

Technical Data Sheet *Proprietary* **BlueGrip™ S2 Workholding Adhesive**

Product Description

Blue Photon's BlueGrip S2 is an ultraviolet (UV) curable workholding adhesive designed for bonding and fixturing. The gel like consistency of BlueGrip S2 allows the formation of thick bond lines for bonding of widely spaced or uneven workpieces. BlueGrip S2 is designed especially for use with the Blue Photon workholding system.

Typical Applications

Typical applications for BlueGrip S2 include bonding of metal, ceramic and other materials to a Blue Photon gripper attached to a workholding fixture.

Instructions for Use

For best performance, surfaces should be free of dirt and grease. Apply enough of the BlueGrip S2 to the gripper face to completely fill the gap between the gripper and the workpiece, then load the workpiece in the fixture as needed and expose to a 385 nm UV light source through the gripper. Adhesive can be thermally cured at 130°C for 45-60 minutes. Allow adhesive to cool at room temperature before use with UV light.

Technical Features

Chemical Type Acrylic
Appearance Translucent White
Glass Transition (*by DSC*) 149°F
Viscosity @ 25°C ~350,000 cps
Specific Gravity 1.07

Performance of Cured Material

Depth of cure when using UV light..... .010-.125"¹
Maximum Gap Fill125"
Block Shear >2200 psi
(*Modified ISO13445, 0.25 in² steel block to glass plate*)
Temperature Range 32°F to 120°F²

¹Contact Blue Photon for recommended adhesive joint thickness

²Holding ability will decrease as joint temperature increases

Packaging

30 cc Amber Syringe
1L Amber Cartridge
40 lb Pail
Others Available

General Information

Safe Handling and Storage

Store BlueGrip S2 in its original container in a cool, dry location below 80°F. Refrigeration recommended for hot locations. Avoid prolonged exposure to light.

Shelf Life

9 months from date of manufacture.

Note

This data is furnished for information only and is believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is recommended that the product be tested in the application for which it is to be used.

For assistance and recommendations on specifications for this product, contact Blue Photon at sales@bluephoton.com.

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