

## Adhesive List for Microdrop Dispenser Heads Curing with UV

adhesive	type of curing	typical viscosity*		nozzle**		dispensing property
		mPas	°C	Ø µm	temperature °C	
Byllux 6308	UV	40	n.d.	60	25	good
Byllux 6508	UV	15	n.d.	60	25	good
Conloc 688	UV	75	n.d.	100	35	difficult
Delo Photobond 4302	UV	100	23	65	60	difficult
Delo Photobond 4436	UV	350	23	65	115	difficult
Delo Photobond GB 310	UV	100	23	100	50	good
Dymax 136 M <sup>1</sup>	UV	90	25	65	65	good
Dymax 190 M <sup>1</sup>	UV	75	25	65	60	good
Dymax 3013	UV	150	25	65	115	difficult
Dymax 3-20256	UV	50	25	65	90	difficult
Dymax 401	UV	70	25	65	50	difficult
Dymax 625 VLV	UV	55	25	65	25	good
Epo-Tek OG 198-54	UV	327	23	75	70	difficult
Epo-Tek UVO 114	UV	450	23	70	85	good
Loctite 3301 <sup>1</sup>	UV	150	25	100	70	difficult
Loctite 661	UV, K	500	25	100	80	difficult
NOA 61	UV	300	25	100	75	good
NOA 63	UV	2500	25	67	100	difficult
NOA 65	UV	1000	25	100	90	good
NOA 68	UV	5000	25	67	128	difficult
NOA 72	UV	175	25	50	80	good
NOA 73	UV	140	25	100	55	good
NOA 74	UV	90	25	67	50	good
NOA 81	UV	300	25	67	75	good
NOA 88	UV	250	25	67	125	difficult
Vitralit 1505	UV	400	25	65	70	good
Vitralit 2009F	UV	100-200	25	91	60	difficult
Vitralit 6127	UV	20-100	25	91	35	good
Vitralit 6164	UV	30	25	65	30	good
Vitralit 9106	UV	250	25	65	95	difficult
Vitralit 70001	UV	50-90	25	91	75	difficult

## Adhesive List for Microdrop Dispenser Heads Two Component Systems

adhesive	type of curing	typical viscosity*		nozzle**		dispensing property
		mPas	°C	Ø µm	temperature °C	
Araldit DBF (Resin)	2K	1300-1800	25	100	67	good
Araldit Hardener HY 956	2K	370-470	25	59	75	good
Epo-Tek 301-2 A	2K	n.d.	n.d.	94	110	difficult
Epo-Tek 301-2 B	2K	n.d.	n.d.	100	28	good
Epo-Tek 353 ND A	2K	n.d.	n.d.	100	70	difficult
Epo-Tek 353 ND A	2K	n.d.	n.d.	100	90	difficult
Epo-Tek 353 ND B	2K	n.d.	n.d.	100	60	difficult
Epo-Tek 353 ND B	2K	n.d.	n.d.	100	70	good
Epoxonic 226 A	2K	1500	25	67	100	good
Epoxonic 226 B	2K	30	25	67	40	good
Epoxonic 50 A	2K	n.d.	n.d.	67	98	good
Epoxonic 50 B	2K	n.d.	n.d.	67	65	good

## Adhesive List for Microdrop Dispenser Heads Anaerob Adhesives

adhesive	type of curing	typical viscosity*		nozzle**		dispensing property
		mPas	°C	Ø µm	temperature °C	
Delo ML 5228	AN	300	23	65	100	difficult
Delo ML 5302	AN	15	23	65	25	good
Delo ML 5327	AN	300	23	65	70	difficult
Loctite 290	AN	12	25	50	25	good
Loctite 601	AN	125	25	25	50	good
Loctite 648 UV anaerob	AN	500	25	50	100	difficult

AN = anaerob systems; K = combination hardening; 2K = two components;  
n.d. = no data; UV = ultraviolett

<sup>1</sup> ISO10993 for medical device

\* wide viscosity-range by different batches of glue

\*\* only nozzle tip is heated, (over 10 mm length); holder and storage bin not heated!

NOA = Norland Optical Adhesive by Gentec; Epo-Tek by J.P. Kummer;  
Vitalit by Panacol-Elosol, Araldit by Bodo Möller Chemie, Byllux by Byla