

Ultra Light-Weld® 3069-T-RF Adhesive Polycarbonate • PVC • Polyester

3069-T-RF is a solvent free, 100% solids, adhesive. Lasting bonds form in seconds to both flexible and rigid substrates including PVC, polycarbonate, polyurethane, PET, and PETG. Bond strength on polycarbonate and PVC usually exceed the strength of those substrates. Its pink fluorescing color allows easy inspection. Dymax Ultra Light-Weld® structural adhesives can be cured with UV or visible light. Ultra Light-Weld® adhesives faster, deeper cures, increase productivity, lower assembly costs and enhance worker safety. When cured with Dymax light-curing spot lamps, focused-beam lamps, or flood lamps, they deliver optimum speed and performance for assembly. Dymax lamps offer the ideal balance of UV and visible light for the fastest, deepest cures. This product is in full compliance with RoHS directive 2015/863/EU.

TYPICAL UNCURED PROPERTIES

Solvent Content	None - 100% solids	
Composition	Urethane Oligomer/(Meth) Acrylate Monomer Blends	
Appearance	Pink Fluorescing	
Flash Point	>93°C (200°F)	
Solubility	Alcohols/Chlorinated Solvents/Ketones	
Toxicity	Low	
Density	1.05 g/mL	
Viscosity (20 rpm)	6,000 cP	ASTM D-1084

TYPICAL CURED PROPERTIES

PHYSICAL

Durometer Hardness	D55	ASTM D-2240
Tensile at Break	1,700 psi	ASTM D-638
Elongation at Break	175%	ASTM D-638
Water Absorption (24 h)	1.8%	ASTM D-570
Boiling Water Absorption (2 h)	1.3%	ASTM D-570

TYPICAL LIGHT CURE DATA

Lamp	2000-EC	5000-EC	PC-3	3010-EC
Light Type	UV	UV	UV	UV
Lamp Type	8"x8" Flood	5"x5" Flood	3/16" dia Spot	3/16" dia Spot
Intensity (mW/cm ²) at Peak	70	275	2500	6000
Wavelength	@ 365 nm	@ 365 nm	@ 365 nm	@ 365 nm
Wavelength (nm) Working Range	300-500	300-500	300-500	300-500
Cure Speed (sec)				
Between Glass	2	1	2	1
Tack Free Surface Cure	N/A	45	20	10



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DISPENSING AND HANDLING ADHESIVE

Dymax 3069-T-RF is available in various packages such as syringes, cartridges, bottles, and pails. It may be dispensed with a variety of automatic bench-top syringe applicators or other equipment as required. Direct questions relating to dispensing and curing systems for specific applications to Dymax Application Engineering.

Wear impervious gloves and/or barrier cream. Repeated or continuous skin contact with liquid adhesive will cause irritation and should be avoided. Do not wear absorbent gloves. Remove adhesive from skin with soap and water. Never use solvents to remove adhesive from skin or eyes.

STORAGE AND SHELF LIFE

Store material in a cool, dark place when not in use. Do not expose to UV light or sunlight. Material may polymerize upon prolonged exposure to ambient light. Replace lid immediately after use. This material has a 18 month shelf life from date of manufacture, unless otherwise specified, when stored between 10°C (50°F) and 35°C (90°F) in the original, unopened container.

CAUTION

For industrial use only. Avoid breathing vapors. Avoid contact with eyes and clothing. In case of contact, immediately flush with water for at least 15 minutes; get medical attention. Wash clothing before reuse. Keep out of reach of children. Do not take internally. If swallowed, induce vomiting at once and call a physician. Repeated or continuous skin contact with liquid adhesive will cause irritation and should be avoided. For specific information, refer to the Material Safety Data Sheet.

GENERAL INFORMATION

This product is intended for industrial use only. Keep out of the reach of children. Avoid breathing vapors. Avoid contact with skin, eyes, and clothing. Wear impervious gloves. Repeated or continuous skin contact with uncured material may cause irritation. Remove material from skin with soap and water. Never use organic solvents to remove material from skin and eyes. For more information on the safe handling of this material, please refer to the Safety Data Sheet before use.

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