

DELO-DUALBOND® GE4910

light and humidity-curing acrylate adhesive, low viscosity

Base

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

Use

- for casting application
- good adhesion to a variety of plastics
- flexible

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 cured in a layer thickness of approx. 0.1 mm	colorless transparent
Density [g/cm ³] DELO standard 13	1.0
Viscosity [mPas] at 23 °C, Brookfield spm 3/10	2000
Minimal curing time [s] DELO Standard 23, UVA intensity: 60 mW/cm ² , DELOLUXcontrol	10
Compression shear strength glass/glass [MPa] DELO Standard 5 UVA intensity: 55 - 60 mW/cm ² , DELOLUXcontrol, irradiation time: 60 s	7

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Compression shear strength glass/Al [MPa] DELO Standard 5 UVA intensity: 55 - 60 mW/cm ² , DELOLUXcontrol, irradiation time: 60 s	6
Compression shear strength glass/PA [MPa] DELO Standard 5 UVA intensity: 55 - 60 mW/cm ² , DELOLUXcontrol, irradiation time: 60 s	6
Compression shear strength glass/PBT [MPa] DELO Standard 5 UVA intensity: 55 - 60 mW/cm ² ; DELOLUXcontrol, irradiation time: 60 s	2
Compression shear strength glass/FR4 [MPa] DELO Standard 5 UVA intensity: 55 - 60 mW/cm ² , DELOLUXcontrol, irradiation time: 60 s	9
Young's modulus [MPa] DIN EN ISO 527	17
Tensile strength [MPa] DIN EN ISO 527	6
Elongation at tear [%] DIN EN ISO 527	315
Shore hardness A according to DIN EN ISO 868	62
Glass transition temperature [°C] DELO Standard 24	70
Water absorption [weight %] DIN EN ISO 62	1.3
Storage life at approx. +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. 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