LED Curable Materials Library
March 26, 2006

Materials Producers (Alphabetically)

Ciba Specialty Chemicals
Epoxy Technology
Henkel Loctite Corporation
Micro-Lite Technology
Norland Products
North Sea Resins
Novagard Solutions

Use of Library

This library provides information to help end users select the LED compatible light cured materials. The materials including adhesives, coatings, sealants and other UV curable materials for the assembly of medical equipment, electronics, biotech devices, displays, disc drives, treatment of wood, carbon fiber composites, graphics, labels, etc.

The electronic version of this table includes links to the materials producer's website and detailed technical data sheets. The contact person for the materials producer can provide further information on the use their material for a specific application. Clearstone manufactures UV and visible light sources and is not a sales representative or distributor of these materials. However, Clearstone is glad to provide technical support for LED UV-Visible light curing equipment and can assist with basic materials testing and application development.

Request the most current electronic version of the LED Curable Materials Library at: info@clearstonetech.com.

Acknowledgement

Clearstone Technologies Inc. would like to thank all the materials companies for their cooperation in producing the LED Curable Materials Library. Clearstone welcomes additional companies to contribute to this collection.

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Ciba Specialty Chemicals
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Formula (Link)	Type	Compatible LED Wavelength (nm)				Secondary Cure	Cure Quality	Features	Applications	Materials Bonded	Exposure Radiation
		365	390-410	455	470						
Irgacure 2100	MAPO/ MAPO blend, liquid		yes					acrylate resins, acrylate monomers, unsaturated polyesters.clear, viscous, yellow	clear, pigmented coatings, inks, composites, adhesives	wood, metal, plastics, paper, optical fibers,	
Irgacure 754	phenyl glyoxylate, multifunctional, liquid	yes						urethane acrylate, polyester diacrylate, epoxy diacrylate	waterborne coatings, clear coats	wood parquet, furniture, vinyl floors, plastic coatings	
Irgacure 819	BAPO, powder	yes	yes					clear acrylate, UPES/Styrene coatings yellow powder	white pigment formulations, thick section curing	glass fiber reinforced polyester/styrene, outdoor use, wood, metal, plastic, paper, optical fibers, printing inks, prepregs	
Irgacure 369	AAK, powder	yes	yes					acrylates slightly yellow powder	photo resists, inks, varnishes,	graphic arts, offset, screen inks, printing plates, solder masks	
Irgacure 784	Titanocene, powder			yes				acrylates yellow to orange powder		photopolymers, resists, printing plates, holograms, laser direct imaging, stereolithography	best in absence of oxygen, 488nm & 532nm OK.
Irgacure 651	aromatic ketone	yes						acrylates, unsaturated polyester/styrene	fillers, top coats, inks, clear coatings	wood, paper, metal, plastic	
Irgacure 379	AAK	yes									
Irgacure 1300	blend of IRGACURE369 + IRGACURE651	yes									
Darocur MBF	phenyl glyoxylate, multifunctional, liquid	yes						acrylates, light yellow liquid	Floor coatings, furniture coatings, plastic and metal coatings		
Darocur TPO	MAPO/ MAPO blend, powder		yes					acrylates, yellow powder	printing inks, adhesives, coatings	wood, metal plastic, paper, optical fiber	

BAPO = bisacylphosphine oxide

MAPO = mono acylphosphine oxide

AAK = alpha amino ketone

Epotek (1/3)

14 Fortune Drive, Billerica, MA 01821-3972, USA, Tel: +1-(978) 667-3805, Fax: +1-(978) 663-9782 Web: http://www.epotek.com
Contact Person: Hope Jones email: hjones@epotek.com

Formula (Link)	Type	Compatible LED Wavelength (nm)				Secondary Cure	Cure Quality	Features	Applications	Materials Bonded	Exposure Radiation
		365	390-410	455	470						
OG112	epoxy	yes				no	tack free		Optical, bonding, potting, coating, encapsulation		
OG112-4	epoxy	yes				no	tack free	Colorless Optical	Optical, OLEDs		100 mW/cm2, 60-120 sec. @ 365 nm
OG113	epoxy	yes				no	tack free	Colorless Optical	Optical, bonding, potting, coating, encapsulation		100 mW/cm2, 60-120 sec. @ 365 nm
OG114-4	epoxy	yes				no	tack free	No Yellow Optical	Optical bonding		100 mW/cm2, 60-120 sec. @ 365 nm
OG115	epoxy	yes				no	tack free	Colorless Optical	Optical bonding		100 mW/cm2, 60-120 sec. @ 365 nm
OG115-3	epoxy	yes				no	tack free	High Tg medium viscosity	LCD Sealing		100 mW/cm2, 60-120 sec. @ 365 nm
OG116	epoxy	yes				no	tack free	Colorless Optical	General Bonding		100 mW/cm2, 60-120 sec. @ 365 nm
OG116-31	epoxy	yes				no	tack free	Colorless Improved dispensing	Bonding, sealing, encapsulation		100 mW/cm2, 60-120 sec. @ 365 nm
OG124	epoxy	yes				no	tack free	Opaque white	adhesive bonding		100 mW/cm2, 60-120 sec. @ 365 nm
OG125	epoxy	yes				no	tack free	Transparent Low index refraction	optically transparent adhesive		100 mW/cm2, 60-120 sec. @ 365 nm
OG127-4	epoxy	yes				no	tack free	Transparent High index refraction	optically transparent adhesive		100 mW/cm2, 60-120 sec. @ 365 nm

Epotek (2/3)

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Formula (Link)	Type	Compatible LED Wavelength (nm)				Secondary Cure	Cure Quality	Features	Applications	Materials Bonded	Exposure Radiation
		365	390-410	455	470						
OG133	epoxy	yes				no	tack free	Clear oil, solvent resistant			100 mW/cm2, 60-120 sec. @ 365 nm
OG133-5	epoxy	yes				no	tack free	slight yellow slightly thixotropic	glop-top encapsulation, stress relief		100 mW/cm2, 60-120 sec. @ 365 nm
OG134	epoxy	yes				no	tack free	Flexible low index refraction			100 mW/cm2, 60-120 sec. @ 365 nm
OG142	epoxy	yes				no	tack free	Colorless optically transparent			100 mW/cm2, 60-120 sec. @ 365 nm
OG142-13	epoxy	yes				no	tack free	Colorless optically transparent	Belcore 1221, 85/85 Fiber Optic Reliability	glass, most plastics and most metals	100 mW/cm2, 60-120 sec. @ 365 nm
OG142-17	epoxy	yes				no	tack free	Colorless optically transparent	Belcore 1221, 85/85 Fiber Optic Reliability	improved adhesion and wetting	100 mW/cm2, 60-120 sec. @ 365 nm
OG142-6	epoxy	yes				no	tack free	White thixotropic	general adhesive bonding, sealing, potting		100 mW/cm2, 60-120 sec. @ 365 nm
OG145	epoxy	yes				no	tack free	Clear high viscosity	Optical type for screen printing		100 mW/cm2, 60-120 sec. @ 365 nm
OG146	epoxy	yes				no	tack free	Clear low viscosity	low index		100 mW/cm2, 60-120 sec. @ 365 nm
OG146-6	epoxy	yes				no	tack free	Clear low viscosity	low index		100 mW/cm2, 60-120 sec. @ 365 nm
OG147	epoxy	yes				80C/30 min	tack free	Opaque black	opaque		100 mW/cm2, 60-120 sec. @ 365 nm
OG147-7	epoxy	yes				no	tack free	High Tg high viscosity	encapsulation, potting, glob-top		100 mW/cm2, 60-120 sec. @ 365 nm

Epotek (3/3)

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Formula (Link)	Type	Compatible LED Wavelength (nm)				Secondary Cure	Cure Quality	Features	Applications	Materials Bonded	Exposure Radiation
		365	390-410	455	470						
OG152	epoxy	yes				no	tack free	High Tg	Excellent adhesion to common substrates		100 mW/cm2, 60-120 sec. @ 365 nm
OG154	epoxy	yes	??			no	tack free	Light Yellow High Tg	Excellent adhesion to common substrates	glass, most plastics and most metals	100 mW/cm2, 60-120 sec. @ 365 nm or 395 nm (?)
OG157	epoxy	yes				no	tack free	High Tg high viscosity slight yellow	Fiber optic and optical adhesive		100 mW/cm2, 60-120 sec. @ 365 nm
OG159-2	epoxy	yes				no	tack free	Thisotropic Paste 1 mil glass beads	screen printing, bondline control		100 mW/cm2, 60-120 sec. @ 365 nm
OG169	epoxy	yes				no	tack free	Colorless low shrinkage	Medical Certified to USP Class VI Biocompatibility standards		100 mW/cm2, 60-120 sec. @ 365 nm
OG172	epoxy	yes				no	tack free	Low Nd medium viscosity	Optical epoxy		100 mW/cm2, 60-120 sec. @ 365 nm
OG175	epoxy	yes					tack free	Amber Low index refraction	Fiber optic and optical adhesive		100 mW/cm2, 60-120 sec. @ 365 nm
OG178	epoxy	yes				no	tack free	Clear (amber?) visible light cure		glass, most plastics and most metals	100 mW/cm2, 60-120 sec. @ 365 nm
OG198	epoxy	yes				150C/1 hr	tack free	Amber High Tg	fiber optic packaging & assembly		100 mW/cm2, 60-120 sec. @ 365 nm
OG198-50	epoxy	yes				150C/30 min	tack free	Amber High Tg	Fiber optic and optical adhesive		100 mW/cm2, 60-120 sec. @ 365 nm
OG198-52	epoxy	yes				150C/30 min	tack free	Amber thixotropic high Tg	Fiber optic and optical adhesive		100 mW/cm2, 60-120 sec. @ 365 nm

Henkel-Loctite

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Formula (Link)	Type	Compatible LED Wavelength (nm)				Secondary Cure	Cure Quality	Features	Applications	Materials Bonded	Exposure Radiation
		365	390-410	455	470						
3105	acrylic	yes	yes			no	tack free		bonding	flexible/ridgid PVC to Polycarbonate, metal, glass, plastics	
3106	acrylic	yes	yes			no	tack free	Sterilization Resistant	bonding	ridgid/flexible PVC to Polycarbonate, metal, glass, plastics	
3107	acrylic	yes	yes			no	tack free	Fluorescence Sterilization Resistant	bonding	heavily plasticized PVC, polycarbonate, ABS	
3311	acrylic	yes	yes			no	tack free	Sterilization Resistant	Disp. Med. Dev.	PVC, Polycarbonate	
3321	acrylic	yes	yes			no	tack free	Sterilization Resistant	thixotropic	flexible/ridgid PVC, Polycarbonate, glass metal	
3341	acrylic	yes	yes			no	tack free	Fluorescence Sterilization Resistant	Disp. Med. Dev.	plasticized PVC, polycarbonate, ABS, thermalplastics	
3525	acrylic	yes	yes			no	tack free	Fluorescence	industrial, motor balancing	glass, metal plastic	
3922	acrylic	yes	yes			no	tack free	Fluorescence Sterilization Resistant	Disp. Med. Dev., Syringe	glass, plastic, metal, SS	
3924	acrylic	yes	yes			no	tack free	Fluorescence Sterilization Resistant	Disp. Med. Dev.	glass, plastic, metal	
3926	acrylic	yes	yes			no	tack free	Fluorescence Sterilization Resistant	Disp. Med. Dev., Syringe	SS, glass, plastic, metal	
3944	acrylic	yes	yes			no	tack free	Fluorescence	Disp. Med. Dev.	flexible, glass, plastic	
3971	acrylic	yes	yes			no	tack free	Fluorescence Sterilization Resistant	Disp. Med. Dev., Syringe	SS, Plasticized	
3972	acrylic	yes	yes			no	tack free	Fluorescence Sterilization Resistant	Disp. Med. Dev., Syringe	SS, Plasticized	
4304	cyanoacrylate	yes	yes			humidity	tack free	Sterilization Resistant	Disp. Med. Dev.	plastics, rubber, metal	
4305	cyanoacrylate	yes	yes			humidity	tack free	Sterilization Resistant	Disp. Med. Dev.	plastics, rubbers, metals	
4306	cyanoacrylate	yes	yes			humidity	tack free	Sterilization Resistant	Disp. Med. Dev.	plastics, rubber, metal	
4307	cyanoacrylate	yes	yes			humidity	tack free	Fluorescence	Disp. Med. Dev., Syringe	plastics, rubber, metal, ABS, aluminum, neoprene	

Micro-Lite Technology (1/3)

6009 East Sanford Circle, Mesa Arizona, 85215, USA, Tel: +1-(480) 807-5200, Fax: +1-(480)-807-5225 Web: http://www.mlt-uv.com
Contact Person: Cynthia Giaccetti email: cynthiag@mlt-uv.com

Formula (Link)	Type	Compatible LED Wavelength (nm)				Secondary Cure	Cure Quality	Features	Applications	Materials Bonded	Exposure Radiation
		365	390-410	455	470						
A-1115-M	adhesive/ medical grade	yes					tack free/ 3 min	flexible, sporox, steris, peracetic acid tested medical grade, USP Class VI	repair coating for endoscopes, clear high gloss	silicons, polyester, polycarbonate, polyurethane	70 mW/cm2 @ 365 nm
A-1009	adhesive	yes					tack free/ 5 min	excellent adhesion low chloride ion	screen printing, roll coating	PCB's, ceramics, gold, silver other metals,	70 mW/cm2 @ 365 nm
A-1000	adhesive	yes				15 min @ 115C	tack free/ 2min	excellent adhesion low chloride ion	screen printing, roll coating	PCB, ceramics, silicon dioxide, many metals	70 mW/cm2 @ 365 nm
A-1175	adhesive/ medical grade	yes					tack free/ 5 min	flexible, sporox, steris, peracetic acid tested medical grade, USP Class VI	repair of endoscopes, low gloss	polyester, polycarbonate, polyurethane, many other plastics	70 mW/cm2 @ 365 nm
A-1011	adhesive	yes					tack free/ 5 min	optical quality glass primer	endoscopes, fiber cable, optical fibers, lenses	glass to glass, metals, ceramics, IC's many plastics	70 mW/cm2 @ 365 nm
A-1004	adhesive	yes				15 min @ 110C	tack free/ 5 min	excellent adhesion low chloride ion	Die attach,	PCBs, ceramixs, IC s and many plastics	70 mW/cm2 @ 365 nm
A-1012	adhesive	yes					tack free/ 1 min	thixotropic low chloride ion	wire bond & screw attachment	PCBs, ceramixs, IC s and many plastics	70 mW/cm2 @ 365 nm
A-1005	adhesive	yes					tack free/ 5 min	withstands 125C	endoscopes, fiber cable, optical fibers, lenses	glass to glass, metals, ceramics, IC's many plastics	70 mW/cm2 @ 365 nm
A-3010	adhesive	yes				15 min @ 125C	tack free/ 5 min	flourescent tracer, clear, humidity temp resistant, low viscosity flame retardant, MIL-I-46058, low chloride	Conformal coating for PCB	PCBs, hybrids	70 mW/cm2 @ 365 nm

Micro-Lite Technology (2/3)

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Formula (Link)	Type	Compatible LED Wavelength (nm)				Secondary Cure	Cure Quality	Features	Applications	Materials Bonded	Exposure Radiation
		365	390-410	455	470						
A-1007	adhesive	yes					tack free/ 1 min	density 1.02-1.65 gm/cc.	wheel balancing, bar code readers, high spped motors		70 mW/cm2 @ 365 nm
2012	encapsulant	yes					tack free/ 5 min	excellent physical, thermal electrical insulation low shrinkage, high tensile & compression strength, -45 to 175C >2000 hr life		capacitors, resistors, recitifiers	70 mW/cm2 @ 365 nm
2081	encapsulant	yes					tack free/ 5 min	low dielect, relieves stress of toroids low chloride ion, op temp -55 to 125C	low viscosity, coating Toroidal coils, dielectric constant =2.8 good RF		70 mW/cm2 @ 365 nm
3751	coating	yes					tack free/ 5 min	low viscosity, spin coat	optical discs, CD ROM, DVD, CD R		70 mW/cm2 @ 365 nm
3011	coating	yes				25 min @ 110C	tack free/ 5 min	low viscosity, translucent, low chloride ion content fluorescent tracer, -55 to 125C, withstands high humidity	conformal coating for PCBs, hybrid electronics, micro circuits		70 mW/cm2 @ 365 nm
3010-M	coating	yes				25 min @ 110C	tack free/ 5 min	MIL-I-45058 low viscosity, translucent, low chloride ion content fluorescent tracer, -55 to 125C, withstands high humidity	conformal coating for PCBs, hybrid electronics, micro circuits		70 mW/cm2 @ 365 nm
3040	coating	yes				25 min @ 110C	tack free/ 5 min	UL approval pending, low viscosity, low chloride ion content fluorescent tracer, flame retardant, -55 to 125C, withstands high humidity	conformal coating for PCBs, hybrids, Ics		70 mW/cm2 @ 365 nm

Micro-Lite Technology (3/3)

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Formula (Link)	Type	Compatible LED Wavelength (nm)				Secondary Cure	Cure Quality	Features	Applications	Materials Bonded	Exposure Radiation
		365	390-410	455	470						
I-2000	Ink	yes					tack free/ 5 min	wide spectrum of colors, resists solvents, acids, bases, Mil Spec 893 &775	inks for heat sensitive substrates, screen or pad printing	metals, glass, thermoplastic, thermo set	70 mW/cm2 @ 365 nm
SR-1000	solder mask	yes					tack free/ 2min	high tensile and compression strength, excellent physical, thermal and electrical insulation properties Temp -65 to 150C, withstands high humidity	acreen print over conductive traces, landing pads, resistors, caps, etc		70 mW/cm2 @ 365 nm
SR-2000	Peelable mask	yes					tack free/ 1 min	flexible, peelable Op. temp. -65 to 135C, physical, thermal, electrical insulation	protects substrate or electrical connections until removed for later repair of electrical connection	PCBs, ceramics, metals, glass, endoscopes	70 mW/cm2 @ 365 nm
SR-2010	Peelable Barrier Coating	yes					tack free/ 5 min	flexible, peelable Op. temp. -65 to 135C, physical, thermal, electrical insulation, >2000 hr life		PCBs, ceramics, metals, glass, endoscopes	70 mW/cm2 @ 365 nm

Norland Products

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Formula (Link)	Type	Compatible LED Wavelength (nm)				Secondary Cure	Cure Quality	Features	Applications	Materials Bonded	Exposure Radiation
		365	390-410	455	470						
NOA-61	photopolymer	yes					tack free	not O2 inhibited, increased adhesion with 1 week 25C or 12 hr 50C good adhesion, solvent resistance	Fed. Spec. MIL-A-3920, bonding lenses, splicing optical fibers	glass, metal, fiberglass, glass filled plastic	3000mj/cm2
NOA-65	photopolymer	yes					tack free	minimum O2 inhibition very flexible, minimizes strain	elastic nature helps bound materials with disimilar coefficients of expansion.	potting of lenses in metal mount, plastic to glass, cold blocking	4500mj/cm2
NOA-71	adhesive	yes					tack free	adhesion promoter, increased adhesion with 1 week 25C or 12 hr 50C moisture resistance	laminating solar cells, holographic plastes, flat panel displays, clear coats	glass, glass-filled, ceramic bonding	3500mj/cm2
NOA-72	adhesive	yes?	405				tack free	increased adhesion with 1 week 25C or 12 hr 50C good adhesion, solvent resistance	bonding compound lenses, laminating polarized film, bonding leaded glass	acrylic, polycarbonate, cellulose acetate butyrate, glass	5000mj/cm2
NOA-76	adhesive	yes?	405				tack free	increased adhesion with 1 week 25C or 12 hr 50C good adhesion, solvent resistance	glass to plastic bonding or laminating polarized film between glass	acrylic, polycarbonate, cellulose acetate butyrate, glass	5000mj/cm2
NOA-78	photopolymer	yes?	405				tack free	colorless low shrinkage, slight flexibility	plastic to plastic, plastic to glass	CF-39, polarized film, delrin, nylon, cellulose Acetate butyrate, polycarbonate, acrylics	3500-7000 mj/cm2

North Sea Resins

115 Research Drive, Bethlehem, PA 18015, USA, Tel: +1-(610) 419-4888 Fax: (610) 419-4889, web: http://www.northsearesins.com
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Formula (Link)	Type	Compatible LED Wavelength (nm)				Secondary Cure	Cure Quality	Features	Applications	Materials Bonded	Exposure Radiation
		365	390-410	455	470						
NSR150	acrylate	no	no	yes	yes		slight tack in O2 environment[1]	cures with 470nm, cures under water, can be machined yellowish, UL approved for potable water,	fill cracks or holes, encapsulating, coating, sealing, pipe repair	FRP, Gelcoat, PVC, Polyetheylene, wood, concrete, fiberglass mesh	2.5 mW/cm2 @ 470 nm 30 sec
NSR110	acrylate	no	no	yes	yes		slight tack in O2 environment[1]	cures with 470nm, cures under water, can be machined, yellowish	fill cracks or holes, encapsulating, coating, sealing, pipe repair	FRP, Gelcoat, PVC, Polyetheylene, wood, concrete, fiberglass mesh	2.5 mW/cm2 @ 470 nm 30 sec
NSR210	acrylate	no	no	yes	yes		slight tack in O2 environment[1]	cures with 470nm, cures under water, can be machined, yellowish	fill cracks or holes, encapsulating, coating, sealing, pipe repair	copper, brass, bronze, steel, aluminum, cast iron, fiber glass mesh	2.5 mW/cm2 @ 470 nm 30 sec
NSR250	acrylate	no	no	yes	yes		slight tack in O2 environment[1]	cures with 470nm, cures under water, can be machined yellowish, UL approved for potable water,	fill cracks or holes, encapsulating, coating, sealing, pipe repair	copper, brass, bronze, steel, aluminum, cast iron, fiber glass mesh	2.5 mW/cm2 @ 470 nm 30 sec
NSR390	acrylate	no	no	yes	yes		slight tack in O2 environment[1]	cures with 470nm, cures under water, can be machined, electrical insulator, solvent resistant, yellowish, paste, can be applied vertically	fill cracks or holes, conduit end-cap	metals, plastics, composites, concrete, wood	

[1] Applicator tabs are available for tack free surface

Novagard Solutions

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Formula (Link)	Type	Compatible LED Wavelength (nm)				Secondary Cure	Cure Quality	Features	Applications	Materials Bonded	Exposure Radiation
		365	390-410	455	470						
RTV 800-200	Silicone	yes	no	no	no	Moisture-12-24hr	tack free	5000 CPs.self leveling Hazy fluid Tensile strength=50 psi Shore hardness=30 Deep cure up to 3/8”	Potting, sealing, heavy coating	PCB, connectors, electronics	250 mW/cm2 <1 sec
RTV 800-205	Silicone	yes	no	no	no	Moisture-12-24hr	tack free	5000 CPs.self leveling Hazy fluid Tensile strength=50 psi Shore hardness=30 Deep cure up to 3/8”	Class VI compliant available	sealing	250 mW/cm2 <1 sec
RTV 800-250	Silicone	yes	no	no	no	Moisture-12-24hr	tack free	700 CPs.self leveling Clear fluid Tensile strength=35 psi Shore hardness=20 Deep cure up to 3/8”	Conformal coating	PCBs	250 mW/cm2 <1 sec
RTV 800-300	Silicone	yes	no	no	no	na	tack free	Deep curing, paste Tensile strength=160 psi Shore hardness=30 Deep cure up to 5/8”	Class VI compliant available	Gasketing materials, Cure in place gaskets Automotive, Medical, electronics, industrial	250 mW/cm2 <1 sec
RTV 800-305	Silicone	yes	no	no	no	Moisture-12-24hr	tack free	Deep curing, paste Tensile strength=100 psi Shore hardness=30 Deep cure up to 5/8”	Class VI compliant available	Gasketing materials, Cure in place gaskets Automotive, Medical, electronics, industrial	250 mW/cm2 <1 sec
RTV 800-306 Class 6	Silicone	yes	no	no	no	Moisture-12-24hr	tack free	Deep curing, paste Tensile strength=100 psi Shore hardness=30 Deep cure up to 5/8”	Class VI compliant available	Gasketing materials, Cure in place gaskets Automotive, Medical, electronics, industrial	250 mW/cm2 <1 sec