

DELO-PHOTOBOND® 4302

UV-curing acrylate adhesive, low viscosity

Use

- specifically developed for interior visual bondings, e. g., bonding of prisms for beamers
- high transparency and permanent light fastness
- easy processing at room lighting is possible
- the product is normally used in a temperature range of -40 °C to +120 °C; depending on the application, other limits may be more reasonable

Base

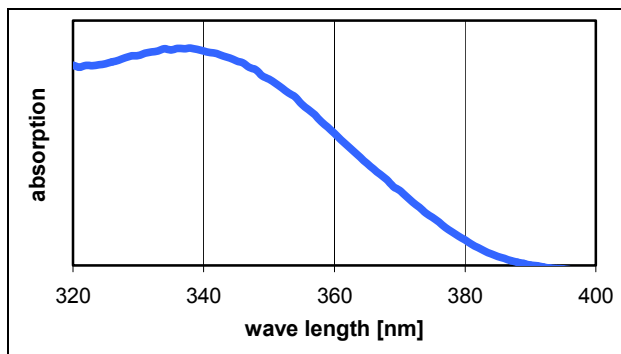
- modified acrylate
- one-component, solvent-free

Curing

- with UV light in a wavelength range of 320 - 400 nm

Absorption spectrum

photoinitiation system in acrylate matrix



Curing parameters

- dependent on material thickness and absorption, adhesive layer thickness, lamp type and distance between lamp and adhesive layer

Processing

- supplied ready for use and can be processed well from the original container or with DELO dispensing units
- the surfaces to be bonded must be dry as well as free of dust, grease and other contaminations
- use DELOTHEN cleaners for the cleaning of bonding surfaces
- use DELOTHEN EP cleaner for the cleaning of glass
- for further information please refer to the instructions for use

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Technical data

Color cured in a layer thickness of approx. 0.1 mm	colorless clear
Density [g/cm³] at room temperature (approx. 23 °C)	1.0
Viscosity [mPas] at 23 °C, Brookfield rpm 3/100	100
Minimal curing time [s] DELO Standard 23, UVA intensity: 60 mW/cm ² , DELOLUXcontrol	40
Surface	tacky and humid
Compression shear strength glass/glass [MPa] DELO Standard 5 UVA intensity: 55 - 60 mW/cm ² , DELOLUXcontrol, irradiation time: 60 s	31
Compression shear strength glass/Al [MPa] DELO Standard 5 UVA intensity: 55 - 60 mW/cm ² , DELOLUXcontrol, irradiation time: 60 s	29
Compression shear strength glass/PC [MPa] DELO Standard 5 UVA intensity: 55 - 60 mW/cm ² , DELOLUXcontrol, irradiation time: 60 s	5
Compression shear strength glass/PMMA [MPa] DELO Standard 5 UVA intensity: 55 - 60 mW/cm ² , DELOLUXcontrol, irradiation time: 60 s	6
Tensile strength [MPa] DIN EN ISO 527	16
Elongation at tear [%] DIN EN ISO 527	90
Young's modulus [MPa] DIN EN ISO 527	260
Shore hardness A DIN 53505	78
Shore hardness D DIN 53505	45
Glass transition temperature [°C] rheometer	111
Coefficient of linear expansion [ppm/K] in a temperature range of +25 to +140 °C	207
Shrinkage [vol. %] DELO Standard 13	10
Water absorption [weight %] DIN EN ISO 62, 24 h at room temperature (approx. 23 °C)	1.3
Index of refraction	1.5
Creep resistance CTI VDE 0303, part 1, IEC 112	600 M
Storage life at room temperature (max. 25 °C) in unopened original container	6 months

Instructions and advice

General

The data and information provided are based on tests performed under laboratory conditions. Reliable information about the behavior of the product under practical conditions and its suitability for a specific purpose cannot be concluded from this.

Many product properties are subject to temperature and may change permanently, especially at high temperatures.

It is the user's responsibility to test the suitability of the product for the intended purpose and temperature range of use by considering all specific requirements. Type and physical and chemical properties of the materials to be processed with the product, as well as all actual influences occurring during transport, storage, processing and use, may cause deviations in the behavior of the product compared to its behavior under laboratory conditions. All data provided are typical average values or uniquely determined parameters measured under laboratory conditions.

The data and information provided are, therefore, no guarantee for specific product properties or the suitability of the product for a specific purpose.

Instructions for use

The instructions for use of DELO-PHOTOBOND are available on: www.DELO.de. We will be pleased to send them to you on demand.

Occupational health and safety

see material safety data sheet

Specification

see quality assurance test report