

DELO-PHOTOBOND® AD494

UV- and light curing acrylate adhesive, high viscosity

Use

- multi-purpose for plastic/plastic, glass/plastic, metal/plastic and glass/glass bondings, e. g., bonding of glass into plastic frames or clips to glass
- combined light and UV curing also enables the curing of components which are difficult to transmit
- good equalization of tensions due to high elongation at tear
- high viscosity enables adhesive layer thicknesses of up to approx. 2 mm

Base

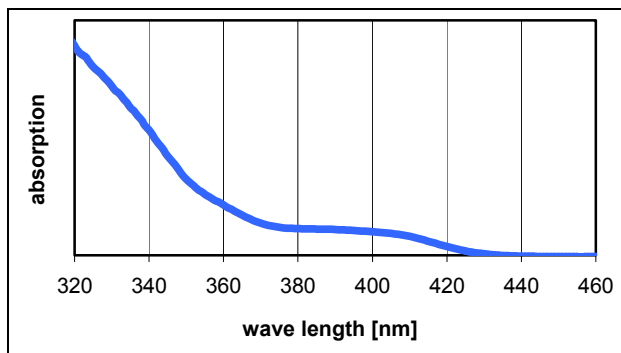
- modified acrylate
- one-component, solvent-free

Curing

- with visible light or UV light in a wavelength range of 320 - 450 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

DELO Industrial Adhesives
DELO-Allee 1 · D-86949 Windach
Phone +49 8193 9900-0
Fax +49 8193 9900-144
E-Mail info@DELO.de · www.DELO.de

Technical data

Color cured in a layer thickness of approx. 0.1 mm	yellowish clear
Density [g/cm³] at room temperature (approx. 23 °C)	1.06
Viscosity [mPas] at 23 °C, Brookfield rpm 7/5	50000
Minimal curing time [s] DELO Standard 23, UVA intensity: 60 mW/cm ² , DELOLUXcontrol	14
Surface	tacky
Compression shear strength glass/glass [MPa] DELO Standard 5 UVA intensity: 55 - 60 mW/cm ² , DELOLUXcontrol, irradiation time: 60 s	13
Compression shear strength glass/Al [MPa] DELO Standard 5 UVA intensity: 55 - 60 mW/cm ² , DELOLUXcontrol, irradiation time: 60 s	12
Compression shear strength glass/VA [MPa] DELO Standard 5 UVA intensity: 55 - 60 mW/cm ² , DELOLUXcontrol, irradiation time: 60 s	8
Compression shear strength glass/PC [MPa] DELO Standard 5 UVA intensity: 55 - 60 mW/cm ² , DELOLUXcontrol, irradiation time: 60 s	13
Compression shear strength glass/PMMA [MPa] DELO Standard 5 UVA intensity: 55 - 60 mW/cm ² , DELOLUXcontrol, irradiation time: 60 s	9
Compression shear strength PC/ABS [MPa] DELO Standard 5 UVA intensity: 55 - 60 mW/cm ² , DELOLUXcontrol, irradiation time: 60 s	12
Compression shear strength PC/Al [MPa] DELO Standard 5 UVA intensity: 55 - 60 mW/cm ² , DELOLUXcontrol, irradiation time: 60 s	10
Compression shear strength PA/PC [MPa] DELO Standard 5 UVA intensity: 55 - 60 mW/cm ² , DELOLUXcontrol, irradiation time: 60 s	11
Compression shear strength FR4/PA [MPa] DELO Standard 5 UVA intensity: 55 - 60 mW/cm ² , DELOLUXcontrol, irradiation time: 60 s	12
Compression shear strength PS/PS [MPa] DELO Standard 5 UVA intensity: 55 - 60 mW/cm ² , DELOLUXcontrol, irradiation time: 60 s	10
Tensile strength [MPa] DIN EN ISO 527	13
Elongation at tear [%] DIN EN ISO 527	310
Young's modulus [MPa] DIN EN ISO 527	20
Shore hardness A	82
Shore hardness D	25

Glass transition temperature [°C]	48
Shrinkage [vol. %]	6.8
Water absorption [weight %] DIN EN ISO 62, 24 h at room temperature (approx. 23 °C)	3
Storage life at room temperature (approx. 23 °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.

This is a test product. The product is, therefore, subject to modifications.

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