

DELO[®] PHOTOBOND[®] LA4878

modified urethane polymer | 1C | humidity-curing after preactivation

free of solvents | humidity-resistant, tension-equalizing, preactivated, unfilled

Special features of product

- compliant with RoHS Directive 2015/863/EU
- compliant with limits of VOC content in adhesive acc. to GB33372-2020

Typical area of use

- 40 - 120 °C
- glass/metal bondings
- bonding of temperature-sensitive substrates
- bonding of opaque components

Curing

Suitable lamp types LED 400 nm, LED 460 nm

Typical preactivation time

*intensity 300 mW/cm²
LED 400 nm* 6 s

*intensity 400 mW/cm²
LED 460 nm* 6 s

Processing

Conditioning time (typical)

*when stored in cold conditions
in containers up to 50 ml* 30 min

*when stored in cold conditions
in containers up to 600 ml* 5 h

Processing time

*at rt approx. +23 °C
in containers up to 600 ml* 14 d

Storage life in unopened original container

at 0 °C to +10 °C 6 month(s)

Technical properties

Color in cured condition in 0.1 mm layer thickness colorless

Transparency in cured condition in 0.1 mm layer thickness transparent

Color in cured condition in 1 mm layer thickness	colorless
Transparency in cured condition in 1 mm layer thickness	transparent

Parameters

Density <i>by the criteria of DIN 66137-2 liquid</i>	1.13	g/cm ³
Viscosity <i>liquid Rheometer Shear rate: 2 1/s Gap: 500 µm</i>	100000	mPa·s
Maximum curable layer thickness <i>400 nm 300 mW/cm² 6 s Plus at approx. +23 °C Rel. air humidity: 50 % 72 h</i>	2.5	mm
Maximum curable layer thickness <i>460 nm 400 mW/cm² 6 s Plus at approx. +23 °C Rel. air humidity: 50 % 72 h</i>	4	mm
Open time after preactivation <i>400 nm 300 mW/cm² 6 s</i>	17	s
Open time after preactivation <i>460 nm 400 mW/cm² 6 s</i>	34	s
Compression shear strength <i>DELO Standard 5 Glass Al, anodized 460 nm 400 mW/cm² 6 s Plus at approx. +23 °C Rel. air humidity: 50 % 72 h</i>	4	MPa
Compression shear strength <i>DELO Standard 5 Glass Glass 460 nm 400 mW/cm² 6 s Plus at approx. +23 °C Rel. air humidity: 50 % 72 h</i>	4	MPa
Compression shear strength <i>DELO Standard 5 Glass PA6 460 nm 400 mW/cm² 6 s Plus at approx. +23 °C Rel. air humidity: 50 % 72 h</i>	4	MPa
Compression shear strength <i>DELO Standard 5 PC PC 460 nm 400 mW/cm² 6 s Plus at approx. +23 °C Rel. air humidity: 50 % 72 h</i>	5	MPa
Compression shear strength <i>DELO Standard 5 PC-ABS PC-ABS 460 nm 400 mW/cm² 6 s Plus at approx. +23 °C Rel. air humidity: 50 % 72 h</i>	3	MPa
Compression shear strength <i>DELO Standard 5 PMMA PMMA 460 nm 400 mW/cm² 6 s Plus at approx. +23 °C Rel. air humidity: 50 % 72 h</i>	5	MPa

Tensile strength <i>by the criteria of DIN EN ISO 527 460 nm 400 mW/cm² 60 s Plus at approx. +23 °C Rel. air humidity: 50 % 168 h</i>	3	MPa
Elongation at tear <i>by the criteria of DIN EN ISO 527 460 nm 400 mW/cm² 60 s Plus at approx. +23 °C Rel. air humidity: 50 % 168 h</i>	500	%
Young's modulus <i>DMTA 460 nm 400 mW/cm² 60 s Plus at approx. +23 °C Rel. air humidity: 50 % 168 h</i>	< 10	MPa
Shore hardness 00 <i>by the criteria of DIN EN ISO 868 460 nm 400 mW/cm² 60 s Plus at approx. +23 °C Rel. air humidity: 50 % 168 h</i>	60	
Shore hardness A <i>by the criteria of DIN EN ISO 868 460 nm 400 mW/cm² 60 s Plus at approx. +23 °C Rel. air humidity: 50 % 168 h</i>	16	
Glass transition temperature <i>DMTA 460 nm 400 mW/cm² 60 s Plus at approx. +23 °C Rel. air humidity: 50 % 168 h</i>	-60	°C
Coefficient of linear expansion <i>DELO Standard 26 TMA Evaluation T: -25 °C - 150 °C 460 nm 400 mW/cm² 60 s Plus at approx. +23 °C Rel. air humidity: 50 % 168 h</i>	265	ppm/K
Shrinkage <i>DELO Standard 13 460 nm 400 mW/cm² 60 s Plus at approx. +23 °C Rel. air humidity: 50 % 168 h</i>	2.3	vol. %
Water absorption <i>by the criteria of DIN EN ISO 62 Layer thickness: 4 mm 460 nm 400 mW/cm² 60 s Plus at approx. +23 °C Rel. air humidity: 50 % 168 h Type of storage: Media Medium: Distilled water Duration: 24 h</i>	1.7	wt. %

Converting table

°F = (°C x 1.8) + 32	1 MPa = 145.04 psi
1 inch = 25.4 mm	1 GPa = 145.04 ksi
1 mil = 25.4 µm	1 cP = 1 mPa·s
1 oz = 28.3495 g	1 N = 0.225 lb

General curing and processing information

The curing time stated in the technical data was determined in the laboratory. It can vary depending on the adhesive quantity and component geometry and is therefore a reference value. Increasing or decreasing the curing temperature and / or irradiation intensity and / or irradiation time shortens or prolongs the curing time and can lead to changed physical properties. A short irradiation time (preactivation time) results in an open time within which opaque components can be joined. The product cures completely after preactivation by humidity at room temperature. Air humidity is mandatory for curing. Suitability must be verified separately for

direct UV loads. All curing or light fixation parameters depend on material thickness and absorption, adhesive layer thickness, lamp type and distance between lamp and adhesive layer. Values measured after 24 h at approx. 23 °C / 50 % r.h., unless otherwise specified.

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. It is the customer's responsibility to test the suitability of a product for the intended purpose by considering all specific requirements and by applying standards the customer deems suitable (e. g. DIN 2304-1). Type, 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.

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Instructions for use

You can find further details in the instructions for use.

The instructions for use are available on www.DELO-adhesives.com.

We will be pleased to send them to you on demand.

Occupational health and safety

See material safety data sheet.

Specification

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CONTACT

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ADHESIVES

DISPENSING

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