

## Photo-curing Adhesive for C-MOS Plastics Lens Holder Bonding

### Product Description

FR324-6 is photo-curing adhesive for C-MOS module. This product can fast cure under ultraviolet light(365nm). Cured resin has toughness and thermal shock resistance. This product is well suited for C-MOS plastic lens holder bonding. This resin has good adhesion strength.

### Features

1. This resin shows high quality and passes many kinds of environmental test experiment.
2. This product complies to the 2011/ 65/EU RoHS regulations.

### Typical Uncured Properties

Appearance	FR324-6
Color	Liquid
Viscosity* 25°C, S14 100rpm, cps	2,200~3,500
Viscosity* 25°C, S14 10rpm, cps	9,200~14,000
Thixotropic Index	3.8~4.2
Specific Gravity	1.017
Refractive Index $n_D@25.2^\circ\text{C}$	1.4789
Solvent Content, %	0

\*This value is for reference. Please refer to COA for the actual value.

### Typical Curing Properties

Recommended Wavelength, nm	310~365
Minimum Light Intensity, mW/cm <sup>2</sup>	> 50
Minimum Light Energy, mJ/cm <sup>2</sup>	2,000

\*The minimum light energy is for reference.

### Direction of Use

1. It should be applied to a clean surface which is free of dirt, grease or mold release. In many cases, a simple solvent wipe is sufficient.
2. For maximum bonding strength apply adhesive evenly to both surfaces to be jointed.
3. Cure time on the really part will depend upon factors such as part geometry, materials to be bonded, bondline thickness and efficiency of the UV light. Cure schedule should be confirmed with actual production parts and equipment.
4. This product may cause skin irritation to sensitive personnel.

### Typical Cured Properties

Durometer Hardness, Shore D	53
Durometer Hardness, Shore A	90
Refractive Index $n_D@25.4^\circ\text{C}$	1.4988

### Storage and Shelf Life

This product should be kept without any possibility of light exposure. Replace the lid immediately after use. This product has a one year minimum shelf life when stored in dark place below 14~34°C in original, unopened containers.

### Caution

Some findings indicate a lack of potential for carcinogenicity with the compositions of this product by long term recurrent application to the skin. However, contact with skin is likely to produce mild transient reddening. It is important to remove adhesive from skin with soap and water thoroughly. DO NOT use solvents for cleaning hands. This product is of moderate acute toxicity by swallowing. If swallowed, call a physician. Avoid contact with eyes. In case of contact, flush with water for at least 15 minutes and get medical attention immediately. For specific information on this product, consult the Material Safety Data Sheet.