

### **DELO-PHOTOBOND® 400**

#### **Base**

- modified acrylate
- one-component, solvent-free

#### **Use**

- glass/glass, glass/metal, glass/plastic and plastic/plastic bondings
- dry surface
- compliant with RoHS directive 2011/65/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 totally be completely removed; DELOTHEN EP as well as acetone, isopropanol or a mixture of both are recommended to remove DELO-PHOTOBOND residues
- for further information please refer to our instructions for use DELO-PHOTOBOND and the brochure "Light Curing"

#### **Curing**

- with visible light in a wavelength range of 400 - 500 nm

#### **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 clear

##### *Density [g/cm<sup>3</sup>]*

at room temperature (approx. 23 °C)

1.1

##### *Viscosity [mPas]*

at 23 °C

3500

##### *Minimal curing time [s]*

DELO Standard 23, UVA intensity: 60 mW/cm<sup>2</sup>, DELOLUXcontrol

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<i>Compression shear strength glass/glass [MPa]</i> DELO Standard 5	13
Compression shear strength glass/Al [MPa] DELO Standard 5	10
Tensile strength [MPa] DIN EN ISO 527	46
Elongation at tear [%] DIN EN ISO 527	4.5
Young's modulus [MPa] DIN EN ISO 527	2000
Shore hardness D according to DIN EN ISO 868	72
Shrinkage [vol. %] DELO Standard 13	3.3
Chemical resistance	good
Index of refraction cured product	1.569
Specific volume resistance [ $\Omega\text{cm}$ ] VDE 0303, part 3	$>1 \times 10^{13}$
Surface resistance [ $\Omega\text{cm}$ ] VDE 0303, part 3	$>1 \times 10^{13}$
Dielectric strength [kV/mm] VDE 0303, part 2	11
Dielectric constant VDE 0303, part 4	2.6
Storage life at room temperature (0 °C to +25 °C) in unopened original container	12 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. Verbal ancillary agreements are deemed not to exist.

### **Instructions for use**

The instructions for use of DELO-PHOTOBOND 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**

Irritating to eyes, respiratory system and skin. In case of contact with eyes, immediately rinse with plenty of water and consult physician. On contact with skin, immediately wash off with plenty of soap and water. For further details 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.