DELO® KATIOBOND® 4597
Light-activated adhesive, high-viscous

**Base**
- modified epoxy resin
- one-component, solvent-free, light-activated, thixotropic

**Use**
- especially for tough-hard bondings and sealings
- for the bonding of metal, glass, plastic and other materials as well as for the coating, fixing or sealing of electronic components
- also suitable for the bonding of opaque components through preactivation
- the cured product is normally used in a temperature range of -40 °C to +150 °C; depending on the application, other limits may be more reasonable
- positively tested according to UL 94 HB
- compliant with RoHS directive 2015/863/EU

**Processing**
- the product is supplied ready for use; in case of cool storage, it must be ensured that the container is conditioned to room temperature before use
- the containers are conditioned at room temperature (max. 25 °C); additional heat addition is not allowed
- the adhesive is usually applied by dispensing
- the adhesive 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
- when using aqueous cleaners with alkaline properties, they must be removed from the bonding surface after cleaning through appropriate rinsing cycles
- dispensing valves and product-bearing elements must be carefully cleaned before use, residues of other products must be completely removed; acetone or DELOTHEN EP are recommended as cleaners
- for further information please refer to our instructions for use DELO KATIOBOND.
Curing
- curing with UV light or visible light in a wavelength range of 320 – 550 nm. DELOLUX LED curing lamps are especially suitable as per the chart below. All standard DELOLUX HID discharge lamps are also suitable. For preactivation, only visible light in a wavelength range of 400 – 550 nm can be used.
- the cationic curing mechanism enables adhesive curing after the joining of opaque components after sufficient irradiation
- after irradiation curing until final strength within 24 h at room temperature
- increased temperatures accelerate the reaction, lower temperature decelerate it
- increased intensities shorten the required irradiation time, lower intensities prolong it

<table>
<thead>
<tr>
<th>Lamp type</th>
<th>DELOLUX 20 / 50 / 80</th>
</tr>
</thead>
<tbody>
<tr>
<td>Wavelength [nm]</td>
<td>365</td>
</tr>
<tr>
<td>Suitability</td>
<td>+ *)</td>
</tr>
</tbody>
</table>

- not suitable   + suitable   ++ especially suitable
*) suitable only in case of direct irradiation, preactivation not possible

Absorption spectrum
- photoinitiation system in epoxy resin basic matrix

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

Technical data

<table>
<thead>
<tr>
<th>Color</th>
<th>brown milky</th>
</tr>
</thead>
<tbody>
<tr>
<td>cured in a layer thickness of approx. 0.1 mm</td>
<td></td>
</tr>
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Density [g/cm³]
DELO Standard 13
at room temperature (approx. 23 °C)

1.1

Viscosity [mPas]
at 23 °C, Brookfield spindle/rpm 7/5

48000

Thixotropy index
3

Preactivation time [s]
DELO Standard 19
DELOLUX 03 S, UVA intensity: 55 - 60 mW/cm² DELOLUXcontrol

6

Open time after preactivation [s]
DELO Standard 19
at room temperature (approx. 23 °C) and normal room lighting

16
Minimal irradiation time [s]  
DELO Standard 37, DSC  
UVA intensity: 55 - 60 mW/cm² DELOLUXcontrol, at 30 °C  

Recommended irradiation time [s]  
UVA-intensity: 55 - 60 mW/cm² DELOLUXcontrol  

Minimal irradiation time [s]  
DELO Standard 37, DSC  
LED 460 nm, intensity: 200 mW/cm²; DELOLUXcontrol, at 30 °C  

Recommended irradiation time [s]  
LED 460nm, intensity: 200 mW/cm² DELOLUXcontrol  

Curing time until final strength [h]  
at room temperature (approx. 23 °C) after irradiation  

Compression shear strength glass/glass [MPa]  
DELO Standard 5  
UVA intensity: 55 - 60 mW/cm², DELOLUXcontrol, irradiation time: 60 s  
curing time: 24 h at room temperature (approx. 23 °C)  

Compression shear strength glass/Al [MPa]  
DELO Standard 5  
UVA intensity: 55 - 60 mW/cm², DELOLUXcontrol, irradiation time: 60 s  
curing time: 24 h at room temperature (approx. 23 °C)  

Compression shear strength glass/FR4 [MPa]  
DELO Standard 5  
UVA intensity: 55 - 60 mW/cm², DELOLUXcontrol, irradiation time: 60 s  
curing time: 24 h at room temperature (approx. 23 °C)  

Compression shear strength PC/Al [MPa]  
DELO Standard 5  
UVA intensity: 55 - 60 mW/cm², DELOLUXcontrol, irradiation time: 60 s  
curing time: 24 h at room temperature (approx. 23 °C)  

Compression shear strength PC/PC [MPa]  
DELO Standard 5  
UVA intensity: 55 - 60 mW/cm², DELOLUXcontrol, irradiation time: 60 s  
curing time: 24 h at room temperature (approx. 23 °C)  

Compression shear strength PMMA/PMMA [MPa]  
DELO Standard 5  
UVA intensity: 55 - 60 mW/cm², DELOLUXcontrol, irradiation time: 60 s  
curing: 24 h at room temperature (approx. 23 °C)  

Compression shear strength PBT/PBT [MPa]  
DELO Standard 5  
UVA intensity: 55 - 60 mW/cm² DELOLUXcontrol, at optimal preactivation time  
curing time: 24 h at room temperature (approx. 23 °C)  

Tensile strength [MPa]  
DIN EN ISO 527  

Elongation at tear [%]  
DIN EN ISO 527  

Shore hardness D  
according to DIN EN ISO 868  

Decomposition temperature [°C]  
DELO Standard 36  

Glass transition temperature [°C]  
rheometer
Coefficient of linear expansion [ppm/K] 180
TMA, in a temperature range of +30 to +150 °C

Shrinkage [vol. %] 2.9
DELO Standard 13

Water absorption [weight %] 1.1
according to DIN EN ISO 62, 24 h at room temperature (approx. 23 °C)

Specific volume resistance [Ωcm] >1xE10
VDE 0303, part 3

Surface resistance [Ω] >1xE10
VDE 0303, part 3

Dielectric strength [kV/mm] 13
VDE 0303, part 2

Dielectric constant 4.9
RF-IV method, 1 MHz, at 25 °C +/- 3 °C

Dielectric constant 4.8
RF-IV method, 10 MHz, at 25 °C +/- 3 °C

Dielectric constant 4.3
RF-IV method, 100 MHz, at 25 °C +/- 3 °C

Dielectric constant 3.6
RF-IV method, 1 GHz, at 25 °C +/- 3 °C

Creep resistance CTI 600 M
VDE 0303, part 1, IEC 112

Storage life at room temperature (0 °C to +25 °C) 6 months
in unopened original container
Performance under temperature influence

Compression/shear strength glass/glass after temperature storage based on initial value at room temperature measured at room temperature (approx. 23 °C) according to DELO standard 5.

Young’s modulus after temperature storage based on initial value at room temperature measured at room temperature (approx. 23 °C) according to DIN EN ISO 527, test specimen type 1B, thickness 2 mm.

tensile strength after temperature storage based on initial value at room temperature measured at room temperature (approx. 23 °C) according to DIN EN ISO 527, test specimen type 1B, thickness 2 mm.

Elongation at tear after temperature storage based on absolute initial value at room temperature measured at room temperature (approx. 23 °C) according to DIN EN ISO 527, test specimen type 1B, thickness 2 mm.
Performance under chemical influence
compression shear strength after storage for 1,000 h
based on initial value at room temperature
measured at room temperature (approx. 23 °C)
according to DELO Standard 5

<table>
<thead>
<tr>
<th>Chemical medium</th>
<th>Compression/shear strength glass/Al [%]</th>
</tr>
</thead>
<tbody>
<tr>
<td>acetone</td>
<td>83</td>
</tr>
<tr>
<td>ethanol denatured</td>
<td>97</td>
</tr>
<tr>
<td>ATF gear oil</td>
<td>106</td>
</tr>
<tr>
<td>petrol</td>
<td>92</td>
</tr>
<tr>
<td>diesel fuel</td>
<td>80</td>
</tr>
<tr>
<td>engine oil 10W40</td>
<td>129</td>
</tr>
<tr>
<td>demineralised water / glykol mixture 50:50</td>
<td>74</td>
</tr>
</tbody>
</table>

**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. 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.

Nothing contained herein shall be construed to indicate the non-existence of any relevant patents or to constitute a permission, encouragement or recommendation to practice any development covered by any patents, without permission of the owner of this patent.

All products provided by DELO are subject to DELO's General Terms of Business. Verbal ancillary agreements are deemed not to exist.

**Instructions for use**
The instructions for use of DELO KATIOBOND 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**
The properties in italics are part of the specification. Ranges with clear limits are defined for them and others, where applicable. In the course of the QA test, each batch is tested for these properties and the maintenance of the limits is ensured. The measuring methods used can deviate from those specified in the data sheet. Details can be found in the QA test report.