

DELO[®] PHOTOBOND[®] DM4084

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

free of solvents | thixotropic, unfilled, skin-friendly

Special features of product

- compliant with RoHS Directive 2015/863/EU
- compliant with limits of VOC content in adhesive acc. to GB33372-2020

Function

- damping adhesive

Typical area of use

- -40 - 130 °C
- membrane damping or wireloop fixation in miniloudspeakers

Curing

Suitable lamp types LED 400 nm, LED 365 nm

Typical irradiation time

*intensity 200 mW/cm²
LED 400 nm
layer thickness 100 µm* 3 s

Processing

Conditioning time (typical)

*when stored in cold conditions
in containers up to 50 ml* 30 min

*when stored in cold conditions
in containers up to 1,000 ml* 4 h

Storage life in unopened original container

at 0 °C to +25 °C 6 month(s)

Technical properties

Color in cured condition in 0.1 mm layer thickness red

Transparency in cured condition in 0.1 mm layer thickness translucent

Fluorescence

red fluorescent

Parameters

Density 1.03 g/cm³
DELO Standard 13 | liquid

Viscosity 38000 mPa·s
by the criteria of DIN EN 12092 | liquid | Rheometer | Shear rate: 2 1/s

Shore hardness 00 50
by the criteria of ASTM D 2240 | 400 nm | 200 mW/cm² | 90 s

Glass transition temperature -55 °C
DMTA | 400 nm | 200 mW/cm² | 90 s

Water absorption 6.0 wt. %
by the criteria of DIN EN ISO 62 | Layer thickness: 4 mm | 400 nm | 200 mW/cm² | 60 s | Type of storage: Media | Medium: Distilled water | Storage temperature: at approx. +23 °C | Duration: 24 h

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 and / or irradiation time 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

You can find further details in the 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

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