

APPLICATION	TYPICAL THICKNESS	MATERIAL APPEARANCE	RECOMMENDED WAVELENGTH	WHY
Coating / Varnish	5 – 50 µm	Clear / transparent	365 nm	Very high reactivity, fast curing in thin layers
		Clear to lightly tinted	385 / 395 nm	Best compromise between speed and process robustness
		Pigmented / filled	395 / 405 nm	Better penetration, reduced surface absorption
UV Adhesive / Resin (Bonding)	< 100 µm	Clear	365 or 385 / 395 nm	Fast photoinitiator activation
	0.1 – 0.5 mm	Clear	395 nm	Versatile, good depth of cure
	> 0.5 mm	Clear to tinted	405 nm	Increased penetration through thickness
	All gaps	UV-filtering substrates	405 nm	Less absorbed by plastics and UV stabilizers
Potting / Encapsulation	> 1 mm	Clear	395 / 405 nm	More homogeneous bulk curing
	> 1 mm	Filled / opaque	405 nm	Improved material transmission
	Shadowed areas	All	405 nm + dual cure	Secures complete curing