

DELO[®] PHOTOBOND[®] 4496

modified acrylate | 1C | UV- / VIS-curing

free of solvents | peel-resistant, thixotropic, unfilled

Special features of product

- compliant with RoHS Directive 2015/863/EU

Function

- sealant

Typical area of use

- 40 - 120 °C

Curing

Suitable lamp types	LED 365 nm, LED 400 nm, UVA	
Typical irradiation time		
<i>intensity 55 - 60 mW/cm² UVA</i>	50	s
<i>intensity 200 mW/cm² LED 400 nm</i>	26	s

Processing

Conditioning time (typical)		
<i>when stored in cold conditions in containers up to 50 ml</i>	30	min
<i>when stored in cold conditions in containers up to 1,000 ml</i>	4	h
Storage life in unopened original container		
<i>at 0 °C to +25 °C</i>	3	month(s)
<i>at 0 °C to +10 °C</i>	6	month(s)

Technical properties

Color in uncured condition	colorless
Color in cured condition in 0.1 mm layer thickness	yellowish

Color in cured condition in 1 mm layer thickness yellowish

Parameters

Density 1.1 g/cm³
liquid

Viscosity 17000 mPa·s
by the criteria of DIN EN 12092 | liquid | Viscosimeter

Viscosity 11000 mPa·s
liquid | Rheometer | Shear rate: 2 1/s | Gap: 500 µm

Compression shear strength 4 MPa
*DELO Standard 5 | **Glass | AI** | 60 mW/cm² | 60 s*

Compression shear strength 6 MPa
*DELO Standard 5 | **Glass | Glass** | 60 mW/cm² | 60 s*

Compression shear strength 5 MPa
*DELO Standard 5 | **Glass | PC** | 60 mW/cm²*

Compression shear strength 5 MPa
*DELO Standard 5 | **PC | AI** | 60 mW/cm² | 60 s*

Compression shear strength 10 MPa
*DELO Standard 5 | **PC | PC** | 60 mW/cm² | 60 s*

Compression shear strength 4 MPa
*DELO Standard 5 | **PMMA | Glass** | 60 mW/cm² | 60 s*

Compression shear strength 3 MPa
*DELO Standard 5 | **PMMA | PMMA** | 60 mW/cm² | 60 s*

Peel resistance 22 N/cm
*DELO Standard 34 | **PC | PC** | 60 mW/cm² | 60 s*

Tensile strength 6 MPa
by the criteria of DIN EN ISO 527 | 60 mW/cm² | 90 s

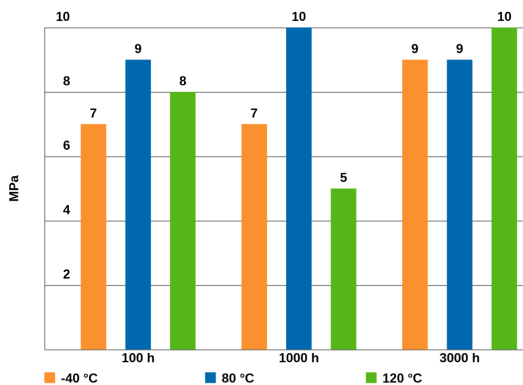
Elongation at tear 300 %
by the criteria of DIN EN ISO 527 | 60 mW/cm² | 90 s

Shore hardness A 35
by the criteria of DIN EN ISO 868 | 60 mW/cm² | 90 s

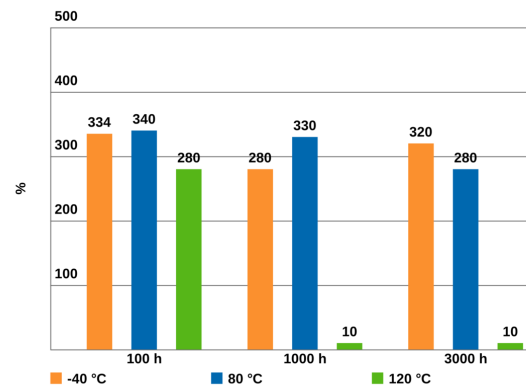
Glass transition temperature 21 °C
DELO Standard 24 | Rheometer

Coefficient of linear expansion <i>TMA Evaluation T: 23 °C - 150 °C</i>	240	ppm/K
Shrinkage <i>DELO Standard 13</i>	6	vol. %
Water absorption <i>by the criteria of DIN EN ISO 62 Type of storage: Media Medium: Distilled water Storage temperature: at approx. +23 °C</i>	0.7	wt. %
Index of refraction <i>Refractometer liquid</i>	1.498	
Decomposition temperature <i>DELO Standard 36</i>	210	°C
Comparative tracking index CTI <i>by the criteria of IEC 112</i>	600	
Relative permittivity <i>by the criteria of RF-IV 1 MHz</i>	4.0	
Relative permittivity <i>by the criteria of RF-IV 1 GHz</i>	3.2	
Relative permittivity <i>by the criteria of RF-IV 10 MHz</i>	4.0	
Relative permittivity <i>by the criteria of RF-IV 100 MHz</i>	3.8	

Tensile strength after thermal storage, based on DIN EN ISO 527



Elongation at tear after thermal storage, based on DIN EN ISO 527



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. 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

DELO Industrial Adhesives
Headquarters

▶ Germany · Windach / Munich ... www.DELO-adhesives.com