



**Manufacturer:**  
Dymax®

**Product Name:**  
Dymax OP-4-20641 UV Optical Adhesive (3ml)

**Manufacturer Part Number:**  
OP-4-20641-3ML

▶ [Click here for more details on the Dymax OP-4-20641 UV Optical Adhesive \(3ml\)](#)



**OPTICAL ADHESIVES**  
**OP-4-20641 Product Data Sheet**

**Ultra Light-Weld® OP-4-20641**  
**Optical Adhesive for Fiber Optical Assembly**

| APPLICATIONS   | FEATURES & BENEFITS   | SUBSTRATES   |
|--|---|--|
| <ul style="list-style-type: none"> <li>Bonding and Laminating Fiber Optic Couplings, Gratings, Lens, and Prisms</li> </ul> | <ul style="list-style-type: none"> <li>Fast, Total Cure in Seconds with UV or Visible Light</li> <li>Thick, Flowing Viscosity to Fill Gaps</li> </ul> | <ul style="list-style-type: none"> <li>Plastics</li> </ul> |

Dymax Ultra Light-Weld® OP-4-20641 was designed for laminating large areas. OP-4-20641 is a clear, UV or visible light-curable adhesive with high transmission across the optical spectrum. It is very soft, low modulus and is designed for thermal cycling of fragile optical components. Dymax Ultra Light-Weld® materials contain no nonreactive solvents and cure upon exposure to light. Their ability to cure in seconds enables faster processing, greater output, and lower processing costs. When cured with Dymax light-curing spot lamps, focused-beam lamps, or flood lamps, they deliver optimum speed and performance. Dymax lamps offer the optimum balance of UV and visible light for the fastest, deepest cures. This product is in full compliance with RoHS directives 2015/863/EU.

| UNCURED PROPERTIES *   |                           |             |
|------------------------|---------------------------|-------------|
| Property               | Value                     | Test Method |
| Solvent Content        | No Nonreactive Solvents   | N/A         |
| Chemical Class         | Acrylated Urethane        | N/A         |
| Appearance             | Colorless Transparent Gel | N/A         |
| Soluble in             | Organic Solvents          | N/A         |
| Density, g/ml          | 1.06                      | ASTM D1875  |
| Viscosity, cP (20 rpm) | 23,000 (nominal)          | ASTM D2556  |

| ADHESION                       |                |
|--------------------------------|----------------|
| Substrate                      | Recommendation |
| PC polycarbonate               | ✓              |
| PEI polyetherimide             | ✓              |
| PVC poly(vinyl chloride)       | ✓              |
| TPU thermoplastic polyurethane | ✓              |

✓ Recommended      ○ Limited Applications  
st Requires Surface Treatment (e.g. plasma, corona treatment, etc.)

| CURED MECHANICAL PROPERTIES *        |              |             |
|--------------------------------------|--------------|-------------|
| Property                             | Value        | Test Method |
| Durometer Hardness                   | D55          | ASTM D2240  |
| Tensile at Break, MPa [psi]          | 13.7 [2,000] | ASTM D638   |
| Elongation at Break, %               | 90           | ASTM D638   |
| Modulus of Elasticity, Mpa [psi]     | 55.8 [8,100] | ASTM D638   |
| Glass Transition T <sub>g</sub> , °C | 73           | DSTM 256†   |

| OTHER CURED PROPERTIES *          |       |             |
|-----------------------------------|-------|-------------|
| Property                          | Value | Test Method |
| Refractive Index (20°C)           | 1.50  | ASTM D542   |
| Boiling Water Absorption, % (2 h) | 5.3   | ASTM D570   |
| Water Absorption, % (25°C, 24 h)  | 2.6   | ASTM D570   |
| Linear Shrinkage, %               | 0.9   | ASTM D2566  |

\* Not Specifications  
N/A Not Applicable  
† DSTM Refers to Dymax Standard Test Method



**Contact the professionals at Fiber Optic Center for a quote or to get more details.**

[focenter.com](http://focenter.com) • 508-992-6464 | (800) 473-4237 • [sales@focenter.com](mailto:sales@focenter.com)

23 Centre Street • New Bedford, MA 02740 USA

*Product specifications and data are subject to change without notice.*



**Manufacturer:**  
Dymax®

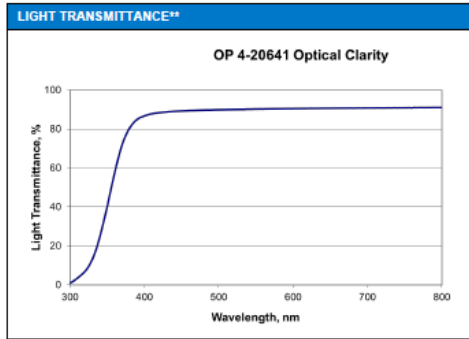
**Product Name:**  
Dymax OP-4-20641 UV Optical Adhesive (3ml)

**Manufacturer Part Number:**  
OP-4-20641-3ML

▶ Click here for more details on the Dymax OP-4-20641 UV Optical Adhesive (3ml)



OPTICAL ADHESIVES  
OP-4-20641 Product Data Sheet



**CURING GUIDELINES**

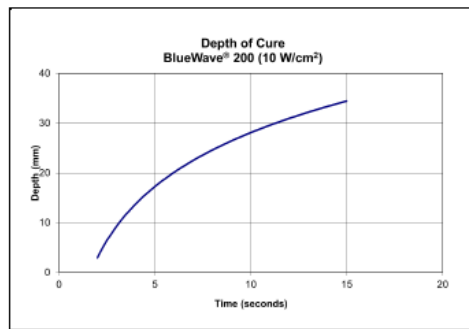
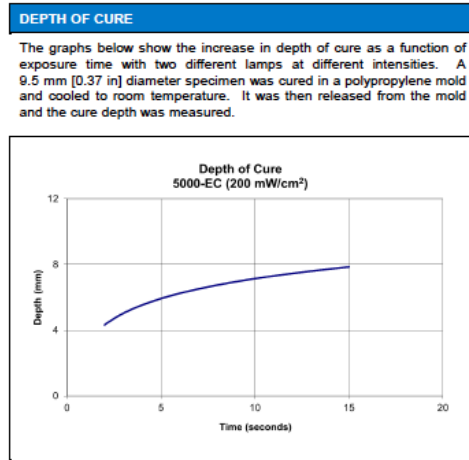
Fixture time is defined as the time to develop a shear strength of 0.1 N/mm<sup>2</sup> [10 psi] between glass slides. Actual cure time typically is 3 to 5 times fixture time.

| Dymax Curing System (Intensity)  | Fixture Time or Belt Speed <sup>A</sup> |
|--|---|
| 2000-EC (50 mW/cm <sup>2</sup> ) <sup>B</sup>                                  | 1 s                                     |
| 5000-EC (200 mW/cm <sup>2</sup> ) <sup>B</sup>                                 | 1 s                                     |
| BlueWave <sup>®</sup> LED DX-1000 Spot (10 W/cm <sup>2</sup> ) <sup>C</sup>    | 1 s                                     |
| BlueWave <sup>®</sup> LED Prime UVA (10 W/cm <sup>2</sup> ) <sup>C</sup>       |   |
| BlueWave <sup>®</sup> LED DX-1000 Flood (875 mW/cm <sup>2</sup> ) <sup>C</sup> | .5 s                                    |
| BlueWave <sup>®</sup> 75 (5.0 W/cm <sup>2</sup> ) <sup>B</sup>                 | 1.5 s                                   |
| BlueWave <sup>®</sup> 200 (10 W/cm <sup>2</sup> ) <sup>B</sup>                 | 1 s                                     |
| UVCS Conveyor with one 5000-EC (200 mW/cm <sup>2</sup> ) <sup>D</sup>          | 8.2 m/min<br>[27 ft/min]                |
| UVCS Conveyor with Fusion F300S (2.5 W/cm <sup>2</sup> ) <sup>D</sup>          | 8.2 m/min<br>[27 ft/min]                |

- A** Curing through light-blocking substrates may require longer cure times if they obstruct wavelengths used for light curing (320-400 nm for UV light curing, 320-450 nm for UV/Visible light curing). These fixture times/belt speeds are typical for curing thin films through 100% light-transmitting substrates.
- B** Intensity was measured over the UVA range (320-395 nm) using a Dymax ACCU-CAL™ 50 Radiometer.
- C** Intensity was measured over the UVA/Visible range (350-450 nm) using a Dymax ACCU-CAL™ 50-LED Radiometer.
- D** At 53 mm [2.1 in] focal distance. Maximum speed of conveyor is 8.2 m/min [27 ft/min]. Intensity was measured over the UVA range (320-395 nm) using the Dymax ACCU-CAL™ 150 Radiometer.

Full cure is best determined empirically by curing at different times and intensities, and measuring the corresponding change in cured properties such as tackiness, adhesion, hardness, etc. Full cure is defined as the point at which more light exposure no longer improves cured properties. Higher intensities or longer cures (up to 5x) generally will not degrade Dymax light-curable materials.

Dymax recommends that customers employ a safety factor by curing longer and/or at higher intensities than required for full cure.



Contact the professionals at Fiber Optic Center for a quote or to get more details.

[focenter.com](http://focenter.com) • 508-992-6464 | (800) 473-4237 • [sales@focenter.com](mailto:sales@focenter.com)

23 Centre Street • New Bedford, MA 02740 USA

Product specifications and data are subject to change without notice.



**Manufacturer:**  
Dymax®

**Product Name:**  
Dymax OP-4-20641 UV Optical Adhesive (3ml)

**Manufacturer Part Number:**  
OP-4-20641-3ML

▶ [Click here for more details on the Dymax OP-4-20641 UV Optical Adhesive \(3ml\)](#)



## OPTICAL ADHESIVES

### OP-4-20641 Product Data Sheet

#### OPTIMIZING PERFORMANCE AND HANDLING

1. This product cures with exposure to light. Exposure to ambient and artificial light should be kept to a minimum before curing. Dispensing components including needles and fluid lines should be 100% light blocking, not just UV blocking.
2. All surfaces in contact with the material should be clean and free from flux residue, grease, mold release, or other contaminants prior to dispensing the material.
3. Cure speed is dependent upon many variables, including lamp intensity, distance from the light source, required depth of cure, thickness, and percent light transmission of components between the material and light source.
4. Oxygen in the atmosphere may inhibit surface cure. Surfaces exposed to air may require high-intensity (>100 mW/cm<sup>2</sup>) UV light to produce a dry surface cure. Flooding the curing area with an inert gas, such as nitrogen, can also reduce the effects of oxygen inhibition.
5. Parts should be allowed to cool after cure before testing and subjecting to any loads or electrical testing.
6. In rare cases, stress cracking may occur in assembled parts. Three options may be explored to eliminate this problem. One option is to heat anneal the parts to remove molded-in stresses. A second option is to open any gap between mating parts to reduce stress caused by an interference fit. The third option is to minimize the amount of time the liquid material remains in contact with the substrate(s) prior to curing.
7. Light curing generally produces some heat. If necessary, cooling fans can be placed in the curing area to reduce the heating effect on components.
8. At the point of curing, an air exhaust system is recommended to dissipate any heat and vapors formed during the curing process.

#### DISPENSING THE MATERIAL

This material may be dispensed with a variety of manual and automatic applicators or other equipment as required.

#### CLEAN UP

Uncured material may be removed from dispensing components and parts with organic solvents. Cured material will be impervious to many solvents and difficult to remove. Clean up of cured material may require mechanical methods of removal.

#### STORAGE AND SHELF LIFE

Store the material in a cool, dark place when not in use. Do not expose to light. This product may polymerize upon prolonged exposure to ambient and artificial light. Keep covered when not in use. This material has an 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.

#### 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.

The data provided in this document are based on historical testing that Dymax performed under laboratory conditions as they existed at that time, and are for informational purposes only. The data are neither specifications nor guarantees of future performance in a particular application. Dymax does not guarantee that this product's properties are suitable for the user's intended purpose.

Numerous factors—including, without limitation, transport, storage, processing, the material with which the product is used, and the ultimate function or purpose for which the product was obtained—may affect the product's performance and/or may cause the product's actual behavior to deviate from its behavior in the laboratory. None of these factors are within Dymax's control. Conclusions about the behavior of the product under the user's particular conditions, and the product's suitability for a specific purpose, cannot be drawn from the information contained in this document.

It is the user's responsibility to determine (i) whether a product is suitable for the user's particular purpose or application and (ii) whether it is compatible with the user's intended manufacturing process, equipment, and methods. Under no circumstances will Dymax be liable for determining such suitability or compatibility. Before the user sells any item that incorporates Dymax's product, the user shall adequately and repetitively test the item in accordance with the user's procedures and protocols. Unless specifically agreed to in writing, Dymax will have no involvement in, and shall under no circumstances be liable for, such testing.

Dymax makes no warranties, whether express or implied, concerning the merchantability of this product or its fitness for a particular purpose. Nothing in this document should be interpreted as a warranty of any kind. Under no circumstances will Dymax be liable for any injury, loss, expense or incidental or consequential damage of any kind allegedly arising in connection with the user's handling, processing, or use of the product. It is the user's responsibility to adopt appropriate precautions and safeguards to protect persons and property from any risk arising from such handling, processing, or use.

Nothing contained herein shall act as a representation that the product use or application is free from patents owned by Dymax or any others. Nothing contained herein shall act as a grant of license under any Dymax Corporation Patent.

Except as otherwise noted, all trademarks used herein are trademarks of Dymax. The "®" symbol denotes a trademark that is registered in the U.S. Patent and Trademark Office.

The contents of this document are subject to change. Unless specifically agreed to in writing, Dymax shall have no obligation to notify the user about any change to its content.

**Contact the professionals at Fiber Optic Center for a quote or to get more details.**

[focenter.com](http://focenter.com) • 508-992-6464 | (800) 473-4237 • [sales@focenter.com](mailto:sales@focenter.com)

23 Centre Street • New Bedford, MA 02740 USA

*Product specifications and data are subject to change without notice.*