



SurABond®

ADHESIVE

HH 240

Excellent for the temporary bonding of optical components made of glass, quartz, metals and ceramics for the purpose of processing

Product Information

Adhesive SurABond® HH 240



*The **SurABond® HH 240** adhesive is RoHS-compliant in accordance to the European directive 2011/65/EC. All ingredients are pre-registered according to REACH Regulation (EC) No. 1907/2006.*

1. Introduction

This product information seeks to ensure the proper use of the **SurABond® HH 240** adhesive and prevent eventual mistakes, which can lead to quality insufficiencies or adverse effects.

SurABond® HH 240 is an UV- or light-curing one-component adhesive for temporary fixing for the application in precision optics processing. SurABond® HH 240 bonds glass on glass as well as on metals, ceramics featuring a mechanical-stable bond during processing. After the processing steps (e.g., cutting, grinding or polishing), the adhesion can be unblocked by an aqueous surfactant containing solution.

SurABond® HH 240 is environmental friendly due to the exclusive utilization of water as separating medium and perfectly suitable for the substitution of raw cements.

SurABond® HH 240 is suitable for temporary bonding of optical components made of glass and quartz, between themselves as well as with metals and ceramics for the subsequent processing by cutting, grinding and polishing, in particular by ultrasonic cutting.

Distinguished properties:

- **UV- and light-curing at room temperature in a matter of seconds**
- **moisture stable during processing**
- **environmental friendly due to unblocking by water-based solution**
- **crystal clear**



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Product Information

2. Surface Pretreatment

The surface to be adhering should be dry as well as free of dust and other impurities. We recommend alcohol, acetone, ethyl acetate or other cleaners established for optical components for the surface cleaning.

3. Processing

SurABond® HH 240 can be applied manually or automatically by a dispenser as well as other common methods.

The adhesive has to be mixed thoroughly by shaking before using.

4. Curing Conditions

SurABond® HH 240 has to be cured by UV-irradiation for 10 to 50 seconds, depending on the radiation intensity.

5. Treatment and unblocking

The treatment of the optical components, which are fixed on the carrier, can be performed in the usual manner. The component/carrier bond will be unblocked by the immersion in a 3% aqueous solution of the Deblocker SurAChem® HR 90. The unblocking time depends on the adhesive surface and solution temperature. The following unblocking times are established for an adhesive surface of 6 cm²:

| | |
|----------|------|
| at 80 °C | 1 h |
| at 30 °C | 10 h |

Subsequently, the components have to be thoroughly cleaned with deionized water before the processing will be continued. The removed adhesive can be easily separated from the aqueous solution by filtration.

6. Delivery Form

SurABond® HH 240 adhesive is available in black dropping bottles, starting from 25 mL.

7. Storage

SurABond® HH 240 adhesive is in unopened conditions and at room temperature stable for 3 month.



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8. Instructions to Occupational and Health Safety

Irritating to eyes and skin. May cause sensitization by skin contact. If on skin, wash immediately with plenty of water and mild soap.

The conversion of all reactive groups is complete after correct curing of the adhesive. Any type of contact is not harmful in that state.

Wear protecting gloves when working with deblocker SurAChem® HR 90. Avoid any skin contact. If on skin, wash immediately with plenty of water and mild soap.

9. Technical Data

| | |
|-----------------------------|---------------------------|
| Chemical basis | modified acrylate |
| Color | Light yellow, transparent |
| Density DIN EN 542 | 1.18 g/cm ³ |
| Solid content | 100% |
| Viscosity | 20 mPas |
| Heat deflection temperature | Up to 80 °C |

For eventual questions or doubts concerning your product, we encourage you to get in touch with SurA Chemicals GmbH.

The information and technical consultation given by SurA Chemicals GmbH, verbally or written, is based on the company's best knowledge and shall only be considered as non-binding advice, also in respect of the protected rights of third parties. The company's technical consultation does not release the customer from own examination concerning the suitability and usability of the company's product. The manufacturer's liability extends solely to the value of the products supplied by SurA Chemicals GmbH and applied by the customer.

SurA Chemicals GmbH guarantees its products to be of perfect quality as stated in its general terms and conditions of sale and delivery.



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