

# Light Lock MV

**LOW-ODOR, LIGHT-CURING CYANOACRYLATE**

TECHNICAL DATA SHEET

Revised October 2020



## PRODUCT DESCRIPTION

**Born2Bond™ Light Lock MV** is a low-odor, low-blooming, dual curing (contact and lightcuring), cyanoacrylate adhesive. It is designed for bonding applications that require fast fixturing coating or surface cure. The UV- and visible-light cure sensitivity allows rapid bonding through transparent parts and quick curing of light-exposed bulk or surface-coated areas, while the instant bonding capability ensures cure between opaque substrates (contact cure).

## KEY FEATURES

- Dual cure formulation: instant and photo-cure
- Fixture time in 60 s (without light exposure)\*
- Can be cured with visible and UV-LED light <5 sec
- Long open time without activation
- Dry to touch, tack free surface cure
- Cure-on-demand of excess material released from bondlines
- Bonds, fills, reconstructs and coats
- Low odor, low blooming
- Available in a range of viscosities: MV, HV and Gel

## DIRECTIONS FOR USE

1. Before applying Born2Bond Light Lock MV, make sure the surface is clean, dry and grease-free.
2. Apply adhesive to one surface. Do not use items like tissues or a brush to spread the adhesive.
3. Assemble the parts within a few seconds. The parts should be accurately positioned, as the short fixture time leaves little opportunity for adjustment.
4. Bonds should be fixed or clamped until the adhesive has reached fixture.
  - The product should be allowed to develop to full strength before subjecting it to any service loads (typically 24 to 72 hours after assembly, depending on bond gap, materials and ambient conditions).

## APPLICATIONS

Typical applications for this product are conformal coating, encapsulation, needle bonding, perfume and liquor bottle metal bonding, electronics assembly, plastic to metal bonding for hearing aids, and glass to metal bonding for jewelry and watches.

## STORAGE/SHELF LIFE

Optimal Storage: 2°C to 8°C (35.6°F to 46.4°F). Storage below 2°C (35.6°F) or greater than 8°C (46.4°F) can adversely affect the product's properties. If stored properly, this product has a shelf life of 12 months from the packaging date.

## HEALTH/SAFETY

The Safety Data Sheet is available on the Bostik website and should be consulted for proper handling, cleanup and spill containment before use. Keep containers covered to minimize contamination.

## LIMITATIONS

This product is not recommended for use in pure oxygen and/or oxygen-rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials. Material removed from containers may be contaminated during use. Do not return product to the original container. Bostik will not assume responsibility for product that has been contaminated or stored under conditions other than those previously indicated. If additional information is required, please contact your local Technical Service Center or customer service representative.

## PRODUCT CHARACTERISTICS

Base Technology	Methoxyethyl Cyanoacrylate
Components 1k - 2k	1k
Appearance/Color	Transparent/greenish
Temperature Use Range	-40°C to 80°C (-40°F to 176°F)
VOC Content (ISO 11890-2)	23 g/L

## UNCURED PHYSICAL PROPERTIES

Viscosity at 23°C (73.4°F)*	180 - 220 cP
Specific Gravity (ASTM D1875: 23°C / 73.4°F)	1.11 g/mL
Refractive Index, ABBE	1.45 - 1.46

\*based on Brookfield viscometer

## CURED PHYSICAL PROPERTIES

Shore Hardness D (ISO 868-2003)	81
Soft Point - HDT (ASTM E2092-18a)	57°C (134.6°F)
Glass Transition Temperature (ISO 6721)	90°C (194°F)
Coefficient of Linear Thermal Expansion (ISO 10545-8)	$55 \times 10^{-6}$
Water Absorption (after 24 hrs) (ASTM D542)	5.0%
Impact Resistance (after 24 hrs) (ISO 9653)	14.1 kJ/m <sup>2</sup>
<b>Electrical Properties of Resistivity IEC 60093</b>	
Surface resistivity DC 500 V (Ohm)	$1.9 \cdot 10^{15}$
Volume resistivity DC 1kV (Ohm.m)	$4.8 \cdot 10^{13}$
<b>Corrected Dissipation Factor, Dielectric Constant IEC 60250</b>	
D @ 1 kHz	0.027
k' @ 1 kHz	4.08
D @ 1 MHz	0.02
k' @ 1 MHz	3.73
DC breakdown voltage according to IEC 60243-1	25.9 kV/mm

## CONVERSIONS

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$
$\text{kV/mm} \times 25.4 = \text{V/mil}$
$\text{mm} / 25.4 = \text{in}$
$\mu\text{m} / 25.4 = \text{mil}$
$\text{N} \times 0.225 = \text{lb}$
$\text{N/mm} \times 5.71 = \text{lb/in}$
$\text{N/mm}^2 \times 145 = \text{psi}$
$\text{MPa} \times 145 = \text{psi}$
$\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$
$\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$
$\text{mPa}\cdot\text{s} = \text{cP}$

## FIXTURE TIME

### Contact Cure\* (0.1N/mm<sup>2</sup>)

Stainless Steel (A316)	40 - 70 seconds
Steel (Mild Steel)	10 - 30 seconds
Aluminum (A5754)	10 - 40 seconds
Neoprene	20 - 50 seconds
EPDM	10 - 30 seconds
Rubber, nitrile	10 - 30 seconds
ABS	10 - 50 seconds
PVC	40 - 90 seconds
Polycarbonate	15 - 60 seconds
Phenolic	40 - 80 seconds
Wood (Oak)	>15 minutes
Wood (Pine)	35 - 70 seconds
Chipboard	20 - 80 seconds
Leather	10 - 30 seconds
PC/ABS	25 - 60 seconds
Paper	15 - 40 seconds

### Curing Speed with Light\* - 405 nm UV Visible LED (28 mW/cm<sup>2</sup>)

PMMA	< 5 seconds
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\*if stored in proper conditions

## BONDING PERFORMANCE

### Lap shear strength (ISO 4587) @ 23°C (73.4°F) (MPa)

#### @ 2mm/min after 10s Curing UV LED

PC / Steel (grit-blasted)	2	+/- 1
PC / Aluminum (A5754)	5	+/- 1
PC / Polycarbonate	2	+/- 1

#### @ 2mm/min after 24h Curing at RT

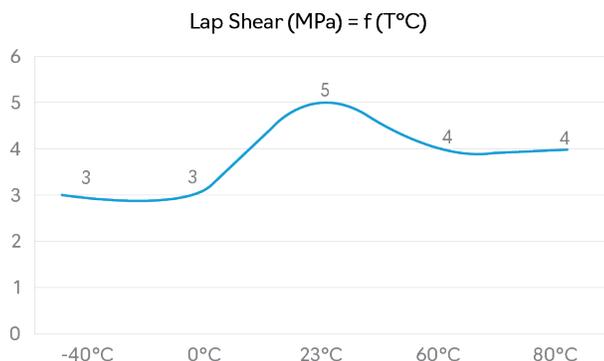
ABS	5	+/- 1
PVC	6	+/- 1
Phenolic	11	+/- 1

#### @ 2mm/min after 1 Week Curing at RT

Polycarbonate	5	+/- 1
GBMS/PC	8	+/- 1

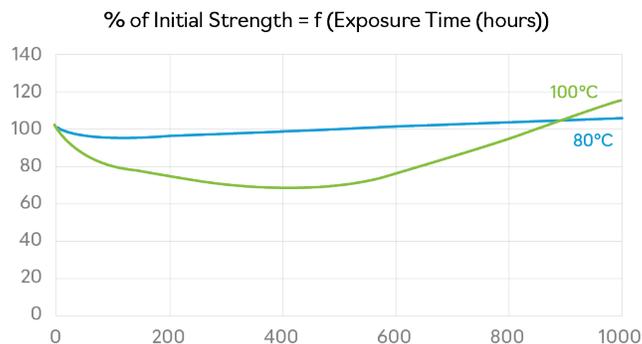
## HOT STRENGTH

The graph below shows the adhesive's performance on grit-blasted, mild steel (GBMS) at various temperatures. The adhesive was cured for one week at 22°C (71.6°F). The lap shear strength was tested according to ISO 4587. The lap shear bonding strength test was performed in a climatic chamber that was set up for 10 minutes before testing at the indicated temperatures.



## HEAT AGING

The graph below shows the heat aging results. The adhesive was cured for one week and aged at the temperature indicated, tested at 22°C (71.6°F). The lap shear strength was tested according to ISO 4587 on polycarbonate.



## CHEMICAL/SOLVENT RESISTANCE

Aged under conditions indicated and tested on GBMS.

% of Initial Strength vs. Exposure Time (hours) and vs. Type of Contaminant				
Testing on GBMS		% of Initial Strength		
ENVIRONMENT	TEMP	100 H	500 H	1000 H
Motor oil	40°C (104°F)	100	100	110
Ethanol	40°C (104°F)	105	100	90
Gasoline	40°C (104°F)	100	90	90
IPA	40°C (104°F)	110	120	110
Water	40°C (104°F)	40	20	20

## HEAT/HUMIDITY RESISTANCE

Aged under conditions indicated and tested @ 23°C (73.4°F).

% of Initial Strength vs. Exposure Time (hours)			
ENVIRONMENT - 95% RH & 40°C (104°F)	% of Initial Strength		
	100 H	500 H	1000 H
GBMS	60	40	50
Polycarbonate	100	75	95

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