

DELO[®] PHOTOBOND[®] SR4060

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

free of solvents | thixotropic, unfilled

Special features of product

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

Typical area of use

- -40 - 150 °C
- mixed bondings with plastics
- bonding of voice coil and membrane in miniloudspeakers

Curing

Suitable lamp types LED 365 nm, LED 400 nm

Typical irradiation time

*intensity 200 mW/cm²
LED 400 nm
layer thickness 100 µm* 5 s

*intensity 1,000 mW/cm²
LED 400 nm
layer thickness 100 µm* 3 s

Processing

Typical adhesive application jetting, needle dispensing

Conditioning time (typical)

*when stored in cold conditions
in containers up to 50 ml* 1 h

*when stored in cold conditions
in containers up to 600 ml* 5 h

Storage life in unopened original container

*up to <= 1 l
at 0 °C to +25 °C* 6 month(s)

Technical properties

Transparency transparent

Color in cured condition in 0.1 mm layer thickness red

Fluorescence red + blue fluorescent

Parameters

Density 1.10 g/cm³
DELO Standard 13 | liquid

Viscosity 33000 mPa·s
liquid | Rheometer | Shear rate: 2 1/s | Gap: 500 µm

Viscosity 9500 mPa·s
liquid | Rheometer | Shear rate: 10 1/s | Gap: 500 µm

Thixotropy index 6.4
liquid | Rheometer | Gap: 500 µm

Compression shear strength 9 MPa
*DELO Standard 5 | **Glass | AI** | 400 nm | 200 mW/cm² | 10 s*

Compression shear strength 18 MPa
*DELO Standard 5 | **PC | PC** | 400 nm | 200 mW/cm² | 10 s*

Peel resistance 30 N/cm
*DELO Standard 34 | **PET | PET** | 400 nm | 200 mW/cm² | 10 s | Type of storage: Temp. | Storage temperature: at approx. +23 °C | Duration: 24 h*

Tensile strength 12 MPa
by the criteria of DIN EN ISO 527 | 400 nm | 200 mW/cm² | 60 s

Elongation at tear 550 %
by the criteria of DIN EN ISO 527 | 400 nm | 200 mW/cm² | 60 s

Young's modulus 150 MPa
DMTA | 400 nm | 200 mW/cm² | 60 s

Shore hardness A 75
by the criteria of DIN EN ISO 868 | 400 nm | 200 mW/cm² | 120 s

Shore hardness D 30
by the criteria of DIN EN ISO 868 | 400 nm | 200 mW/cm² | 120 s

Glass transition temperature 45 °C
DMTA | 400 nm | 200 mW/cm² | 60 s

Coefficient of linear expansion 230 ppm/K
DELO Standard 26 | TMA | Evaluation T: 30 °C - 130 °C | 400 nm | 200 mW/cm² | 60 s

Shrinkage 6.0 vol. %
400 nm | 200 mW/cm² | 60 s

Water absorption 9.4 wt. %
by the criteria of DIN EN ISO 62 | Layer thickness: 2 mm | 400 nm | 200 mW/cm² | 60 s | Type of storage: Media | Medium: Distilled water | 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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CONTACT