

DELO-DUOPOX[®] 03 rapid thix

modified epoxy resin | 2C | room-temperature-curing

flow-resistant, suitable for side-by-side cartridges, unfilled

Special features of product

- compliant with RoHS Directive 2015/863/EU

Function

- electronic adhesive

Typical area of use

- 40 - 80 °C

Curing

Curing time

until initial strength at rt approx. +23 °C tensile shear strength 1 - 2 MPa	10	min
until functional strength at rt approx. +23 °C tensile shear strength > 10 MPa	2	h
until final strength at rt approx. +23 °C	24	h
until functional strength at +80 °C tensile shear strength > 10 MPa	5	min
until final strength at +80 °C	40	min

Processing

Mixing ratio A : B - volume	1 : 1	
Mixing ratio A : B - weight	1 : 1	
Processing time after mixing		
in 3 g batch at rt approx. +23 °C	3	min
Storage life in unopened original container		
up to <= 1 l at +18 °C to +25 °C	12	month(s)

Technical properties

Color in cured condition in 1 mm layer thickness	yellowish
Transparency in cured condition in 1 mm layer thickness	transparent

Parameters

Density <i>Component A by the criteria of DIN 66137-2 liquid</i>	1.17	g/cm ³
Density <i>Component B by the criteria of DIN 66137-2 liquid</i>	1.21	g/cm ³
Viscosity <i>Component A by the criteria of DIN 53019 liquid Rheometer Shear rate: 2 1/s</i>	63000	mPa·s
Viscosity <i>Component B by the criteria of DIN 53019 liquid Rheometer Shear rate: 2 1/s</i>	65000	mPa·s
Tensile shear strength <i>by the criteria of DIN EN 1465 Al Al Pretreatment: sand-blasted at approx. +23 °C 24 h</i>	16	MPa
Tensile shear strength <i>by the criteria of DIN EN 1465 Al Al Pretreatment: sand-blasted at approx. +23 °C 24 h Measuring temperature: 100 °C</i>	3	MPa
Tensile shear strength <i>by the criteria of DIN EN 1465 Steel Steel Pretreatment: sand-blasted at approx. +23 °C 24 h</i>	16	MPa
Tensile strength <i>by the criteria of DIN EN ISO 527 at approx. +23 °C 24 h</i>	10	MPa
Elongation at tear <i>by the criteria of DIN EN ISO 527 at approx. +23 °C 24 h</i>	101	%
Young's modulus <i>by the criteria of DIN EN ISO 527 at approx. +23 °C 24 h</i>	20	MPa
Shore hardness D <i>by the criteria of DIN EN ISO 868 at approx. +23 °C 24 h</i>	63	
Coefficient of linear expansion <i>DELO Standard 26 TMA Evaluation T: 40 °C - 150 °C at approx. +23 °C 24 h</i>	205	ppm/K
Water absorption <i>by the criteria of DIN EN ISO 62 Layer thickness: 4 mm at approx. +23 °C 24 h Type of storage: Media Medium: Distilled water Duration: 24 h</i>	1	wt. %

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. Curing can be supported or accelerated by heat input. Additional heat input can change the physical properties of the product. 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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All products provided by DELO are subject to DELO's General Terms of Business. Verbal ancillary agreements are deemed not to exist.

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

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

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CONTACT

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ADHESIVES

DISPENSING

CURING

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