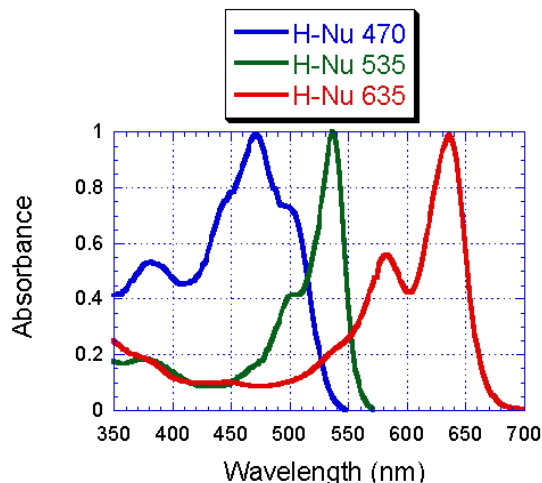


H-Nu 635 Visible Light Photoinitiator

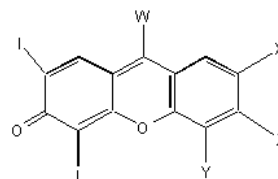
Name: 2,4,5,7-Tetraiodo-3-hydroxy-9-cyano-6-fluorone	Formula: C ₁₄ H ₂ I ₄ NO ₃
CAS # 144735-94-4	Synonyms: TIHCF, H-Nu 635

General Information

- H-Nu Series of Fluorone dyes (H-Nu 470, 535 and 635) - photoinitiators with panchromatic absorbance throughout the UVA/visible spectrum (350-670 nm)
- **H-Nu 635** - capable of curing a wide range of resins:
Acrylates - free-radical mechanism
- **H-Nu 635** - experimental photoinitiator, broad absorbance range of 500 nm to 660 nm (λ_{max} =635 nm)



H-Nu Photoinitiator Structures



Compound	W	X	Y	Z	ϵ	λ_{max} (nm)
H-Nu 470	H	H	H	OBu	30200	470
H-Nu 535	H	I	I	OH	91200	535
H-Nu 635	CN	I	I	OH	80000	635

ϵ is the molar extinction coefficient. λ_{max} (nm) is the peak maximum absorbance wavelength

Benefits of Use

- High absorptivity, low concentrations are needed (0.01-0.15 wt%)
- Capable of significant depth of cure in free radical formulations, > 1 inch
- Time and energy savings when one-pass thick cure can replace thin multi-layered coatings
- Cure through UV opaque, pigmented, or colored substrates (e.g. Kapton)
- Initiator bleaching: from bright blue to pale blue/no residual color
- Bleaching/color change indicator of exposure/cure with UV/visible light

Physical Properties

Appearance	Blue Solid
Molecular Weight	741 g/mol
Melting Point	>270 °C
Absorbance Maximum	635 nm
Molar Extinction Coefficient	90,000 (635 nm)

Photoinitiator Usage Recommendations

Complete dissolution of H-Nu Photoinitiators is required for best results:

- Dissolving H-Nu photoinitiators requires special care. Direct solubility of H-Nu 635 in resins can be difficult, predissolution of H-Nu photoinitiators in one of the following resins/solvents before adding resin is recommended
 - **Free Radical -- DMAA (N,N-Dimethylacrylamide)**
 - usage at 5-10 parts **DMAA** to 1 part **H-Nu 635**
- The presence of any undissolved red particles is an indication of incomplete solubility. More heating or stirring may help with incorporation, or predissolution using **DMAA** as noted above is needed.
- Predissolving H-Nu 635 in the appropriate material may allow for easier addition and faster usage. If not predissolving **H-Nu 635**, stirring/heating (65C is ok) at least 3 to 4 hours before using the formulation to ensure maximum solubility is recommended.
- **H-Nu photoinitiator** systems and materials that contain them are light sensitive and should be kept in the dark or in light proof bottles when not in use.
- “Dimmed” light conditions or other form of light shielding for mixing and formulating when using H-Nu photoinitiators are recommended to prevent unwanted pre-polymerization.
- **Store under refrigerated conditions**

Photopolymerization Mechanism

Acrylate Cure (Free-radical)

- Coinitiators are required – amine acrylates (**AA**) at 5 - 10 wt.% are recommended
- H-Nu 254 iodonium salt is recommended for acceleration if needed (may cause instability)
- Recommended starting level of **H-Nu 535** - 0.05 - 0.15 wt.% based on total solids.
- Recommended starting concentrations:

Thin Cure (< 1 mm)

0.10 wt.% H-Nu 635	0.15 wt.% H-Nu 254	5 wt.% Amine Acrylate (AA)
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Thick Cure (1 mm or greater)

0.05 wt.% H-Nu 635	0.15 wt.% H-Nu 254	5-10 wt% AA
0.05 wt.% H-Nu 635	N/A	5-10 wt.% AA

Optimization may be necessary for each individual application

SGL's experimental coinitiator **Borate V** improves cure response over typical amine coinitiators and can be purchased separately.

Photoinitiator package (when added to a model acrylate formulation)	Reactivity (1-highest, 5-lowest)	Stability and storage
H-Nu 635 + H-Nu 254 + Borate V	1	Needs refrigeration as it may polymerize in the dark at room T, can be used by mixing just prior to using.
H-Nu 635 + Sulfonium Hexafluoroantimonate Salt + Borate V	2	Needs refrigeration as it may polymerize in the dark at room T, can use by mixing just prior to using.
H-Nu 635 + Borate V	3	Stable at room T, refrigeration recommended when not in use to prolong shelf life.
H-Nu 635 + H-Nu 254 + Amine	4	May be unstable depending on resin used – use only as necessary
H-Nu 635 + Amine	5	Stable

- Typical formulations with Borate V:

0.05 - 0.1 wt.% H-Nu 635	N/A	0.50 wt.% Borate V
0.05 – 0.1 wt.% H-Nu 635	0.5 wt.% H-Nu 254	0.50 wt.% Borate V
0.05 – 0.1 wt.% H-Nu 635	1 wt.% Sulfonium Salt	0.50 wt.% Borate V

It is best to dissolve **Borate V** directly into **DMAA** (2 parts **DMAA** to 1 part **Borate V**) before adding the resin as **Borate V** is difficult to dissolve in some resin systems.

Formulation Examples

Free Radical Polymerization: All values are wt%

Cure through red PMMA plastic, lamination of red PMMA to another plastic substrate:

0.15% H-Nu 635

10% DMAA

0.3% H-Nu 254

1% Borate V

Photoinitiator package added to:

100% Proprietary urethane acrylate oligomer

Product Safety and Handling

Please read MSDS information before handling any products described in this brochure.

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