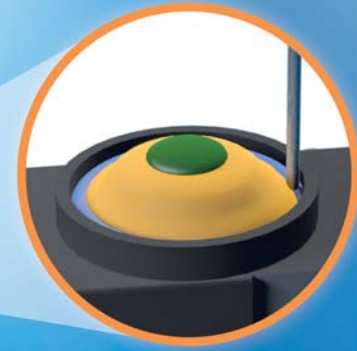


Connectors:  
Reliable  
pin sealing



Relays: Pin casting –  
the adhesive flows  
into the cavity



Microswitches:  
Pin sealing, bonding  
of housing, sealing  
of switch button

## Fast sealing of electronic components within just seconds

DELO's light-curing adhesives enable the reliable sealing of microswitches, relays and connectors, fixing of electronic components, and bonding of housing parts. Applications in the automotive industry in particular require fast bonding processes combining short cycle time with reliable process control. DELO's light-curing

adhesives are excellent for this purpose: Fast curing within seconds by exposure to light ("curing on demand") enables immediate in-line quality control. This is how component defects can be detected promptly and necessary remedial actions can be taken, saving time and cost.

### DELO-PHOTOBOND | DELO-DUALBOND



- Fast light fixation within seconds (immediate final strength)
- Highly flexible and tension-equalizing
- Curing in shadowed areas (by heat or humidity)

	DELO-PHOTOBOND		DELO-DUALBOND	
	GE4009		GE4906	GE4707
Viscosity [mPas]	1,600		2,200	1,500
Curing	UV-VIS		UV-VIS/humidity	UV-VIS/heat
Minimum curing time [s]	9		7	7
Elongation at tear [%]	500		500	460
Temperature resistance	-40 to +150 °C			

### DELO-KATIOBOND | DELO-DUALBOND



- Fast light fixation within seconds
- Curing in shadowed areas (by heat)
- Can be preactivated<sup>1)</sup> (for opaque components)
- Hard or flexible composite

	DELO-KATIOBOND		DELO-DUALBOND	
	4578	KB554	AD761	GE731
Viscosity [mPas]	12,400	1,500	11,000	17,000
Curing	UV-VIS <sup>1)</sup>	UV-VIS <sup>1)</sup>	UV-VIS/heat	UV-VIS/heat
Minimum irradiation time [s]	15	24	10	6
Elongation at tear [%]	3	45	84	98
Temperature resistance	-40 to +150 °C		-40 to +180 °C	

AD = ADhesive    GE = General Encapsulant    KB = KatioBond



Cycle time: 1.7 s

## Process example: Microswitches

Preactivation of the fillet, e.g. using the DELOLUX 202 LED lamp

Dispensing of the adhesive onto the outer fillet

Placing of the cap and sealing of the button with adhesive

Curing of the adhesive on the button and final curing of the adhesive on the cover in one step

Pin sealing

Curing of the pin adhesive, e.g. using the DELOLUX 202 LED lamp

## Three tasks – one adhesive

1. Optimal joining of opaque component parts using DELO-KATIOBOND adhesives: Dispense onto one housing part, use one short light impulse for preactivation, and join the cap.
2. Sealing of the switch button with adhesive. Cures together with the housing bonding in the second step.
3. Subsequent sealing of the connection pins.

## Satisfied customers



Watch the animation at

[www.youtube.com/DELOadhesives](http://www.youtube.com/DELOadhesives)

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08/15

Adhesives

Dispensing

Curing

Consulting

**DELO**

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