

### Features & Benefits

- 💧 Cure on demand
- 💧 Highly transparent
- 💧 Excellent adhesion to plastics
- 💧 High elongation
- 💧 Low shrinkage

### Description

**PERMABOND® UV639** is a UV-curing adhesive developed for use on plastics. It has superb adhesion to acrylic, polycarbonate and PETG. This adhesive can also be used to bond glass, metals and other materials. UV639 cures to give a colourless bond so is ideal for applications where aesthetic appearance is vitally important.

### Physical Properties of Uncured Adhesive

Chemical composition	Urethane methacrylate
Appearance	Colourless, clear
Viscosity @ 25°C	20rpm: 1,200-1,800 mPa.s (cP)

### Typical Curing Properties

Typical fixture time (PMMA)*	Low power 4mW/cm <sup>2</sup> battery lamp: 5secs LED 200mW/cm <sup>2</sup> lamp: <1s
Typical fixture time (Polycarbonate)*	Low power 4mW/cm <sup>2</sup> battery lamp: 10secs
Cure wavelength	365 - 420 nm**

\*The cure time depends on the power of the UV lamp, its spectral output, the distance between the lamp and the components, and the transmission characteristics of the substrates.

\*\*LED UV lamps have a narrow range of spectral output. It is important to check suitability with Permabond in order to match the LED lamp's peak wavelength with that of the adhesive's photoinitiator to ensure optimal adhesive cure.

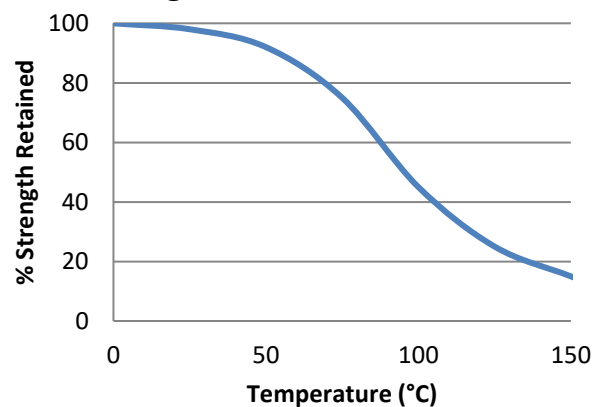
### Typical Performance of Cured Adhesive

Overlap shear strength (ISO4587)	Polycarbonate	>8 N/mm <sup>2</sup> (>1160 psi)*
	Acrylic	>6 N/mm <sup>2</sup> (>870 psi)*
	PET-G	>7 N/mm <sup>2</sup> (>1015 psi)*
	PET	>5 N/mm <sup>2</sup> (>725 psi)*
Block shear strength (ASTM D4501)	PMMA/Glass	>8 N/mm <sup>2</sup> (>1160 psi)*
	PMMA/PMMA	6 N/mm <sup>2</sup> (870 psi)**
Tensile strength (ISO37)	20 N/mm <sup>2</sup> (2900 psi)	
Elongation at break (ISO37)	>220%	
Hardness (ISO868)	35-45 Shore D	
Water absorption (ISO62) 2 hours in boiling water	14%	
Glass transition (Tg)	70°C (158°F)	

\*Substrate failure was observed

\*\*Cohesive failure

### Hot Strength



"Hot strength" shear strength tests performed on glass to mild steel. Fully cured specimens conditioned to pull temperature for 30 minutes before testing at temperature.

UV639 can withstand higher temperatures for brief periods (such as for paint baking and wave soldering processes) providing the joint is not unduly stressed. The minimum temperature the cured adhesive can be exposed to is -55°C (-67°F) depending on the materials being bonded.

The information given and the recommendations made herein are based on our research and are believed to be accurate but no guarantee of their accuracy is made. In every case we urge and recommend that purchasers before using any product in full-scale production make their own tests to determine to their own satisfaction whether the product is of acceptable quality and is suitable for their particular purpose under their own operating conditions. THE PRODUCTS DISCLOSED HEREIN ARE SOLD WITHOUT ANY WARRANTY AS TO MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE OR ANY OTHER WARRANTY, EXPRESS OR IMPLIED.

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## Additional Information

This product is not recommended for use in contact with strong oxidizing materials.

Information regarding the safe handling of this material may be obtained from the Safety Data Sheet.

Users are reminded that all materials, whether innocuous or not, should be handled in accordance with the principles of good industrial hygiene.

**This Technical Datasheet (TDS) offers guideline information and does not constitute a specification.**

## Surface Preparation

Surfaces should be clean, dry and grease-free before applying the adhesive. Particular care should be taken to remove silicone based cleaning agents which may have been used previously to clean glass.

Some metals such as aluminium, copper and its alloys, will benefit from light abrasion with emery cloth (or similar) to remove the oxide layer.

Isopropanol can be used to degrease most surfaces.

Where thermoplastic surfaces are involved we recommend tests are done to ensure compatibility, mold release agents may affect bond strength.

## Directions for Use

- 1) Adhesive can either be applied directly from the bottle or dispensed via automated dispensing equipment for more accurate dosing. Minimise exposure of product to ambient light.
- 2) It is important to try to prevent air entrapment within the joint as this could be detrimental to the finished appearance of the adhesive.
- 3) Parts should be firmly held and not disturbed during cure. Expose the joint to ultra-violet light for the appropriate time to ensure full cure. Cure time depends on the power of the UV lamp, its spectral output, the distance between the lamp and the components, and the transmission characteristics of the substrates.
- 4) For help selecting a suitable lamp and/or dispensing equipment, please contact the Permabond technical helpline.

## Video Link

UV adhesive directions for use:  
<https://youtu.be/Y9q0FGFhdvc>



## Other Products Available

### Anaerobics

- Thread lockers
- Thread sealants
- Gasket makers
- Sealants / retainers

### Cyanoacrylates

- Instant adhesives
- For rapid bonding of metals, plastics, rubber and many other materials

### Epoxies

- Two-part room temperature cure adhesives
  - Single-part heat cure adhesives
- Modified Technology (MT) flexible grades available

### MS-Polymers

- Single-part, moisture-curing, flexible sealants

### Polyurethanes

- Two-part room temperature curing adhesives

### Toughened Acrylics

- Rapid curing, high strength structural adhesives

### UV Light Cured Adhesives

- Glass / plastic bonding
  - Optically clear
  - Non-yellowing

## Storage & Handling

Storage Temperature	5 to 25°C (41 to 77°F)
Protect liquid adhesive from room lighting.	

[www.permabond.com](http://www.permabond.com)

• UK: 0800 975 9800

• General Enquiries: +44 (0)1962 711661

• US: 732-868-1372

• Asia: + 86 21 5773 4913

[info.europe@permabond.com](mailto:info.europe@permabond.com)

[info.americas@permabond.com](mailto:info.americas@permabond.com)

[info.asia@permabond.com](mailto:info.asia@permabond.com)

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