

DELO PHOTOBOND AD494

modified acrylate | 1C | UV- / VIS-curing

thixotropic | tension-equalizing

Special features of product

- compliant with RoHS Directive 2015/863/EU

Typical area of use

- 40 - 120 °C

Curing

Suitable lamp types	LED 365 nm, LED 400 nm, UVA
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Recommended irradiation time

<i>intensity 200 mW/cm²</i> <i>LED 400 nm</i>	9	s
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<i>intensity 55 - 60 mW/cm²</i> <i>UVA</i>	14	s
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Processing

Adhesive application	needle-dispensable
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Storage life in unopened original container

<i>at 0 °C to +25 °C</i>	6	month(s)
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Technical properties

Color in uncured condition	colorless
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Color in cured condition in 0.1 mm layer thickness	colorless
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Color in cured condition in 1 mm layer thickness	colorless
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Density	1.1	g/cm ³
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Parameters

Viscosity	32000	mPa·s
<i>Liquid Rheometer Shear rate: 2 1/s Gap: 500 µm</i>		

Viscosity <i>Liquid Viscosimeter</i>	50000	mPa·s
Minimum irradiation time <i>DELO Standard 23 Rheometer 400 nm 200 mW/cm²</i>	10	s
Minimum irradiation time <i>DELO Standard 23 Rheometer 60 mW/cm²</i>	14	s
Compression shear strength <i>DELO Standard 5 PC Al 60 mW/cm² 60 s Type of storage: Temp. Duration: 3 h</i>	8	MPa
Compression shear strength <i>DELO Standard 5 PC ABS 60 mW/cm² 60 s Type of storage: Temp. Duration: 3 h</i>	14	MPa
Compression shear strength <i>DELO Standard 5 PS PS 60 mW/cm² 60 s Type of storage: Temp. Duration: 3 h</i>	10	MPa
Compression shear strength <i>DELO Standard 5 PMMA Glass 60 mW/cm² 60 s Type of storage: Temp. Duration: 3 h</i>	11	MPa
Compression shear strength <i>DELO Standard 5 PC PC 60 mW/cm² 60 s Type of storage: Temp. Duration: 3 h</i>	18	MPa
Compression shear strength <i>DELO Standard 5 PC PA6 60 mW/cm² 60 s Type of storage: Temp. Duration: 3 h</i>	10	MPa
Compression shear strength <i>DELO Standard 5 PC Glass 60 mW/cm² 60 s Type of storage: Temp. Duration: 3 h</i>	12	MPa
Compression shear strength <i>DELO Standard 5 Glass Stainless steel 60 mW/cm² 60 s Type of storage: Temp.</i>	13	MPa
Compression shear strength <i>DELO Standard 5 Glass Glass 60 mW/cm² 60 s Type of storage: Temp.</i>	13	MPa
Compression shear strength <i>DELO Standard 5 Glass Al 60 mW/cm² 60 s Type of storage: Temp.</i>	12	MPa
Compression shear strength <i>DELO Standard 5 FR4 PA6 60 mW/cm² 60 s Type of storage: Temp. Duration: 3 h</i>	9	MPa
Tensile strength <i>Based on DIN EN ISO 527 60 mW/cm² 90 s Plus 60 mW/cm² 90 s Type of storage: Temp. Duration: 24 h</i>	13	MPa

Elongation at tear <i>Based on DIN EN ISO 527 60 mW/cm² 90 s Plus 60 mW/cm² 90 s Type of storage: Temp. Duration: 24 h</i>	310	%
Young's modulus <i>DMTA [Wavelength]: nm [Intensity]: mW/cm² [Irradiation time]: s</i>	340	MPa
Young's modulus <i>Based on DIN EN ISO 527 60 mW/cm² 90 s Plus 60 mW/cm² 90 s Type of storage: Temp. Duration: 24 h</i>	31	MPa
Shore hardness A <i>Based on DIN EN ISO 868</i>	82	
Shore hardness D <i>Based on DIN EN ISO 868</i>	25	
Glass transition temperature <i>DELO Standard 24 Rheometer</i>	48	°C
Shrinkage <i>DELO Standard 13</i>	6.8	vol. %
Water absorption <i>Based on DIN EN ISO 62 Type of storage: Media Medium: Distilled water Temp.: at approx. +23 °C</i>	3	wt. %
Decomposition temperature <i>DELO Standard 36</i>	225	°C

Converting table

°F = (°C x 1.8) + 32	1 MPa = 145.04 psi
1 inch = 25.4 mm	1 GPa = 145.04 ksi
1 mil = 25.4 µm	1 cP = 1 mPa·s
1 oz = 28.3495 g	1 N = 0.225 lb

General curing and processing information

The curing time stated in the technical data was determined in the laboratory. It can vary depending on the adhesive quantity and component geometry and is therefore a reference value. Increasing or decreasing the curing temperature and / or irradiation intensity shortens or prolongs the curing time and can lead to changed physical properties. All curing or light fixation parameters depend on material thickness and absorption, adhesive layer thickness, lamp type and distance between lamp and adhesive layer. Values measured after 24 h at approx. 23 °C / 50 % r.h., unless otherwise specified.

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.

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Instructions for use

The instructions for use are available on www.DELO-adhesives.com.

We will be pleased to send them to you on demand.

Occupational health and safety

See material safety data sheet.

Specification

Nothing contained in this Technical Datasheet shall be interpreted as any express warranty or guarantee. This Technical Datasheet is for reference only and does not constitute a product specification. Please ask our responsible Sales Engineer for the applicable product specification which includes defined ranges. DELO is neither liable for any values and content of this Technical Datasheet nor for oral or written recommendations regarding the use, unless otherwise agreed in writing. This limitation of liability is not applicable for damages resulting from intent, gross negligence or culpable breach of cardinal obligations, nor shall it apply in case of death or personal injury or in case of liability under any applicable compulsory law.

CONTACT

DELO PHOTOBOND AD494 | as-of 25.10.2019 09:25 | Page 4 of 4

DELO Industrial Adhesives
Headquarters

► Germany · Windach / Munich ... www.DELO-adhesives.com

ADHESIVES

DISPENSING

CURING

CONSULTING

DELO