

### **DELO-DUALBOND® AD4950**

light and humidity-curing acrylate adhesive, medium viscosity

#### **Base**

- modified acrylate
- one-component, solvent-free

#### **Use**

- multi-purpose for plastic/plastic, glass/plastic, metal/plastic, glass/glass and glass/metal bondings
- tension-equalizing thanks to high elongation at tear
- the product is normally used in a temperature range of -40 °C to +120 °C; depending on the application, other limits may be more reasonable
- compliant with RoHS directive 2002/95/EC

#### **Processing**

- supplied ready for use and 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
- use DELOTHEN EP cleaner for the cleaning of glass
- for further information please refer to the instructions for use

#### **Curing**

- with UV light or visible light in a wavelength range of 320 - 450 nm and by humidity in shadow zones
- humidity curing starts at the surface of the acrylate; a skin is formed after a few hours; deep curing of the acrylate proceeds with approx. 2mm/24h

#### **Curing parameters**

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

#### **Technical data**

Color uncured in 0.1 mm layer thickness	colorless
Density [g/cm <sup>3</sup> ] DELO standard 13	1.0
Viscosity [mPas] at 23 °C, Brookfield spm 3/10	36000
Minimal curing time [s] DELO Standard 23, UVA intensity: 60 mW/cm <sup>2</sup> , DELOLUXcontrol	10

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<b>Compression shear strength glass/glass [MPa]</b> DELO Standard 5 UVA intensity: 55 - 60 mW/cm <sup>2</sup> , DELOLUXcontrol, irradiation time: 60 s	9
<b>Compression shear strength glass/Al [MPa]</b> DELO Standard 5 UVA intensity: 55 - 60 mW/cm <sup>2</sup> , DELOLUXcontrol, irradiation time: 60 s	6
<b>Compression shear strength glass/PA [MPa]</b> DELO Standard 5 UVA intensity: 55 - 60 mW/cm <sup>2</sup> , DELOLUXcontrol, irradiation time: 60 s	8
<b>Compression shear strength glass/PBT [MPa]</b> DELO Standard 5 UVA intensity: 55 - 60 mW/cm <sup>2</sup> ; DELOLUXcontrol, irradiation time: 60 s	4
<b>Compression shear strength glass/FR4 [MPa]</b> DELO Standard 5 UVA intensity: 55 - 60 mW/cm <sup>2</sup> , DELOLUXcontrol, irradiation time: 60 s	11
<b>Compression shear strength PMMA/PMMA [MPa]</b> DELO Standard 5 UVA intensity: 55 - 60 mW/cm <sup>2</sup> , DELOLUXcontrol, irradiation time: 60 s	8
<b>Young's modulus [MPa]</b> DIN EN ISO 527	45
<b>Tensile strength [MPa]</b> DIN EN ISO 527	8
<b>Elongation at tear [%]</b> DIN EN ISO 527	270
<b>Shore hardness A</b> according to DIN EN ISO 868	77
<b>Glass transition temperature [°C]</b> DELO Standard 24	70
<b>Shrinkage [%]</b> DELO Standard 13	4.6
<b>Water absorption [weight %]</b> DIN EN ISO 62	2.5
<b>Storage life</b> at +5 °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.

Many product properties are subject to temperature and may change permanently, especially at high temperatures.

It is the user's responsibility to test the suitability of the product for the intended purpose and temperature range of use by considering all specific requirements. Type and 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.

### **Instructions for use**

The instructions for use of DELO-DUALBOND are available on: [www.DELO.de](http://www.DELO.de). We will be pleased to send them to you on demand.

### **Occupational health and safety**

see material safety data sheet

### **Specification**

see quality assurance test report