**DELO® PHOTOBOND® LA4860**

Modified urethan polymer
light-activated moisture curing

**Base**
one component, solvent free, thixotropic

**Use**
- also suitable for the bonding of opaque components through preactivation
- for flat or bead-shaped bonding applications or sealings. For example flacon- / instrument panel- or display bonding.
- the cured product is normally used in a temperature range of -40 °C to +110 °C; depending on the application, other limits may be more reasonable
- due to its fluorescence, the product is suitable where application control is necessary
- compliant with RoHS directive 2015/863/EU

**Processing**
- the adhesive 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 (+18 °C to +25 °C); the conditioning time is approx. 0.5 h for containers up to 50 ml and approx. 4 h for containers up to 1,000 ml; additional heat addition is not allowed
- the adhesive can be applied by dispensing
- the surfaces to be bonded must be dry as well as free of dust, grease and other contaminations
- dispensing valves and product-bearing elements must be carefully cleaned before use, residues of other products must be completely removed; Isopropanol is recommended to remove DELO PHOTOBOND residues

**Curing**
- for curing a humidity access is essential
- curing only after activation with light in a wavelength range of 360-460 nm
- short exposure times create an open time, so opaque parts can be joined
- after light activation, the product cures completely at room temperature due to moisture

**Technical data**

<table>
<thead>
<tr>
<th>Color</th>
<th>colorless fluorescent</th>
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<tr>
<td>uncured</td>
<td>yellowish fluorescent</td>
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DELO PHOTOBOND LA4860 - 06.19 (Revision 28)
Density [g/cm³]
at room temperature (approx. 23 °C)
1.15

Viscosity [mPas]
at 23°C, rheometer, PP20, gap 500µm, shear rate 2/s
70000

Processing time
at room temperature (approx. 23 °C)
4 weeks

Recommended preactivation time [s]
LED 400nm, intensity: 200 mW/cm², DELOLUXcontrol
500µm layer thickness
4

Open time after preactivation [s]
DELO Standard 19
at standard conditions (23 °C/50 %relative humidity) and normal room lighting
23

Compression shear strength glass/glass [MPa]
DELO-Norm 5
LED intensity: 400 nm, 200mW/cm², DELOLUXcontrol, preactivation time: 4 s
72h at 23°C/50% relative humidity
2

Compression shear strength glass/PC [MPa]
DELO-Norm 5
LED intensity: 400 nm, 200mW/cm², DELOLUXcontrol, preactivation time: 4 s
72h at 23°C/50% relative humidity
3

Compression shear strength glass/PMMA [MPa]
DELO-Norm 5
LED intensity: 400 nm, 200mW/cm², DELOLUXcontrol, preactivation time: 4 s
72h at 23°C/50% relative humidity
1

Compression shear strength PMMA/ABS [MPa]
DELO-Norm 5
LED intensity: 400 nm, 200mW/cm², DELOLUXcontrol, preactivation time: 4 s
72h at 23°C/50% relative humidity
1

Compression shear strength PC/ABS [MPa]
DELO-Norm 5
LED intensity: 400 nm, 200mW/cm², DELOLUXcontrol, preactivation time: 4 s
72h at 23°C/50% relative humidity
2

Compression shear strength PC-ABS/PC-ABS [MPa]
DELO-Norm 5
LED intensity: 400 nm, 200mW/cm², DELOLUXcontrol, preactivation time: 4 s
72h at 23°C/50% relative humidity
1

Compression shear strength PC/PC [MPa]
DELO-Norm 5
LED intensity: 400 nm, 200mW/cm², DELOLUXcontrol, preactivation time: 4 s
72h at 23°C/50% relative humidity
1

Compression shear strength Al/Al [MPa]
DELO-Norm 5
LED intensity: 400 nm, 200mW/cm², DELOLUXcontrol, preactivation time: 4 s
72h at 23°C/50% relative humidity
2

Tensile strength [MPa]
DIN EN ISO 527
LED 400 nm, intensity: 200 mW/cm², DELOLUXcontrol
curing time: 7 d at 23 °C / 50 % relative humidity
1
Elongation at tear [%]
DIN EN ISO 527
LED 400 nm, intensity: 200 mW/cm², DELOLUXcontrol
curing time: 7 d at 23 °C / 50 % relative humidity
350

Young's modulus [MPa]
DIN EN ISO 527
LED 400 nm, intensity: 200 mW/cm², DELOLUXcontrol
curing time: 7 d at 23 °C / 50 % relative humidity
<100

Shore hardness A
according to DIN EN ISO 868
10

Glass transition temperature [°C]
DMTA tension, 1Hz
-64

Shrinkage [vol. %]
DELO Standard 13
3

Water absorption [weight %]
according to DIN EN ISO 62, 24 h at room temperature (approx. 23 °C)
0.7

Storage life
at 0 °C to +10 °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.

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 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.