NORLAND PRODUCTS INCORPORATED
1095 Cranbury South River Road, Suite 20, Jamesburg, NJ 08831
Tel • 609-395-1966 Fax • 609-395-9006
Website: www.norlandproducts.com

Norland Blocking Adhesive 108

NBA 108 is a single component, UV curing adhesive used for temporary bonding of lenses to metal polishing mounts. This blocking adhesive is formulated to be used with polishing processes that use large amounts of liquid or use heavy grinding. The adhesive cures in minutes at room temperature by exposure to long wave UV light and eliminates the heat induced strain typical of the old fashioned hot pitch blocking methods. NBA 108 is specifically formulated to provide low shrinkage and low strain to further minimize any potential strain on the lens during the blocking process. Debonding is accomplished by soaking in acetone.

The adhesive cures only by exposure to UV light in the range of 350 to 380 nanometers. Recommended light sources include mercury lamps, sun lamps, fluorescent black lights and xenon lamps. Norland Products sells a variety of light sources optimized for curing our adhesive. The adhesive needs 5 joules per centimeter squared of long wave UV energy to fully cure. Cure time will depend on the amount of UV energy the light source used generates at the surface of the adhesive.

Debonding is accomplished by immersing parts in acetone. Debonding time is a function of surface area. Plano surfaces will require more time than surfaces with only slight edge contact, therefore annular ring designs of the mounting block are most efficient. Relief grooves or slots in the metal block may also be used for promoting the deblocking process by allowing the solution to come in contact with more of the adhesive.

Lenses may also be debonded by heating between 80 and 100° C. After separation, the components and tools are cleaned in acetone.

Shelf life of the liquid is at least 6 months at room temperature if stored in the original container away from UV light. Prolonged skin contact should be avoided and affected areas should be washed with soap and water. Avoid prolonged vapor inhalation and use in a well ventilated area.

Typical Properties of NBA 108

Solids :	**100%**
Viscosity at 25° C:	**550cps**
Refractive Index (cured)	**1.51**
Elongation at Failure	**18%**
Modulus (psi)	**710**
Tensile (psi)	**101**
Hardness - Shore D:	**25**