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NORLAND OPTICAL ADHESIVE 168HC

Norland Optical Adhesive 168HC is a clear and slightly yellow tinted liquid adhesive that will cure to a clear film when exposed to long wave ultraviolet and/or visible light. NOA 168HC is recommended for bonding glass to glass. Adhesion is also good to cellulose acetate butyrate and polycarbonate. This adhesive when fully cured is very rigid and brittle. NOA 168HC can be cured with ultraviolet light from 315nm to 395nm. Peak absorption is at 365nm. It can also be cured with visible light from 400nm to 450nm. Full cure requires 6 Joules/cm². The NOA 168HC can withstand temperatures from -15 °C to 125 °C.

If used as a coating or exposed to air, the adhesive will need to be cured under a nitrogen atmosphere to prevent the surface from remaining tacky due to oxygen inhibition.

Typical Properties of NOA 168HC

Refractive Index Cured	1.68
Viscosity @ 25C	2000-3000 cps
Hardness - Shore D	80
Color of Cured Polymer	Clear

Keep NOA 168HC in a cool (5-25°C) dark place. If refrigerated, allow the adhesive to come to room temperature before using. The full shelf life is 1 year from the date of manufacture and we guarantee that it will have at least 6 months at time of shipping.

Care should be taken in handling this material. The material Safety Data Sheet should be read for this product. Prolonged contact with skin should be avoided and affected areas should be washed thoroughly with copious amounts of soap and water. If adhesive gets into eyes, flush with water for 15 minutes and seek medical attention.

The data contained in this technical data sheet is of a general nature and is based on laboratory test conditions. Norland Products does not warrant the data contained in this data sheet. Norland does not assume responsibility for test or performance results obtained by users. It is the users responsibility to determine the suitability for their product application, purposes and the suitability for use in the user's intended manufacturing apparatus and methods. The user should adopt such precautions and use guidelines as may be reasonably advisable or necessary for the protection of property and persons. Nothing in this technical data sheet shall act as a representation that the product use or application will not infringe a patent owned by someone other than Norland Products or act as a grant of a license under any Norland Products Inc patent. Norland Products recommends that each user test its proposed use and application before putting into production.