

DELO® PHOTOBOND® DM4084

UV- and light curing acrylate adhesive, high viscosity

Base

- modified acrylate
- one-component, solvent-free, thixotropic

Use

- damping glue for mini loudspeakers
- fast curing
- very soft adhesive
- UV- and light-curing: can be cured through UV-blocking foils
- the cured product is normally used in a temperature range of -40 °C to +130 °C; depending on the application, other limits may be more reasonable
- compliant with RoHS directive 2015/863/EU

Processing

- supplied ready for use
- the surfaces to be bonded must be dry as well as free of dust, grease and other contaminations
- use Isopropanol for the cleaning of glass
- for further information please refer to the instructions for use

Curing

- with visible light or UV light in a wavelength range of 320 - 450 nm
- to achieve a dry adhesive surface very fast, a suitable lamp must be used and the UV intensity must be high enough

Curing parameters

Lamp type	DELOLUX 20 / 50 / 80		
Wavelength [nm]	365	400	460
Suitability	+	++	-

- not suitable + suitable ++ especially suitable

Technical data

Color

cured in a layer thickness of approx. 0.1 mm

red fluorescent

Density [g/cm³]

DELO Standard 13
at room temperature (approx. +23 °C)

1.03

Viscosity [mPas]

at 23 °C, rheometer, 2 1/s

38000

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Minimal curing time [s] DELO Standard 23, LED 400nm, intensity: 200 mW/cm ² , DELOLUXcontrol	3
Shore hardness 00 based on ASTM D2240	50
Glass transition temperature [°C] DMTA	-55
Storage life at room temperature (0 °C to +25 °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. 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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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 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

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.