

**LOCTITE 3623**

September 2017

**PRODUCT DESCRIPTION**

LOCTITE 3623 provides the following product characteristics:

<b>Technology</b>	Acrylate
<b>Appearance</b>	Translucent liquid
<b>Cure</b>	UV Cure
<b>Application</b>	Device assembly, Primer

LOCTITE 3623 one part, UV curable adhesive is designed for wire protection coating in headphone assembly manufacturing.

**TYPICAL PROPERTIES OF UNCURED MATERIAL**

Viscosity, HAAKE PK1, 2° Cone @ 25 °C, ± 0.5°C, mPa·s (cP):

@ Shear rate of 20 s<sup>-1</sup> 18,680

**TYPICAL CURING PERFORMANCE****Typical UV Cure Condition(s)**

CTV, cured 30 seconds @ 100 mW/cm<sup>2</sup>, mm 2.5  
 Tack Free Time, 100 mW/cm<sup>2</sup>, seconds 15  
 Fixture Time, 6 mW/cm<sup>2</sup>, seconds 10

**Depth of Cure**

Sample tested using Uvaloc 1000, 3.1  
 irradiance 100 mW/cm<sup>2</sup>,  
 exposure time 30 seconds

The above cure profile is a guideline recommendation. Cure rate and ultimate depth of cure depend on light intensity, spectral distribution of light source, exposure time and the light transmittance of the substrate.

**TYPICAL PROPERTIES OF CURED MATERIAL****Physical Properties**

Hardness, Shore D 72.5

**GENERAL INFORMATION**

For safe handling information on this product, consult the Safety Data Sheet, (SDS).

**Not for product specifications**

The technical data contained herein are intended as reference only. Please contact your local quality department for assistance and recommendations on specifications for this product.

**Conversions**

(°C x 1.8) + 32 = °F  
 kV/mm x 25.4 = V/mil  
 mm / 25.4 = inches  
 N x 0.225 = lb  
 N/mm x 5.71 = lb/in  
 psi x 145 = N/mm<sup>2</sup>  
 MPa = N/mm<sup>2</sup>  
 N·m x 8.851 = lb·in  
 N·m x 0.738 = lb·ft  
 N·mm x 0.142 = oz·in  
 mPa·s = cP

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#### Reference 1