable cross-linked matrix provides formidable resistance against corrosive solvents, harsh thermal cycling, and extreme environmental degradation. Furthermore, it excels in precise gap-filling capabilities, actively securing delicate internal components to permanently block moisture ingress. Ultimately, Incure Optik™ 7254 meets the requirements of NASA Low-Outgassing (ASTM E595) standards while complying with RoHS and REACH.

PRODUCT HIGHLIGHTS

- Rapid UV light cure
- Tack-free finish
- High-modulus rigidity
- Deep moisture barrier
- High impact absorption

TYPICAL APPLICATIONS

- Structural assembly
- Multi-substrate bond
- Precision encapsulation
- Industrial potting
- Component sealing

UNCURED PROPERTIES

Chemical Type	Urethane Acrylate			
Liquid Appearance	Clear			
Density, g/ml	1.05	Refractive Index	1.48	@20°C
Surface Energy (Liquid), dynes/cm	38 / 40	Toxicity	Medium	
¹ Viscosity, cP	1,200 to 2,400	Spindle	3 @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	D78 to D88	ASTM 2240
Linear Shrinkage, %	2.50	ASTM D2566
Water Absorption at 24hrs, %	2.4	² ISTM D570
Tensile (PSI)	PC-PC 400, SS-SS 5,900, S-S 7,800	ASTM 638
* PC-PC / SS-SS / S-S / AL-AL * PC Substrate Failure		
Surface After Full Cure	Clear	² ISTM D189
Elongation at Break, %	20	ASTM 638
Temperature Resistance, °C	-55 to 125	² ISTM D366
Service Temperature, °C	-55 to 125	² ISTM D366
Young's Modulus of Elasticity, PSI	304,500	³ ASTM 638
Linear CTE (α_1 & α_2), ppm/°C	60 / 180	² ISTM D696
Glass Transition Temp (T _g), °C	85	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
F200P @3.75" Dist	6	mW/cm ²	223	56	4
Belt Speed (ft/min)	9	mJ/cm ²	1,338	336	24
F500 @3.0" Dist	4	mW/cm ²	436	127	12
Belt Speed (ft/min)	9	mJ/cm ²	1,744	508	48
S20 w/4-Pole L/G @0.4" Dist	mW/cm ²	3,000	530	50	3,400
Exposure Time (s)	3	mJ/cm ²	9,000	1,590	150
L9000 LED Spot @0.67" Dist	mW/cm ²	2,800	42	12	102
Exposure Time (s)	4	mJ/cm ²	11,200	168	48

Cure times on 8mm ø 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) / (ø mm)	1,400 (3)	1,500 (4)	650 (6)	360 (8)	240 (10)	175 (12)
L9000 (mW/cm ²) / (ø 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 ±10% variation, with LED Flood Static Uniformity at ±78% and Dynamic Uniformity at ±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 months from date of manufacture. Avoid direct exposure of bottle to visible light at all times. Containers should remain covered when not in use. For optimal performance, product should be stored at between -30°C to -5°C. Thaw to 15°C to 35°C at least an hour before use. Transfer of product into other packages void all warranties. Users should ensure all bonding surfaces are free of grease, mold 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

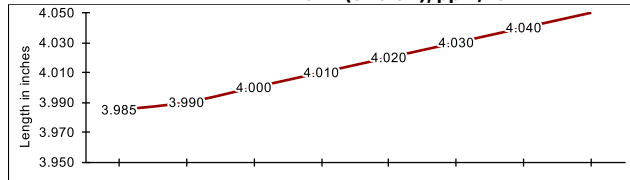
The data contained in this document are furnished for information only. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any production methods mentioned herein. 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

110°C for 30mins
125°C for 15mins

LINEAR CTE (α_1 & α_2), ppm/°C



*TENSILE STRENGTH VS TEMPERATURE

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

