

### Description

EW 6339 is a one-part epoxy adhesive with low shrinkage and good flowability. It is optically transparent. It is ideal for potting and bonding of optical components.

### Features

- Recommended substrates: glass, aluminum, stainless steel, PC and PCB
- UV or fast thermal curing
- Optically transparent
- Very low viscosity

### Uncured Properties

<b>Chemical Type</b>	Epoxy
<b>Appearance</b>	Transparent
<b>Viscosity @ 25°C [mPa·s]</b> Brookfield DV2T, spindle 14# @ 20rpm	500
<b>Specific Gravity [g/cm<sup>3</sup>]</b>	~1.15
<b>Shelf Life @ 2-8°C [months]</b>	6

### Curing Conditions

<b>Surface Curing [secs]</b> UVA at 100mW/cm <sup>2</sup> using high pressure mercury UV Lamp	30
<b>Depth of Light Cure [mm]</b>	3
<b>Thermal Curing @ 90°C [mins]</b>	30

### Cured Properties

<b>Hardness [Shore D]</b> ASTM D2240	75
<b>Shear Strength [MPa]</b> PCB / PCB ASTM D1002	10
<b>Tensile Strength [MPa]</b> ASTM D638	12

<b>Elongation at Break [%]</b> ASTM D638	5
<b>Refractive Index [%]</b> ASTM D1807	1.51

### Directions for Use

#### 1. Surface Treatment

Surfaces to be bonded should be free of dust, oil, grease or any other contaminants in order to achieve a reproducible bond. For slightly contaminated surfaces, it is sufficient to wipe with isopropanol or ethanol. Substrates with a low surface energy (e.g. polyethylene, polypropylene, Teflon) need to be pre-treated physically (e.g. atmospheric plasma or corona) in order to achieve sufficient adhesion.

#### 2. Application

Products are supplied ready for use. Depending on package type, they can be dosed manually, semi-automatically or fully-automatically with a dosage apparatus. With automatic dispensing using a cartridge, the adhesive is conveyed via pressure and a piston rod to a dispense valve. With bottles, the adhesive is conveyed using a pump.

After application, it is recommended that the two substrates be adjoined immediately as it is possible the curing process will begin with select products under ambient conditions.

3. Suggested working temperature range is -40 to 130°C.

### Storage

Maximum shelf life may be obtained when product is stored in a cool, dry location at a temperature between **2°C to 8°C**.

TO PREVENT CONTAMINATION OF UNUSED PRODUCT, DO NOT RETURN ANY PRODUCT TO ITS ORIGINAL CONTAINER.

**Allow the product to thaw for two hours after it is removed from the refrigerator prior to use.** It is best practice to wipe away any moisture on the surface of the syringe with cleanroom wipes.

### Materials Handling

Refer to the Material Safety Data Sheet (MSDS) for this product.

#### *Disclaimer*

*The information provided here including the recommendations for use and application of the product is based on internal laboratory test conditions and should only be used as a reference. CollTech does not assume responsibility for the test or performance results obtained by the user. It is the responsibility of the user to perform their own evaluations to confirm whether this product is suitable for their application.*