**DELO® PHOTOBOND® AD485**

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

thixotropic, unfilled

### Special features of product
- compliant with RoHS Directive 2015/863/EU

### Typical area of use
- -40 - 120 °C

#### Curing

<table>
<thead>
<tr>
<th>Suitable lamp types</th>
<th>LED 365 nm, LED 400 nm, UVA</th>
</tr>
</thead>
</table>

<table>
<thead>
<tr>
<th>Typical irradiation time</th>
<th>7 s</th>
</tr>
</thead>
<tbody>
<tr>
<td><em>intensity</em> 55 - 60 mW/cm²</td>
<td>UVA</td>
</tr>
</tbody>
</table>

#### Processing

Storage life in unopened original container

<table>
<thead>
<tr>
<th>at 0 °C to +25 °C</th>
<th>6 month(s)</th>
</tr>
</thead>
</table>

#### Technical properties

- **Color in uncured condition**: red
- **Transparency**: translucent
- **Color in cured condition in 0.1 mm layer thickness**: red
- **Color in cured condition in 1 mm layer thickness**: red
- **Fluorescence**: red fluorescent

#### Parameters

- **Density**
  - liquid: 1.1 g/cm³
- **Viscosity**
  - Based on DIN EN 12092 | liquid | Viscosimeter: 80000 mPa·s
<table>
<thead>
<tr>
<th>Property</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Minimum irradiation time</td>
<td>7 s</td>
</tr>
<tr>
<td>Compression shear strength</td>
<td>2 MPa</td>
</tr>
<tr>
<td>Compression shear strength</td>
<td>3 MPa</td>
</tr>
<tr>
<td>Compression shear strength</td>
<td>2 MPa</td>
</tr>
<tr>
<td>Compression shear strength</td>
<td>1 MPa</td>
</tr>
<tr>
<td>Compression shear strength</td>
<td>2 MPa</td>
</tr>
<tr>
<td>Compression shear strength</td>
<td>3 MPa</td>
</tr>
<tr>
<td>Compression shear strength</td>
<td>3 MPa</td>
</tr>
<tr>
<td>Peel resistance</td>
<td>5 N/cm</td>
</tr>
<tr>
<td>Peel resistance</td>
<td>9 N/cm</td>
</tr>
<tr>
<td>Tensile strength</td>
<td>1 MPa</td>
</tr>
<tr>
<td>Elongation at tear</td>
<td>230 %</td>
</tr>
<tr>
<td>Shore hardness A</td>
<td>18</td>
</tr>
<tr>
<td>Glass transition temperature</td>
<td>-16 °C</td>
</tr>
<tr>
<td>Shrinkage</td>
<td>4 vol. %</td>
</tr>
</tbody>
</table>

**DELO Standard 23 | Rheometer | 60 mW/cm²**

**DELO Standard 5 | Glass | Glass | 60 mW/cm² | 60 s**

**DELO Standard 5 | PC | PC | 60 mW/cm² | 60 s**

**DELO Standard 5 | Glass | Al | 60 mW/cm² | 60 s**

**DELO Standard 5 | Glass | PA6 | 60 mW/cm² | 60 s**

**DELO Standard 5 | Glass | PBT | 60 mW/cm² | 60 s**

**DELO Standard 5 | Glass | FR4 | 60 mW/cm² | 60 s**

**DELO Standard 5 | PMMA | PMMA | 60 mW/cm² | 60 s**

**DELO Standard 34 | PET | PET | 60 mW/cm²**

**DELO Standard 34 | PEI | PEI | 60 mW/cm²**

**Based on DIN EN ISO 527 | 60 mW/cm² | 90 s**

**Based on DIN EN ISO 527 | 60 mW/cm² | 90 s**

**Based on DIN EN ISO 868 | 60 mW/cm² | 90 s**
Water absorption

Based on DIN EN ISO 62 / 60 mW/cm² / 90 s / Type of storage: Media / Medium: Distilled water
Storage temperature: at approx. +23 °C

1.3 wt. %

Converting table

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