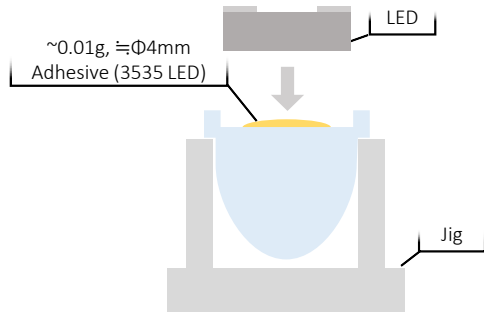


Adhesion

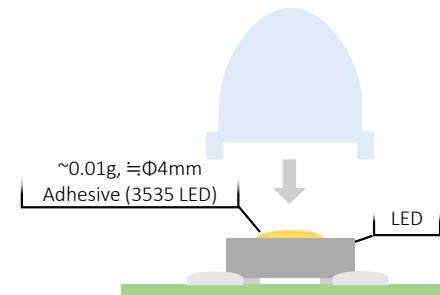
ASA Color lenses are not self-adhesive and must be attached using some type of adhesive or mechanical attachment. Some possible methods of adhesion are detailed below.

1. LED to Lens (Recommended)



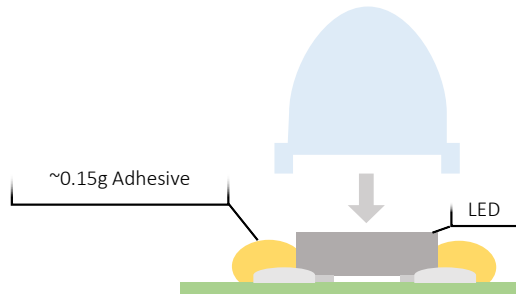
Secure in place and cure

2. Lens to Mounted LED



Ensure no floating or tilting of lens before curing

3. Lens to PCB



Ensure no floating or tilting of lens before curing
Recommended for opaque or room temp-curing adhesives

Adhesive Considerations

Adhesion Types 1 and 2

In addition to strength and compatibility with your processes, ensure your selected adhesive:

- Is silicone based
- Has low siloxane levels
- Does not yellow
- Is transparent / has appropriate UV transparency

*LED encapsulants containing adhesive components can be used as well.

Adhesion Type 3

In addition to strength and compatibility with your processes, ensure your selected adhesive:

- Is silicone based
- Has low siloxane levels
- Has high viscosity

Adhesive Recommendations on Next Page

Adhesion

ASA Color lenses are not self-adhesive and must be attached using some type of adhesive or mechanical attachment.

Recommended Adhesives

Maker	Dow Corning	Momentive	Shin-Etsu Silicone
Product Number	SE9186L	TSE3221S	X-32-1964
Cure Condition	20°C, 55%×6h (Room Temp Cure)	100°C×3h or 130°C×1h	100°C×3h
Viscosity	25 Pa·s	58 Pa·s	0.025 Pa·s
Type	Room Temp Cure (1 Component)	Heat Cure (1 Component)	Heat Cure (1 Component)
Adhesion Method	Lens to PCB (3)	LED to Lens / Lens to LED (1, 2)	

Mechanical

ASA Color lenses are not self-adhesive and must be attached using some type of adhesive or mechanical attachment. Mechanical attachment is illustrated below.

ASA Color standard lenses are flanged, allowing mechanical attachment as an alternative to adhesion.

Our recommended solution is a securing plate with a hole of ~5% larger diameter than the lens optic, fitted over the lens.

Care must be taken to ensure no scraping or other physical damage to the lens optic when mounting.

This method has the advantage of easier lens replacement while preserving the LED, especially for usage cases where a lens might be exposed to damage or contamination.

