

### DELO-PHOTOBOND® 4468

UV- and light curing acrylate adhesive, medium viscosity

#### Base

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

#### Use

- optimized for high force transduction in interior glass/glass or glass/metal bonds, e. g., bonding of hinges to glass doors
- long lifetime due to high humidity resistance, important for applications in the sanitary sector
- tested for biocompatibility and meets the requirements according to USP 23, 1995, for Class VI Plastics -70 °C
- the cured 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 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; 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

- curing with UV light or visible light in a wavelength range from 320 to 450 nm. DELOLUX LED curing lamps are especially suitable as per the chart below. All standard DELOLUX HID discharge lamps are also suitable
- increased intensities shorten the required irradiation time, lower intensities prolong it

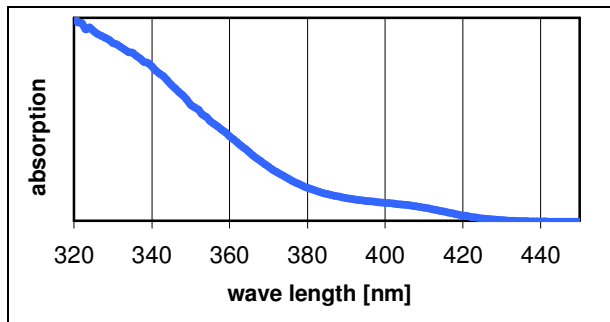
Lamp type	DELOLUX 20 / 50 / 80		
Wavelength [nm]	365	400	460
Suitability	+	++	-

- not suitable + suitable ++ especially suitable

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## **Absorption spectrum**

photoinitiation system in acrylate matrix



## **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

### **Light fastness**

after exposure to UV light in sunlight simulator  
DELO Standard 25

duration of exposure in sunlight simulator	chromaticity coordinate of the L,a,b-color-space
0 h	2,7
500h	2,6
1000 h	2,7

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

at room temperature (approx. 23 °C)

1.0

### **Viscosity [mPas]**

at 23 °C, Brookfield rpm 4/5

7000

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

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

40

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

DELO Standard 23, LED 400nm, intensity: 200 mW/cm<sup>2</sup>, DELOLUXcontrol

24

### **Surface**

tacky

### **Compression shear strength glass/glass [MPa]**

DELO Standard 5

UVA intensity: 55 - 60 mW/cm<sup>2</sup>, DELOLUXcontrol, irradiation time: 60 s

22

### **Compression shear strength glass/Al [MPa]**

DELO Standard 5

UVA intensity: 55 - 60 mW/cm<sup>2</sup>, DELOLUXcontrol, irradiation time: 60 s

24

### **Compression shear strength glass/VA [MPa]**

DELO Standard 5

UVA intensity: 55 - 60 mW/cm<sup>2</sup>, DELOLUXcontrol, irradiation time: 60 s

20

### **Compression shear strength glass/PC [MPa]**

DELO Standard 5

UVA intensity: 55 - 60 mW/cm<sup>2</sup>, DELOLUXcontrol, irradiation time: 60 s

3

### **Compression shear strength glass/PMMA [MPa]**

DELO Standard 5

UVA intensity: 55 - 60 mW/cm<sup>2</sup>, DELOLUXcontrol, irradiation time: 60 s

3

Compression shear strength PC/Al [MPa] 3

DELO Standard 5  
UVA intensity: 55 - 60 mW/cm<sup>2</sup>, DELOLUXcontrol, irradiation time: 60 s

Compression shear strength PMMA/PMMA [MPa] 3

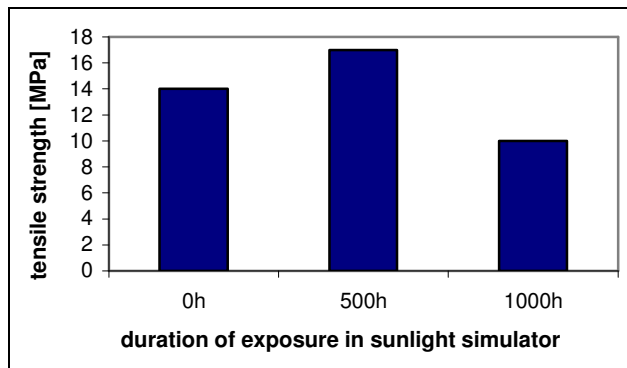
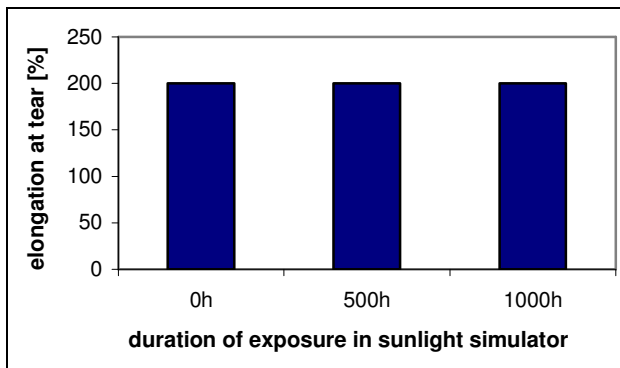
DELO Standard 5  
UVA intensity: 55 - 60 mW/cm<sup>2</sup>, DELOLUXcontrol, irradiation time: 60 s

Tensile strength [MPa] 14  
DIN EN ISO 527

Elongation at tear [%] 200  
DIN EN ISO 527

Young's modulus [MPa] 250  
DIN EN ISO 527

**Material properties**  
after exposure to UV light in a sunlight simulator



Shore hardness A 83  
according to DIN EN ISO 868

Shore hardness D 45  
according to DIN EN ISO 868

Decomposition temperature [°C] 195  
DELO Standard 36

Glass transition temperature [°C] 74  
rheometer

Coefficient of linear expansion [ppm/K] 216  
in a temperature range of +25 to +140 °C

Shrinkage [vol. %] 9  
DELO Standard 13

Water absorption [weight %] 0.9  
according to DIN EN ISO 62, 24 h at room temperature (approx. 23 °C)

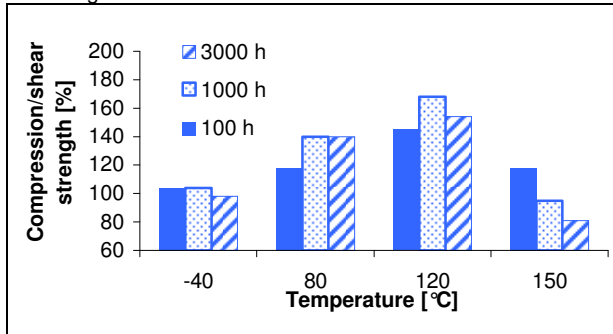
Index of refraction 1.5

Creep resistance CTI 600 M  
VDE 0303, part 1, IEC 112

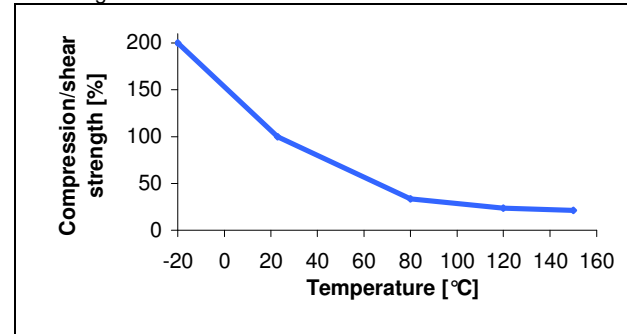
Storage life 6 months  
at room temperature (0 °C to +25 °C) in unopened original container

## Performance under temperature influence

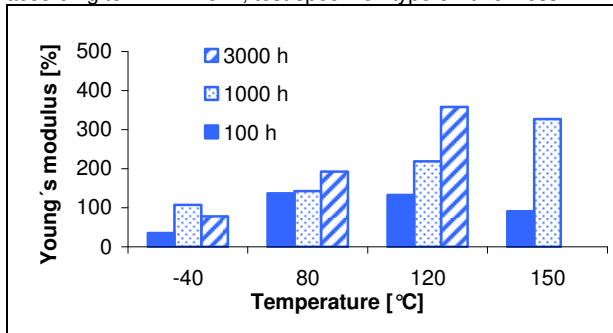
compression/shear strength glass/glass after temperature storage based on initial value at room temperature measured at room temperature (approx. 23 °C) according to DELO standard 5



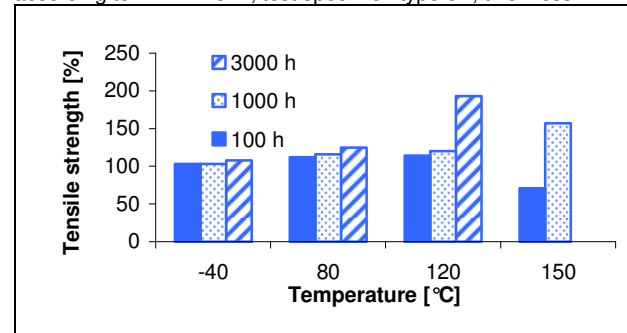
compression/shear strength glass/glass at temperature based on initial value at room temperature measured at determined temperature according to DELO standard



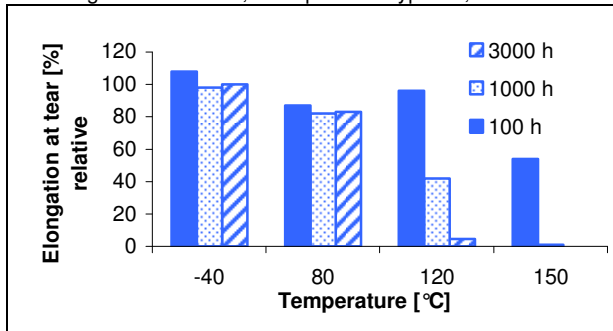
Young's modulus after temperature storage based on initial value at room temperature measured at room temperature (approx. 23 °C) according to DIN EN 527, test specimen type 5A thickness 2 mm



tensile strength after temperature storage based on initial value at room temperature measured at room temperature (approx. 23 °C) according to DIN EN 527, test specimen type 5A, thickness 2 mm



elongation at tear after temperature storage based on absolute initial value at room temperature measured at room temperature (approx. 23 °C) according to DIN EN 527, test specimen type 5A, thickness 2 mm



## Performance under chemical influence

compression shear strength after storage for 1,000 h based on initial value at room temperature measured at room temperature (approx. 23 °C) according to DELO Standard 5

Chemical medium	Compression/shear strength glass/Al [%]
ATF gear oil	80
Demineralised water/ glykol mixture 50:50	76
engine oil 10W40	85

## **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 the product for the intended purpose 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. The data and information provided are therefore no guarantee for specific product properties or the suitability of the product for the intended 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 DELOs' General Terms of Business. Verbal side agreements are not permitted. This document is subject to change.

### **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**

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.