

# DELO-DUOPOX<sup>®</sup> AD895

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

suitable for side-by-side cartridges, pasty, filled

## Special features of product

- compliant with RoHS Directive 2015/863/EU
- tested for biocompatibility and meets the requirements according to DIN EN ISO 10993-5: test for cytotoxicity
- compliant with limits of VOC content in adhesive acc. to GB33372-2020

## Function

- construction adhesive

## Typical area of use

- -40 - 140 °C

## Curing

Curing time

<i>until initial strength at rt approx. +23 °C tensile shear strength 1 - 2 MPa</i>	5.5	h
<i>until functional strength at rt approx. +23 °C tensile shear strength &gt; 10 MPa</i>	8	h
<i>until final strength at rt approx. +23 °C</i>	24	h

## Processing

Mixing ratio A : B - volume 2 : 1

Mixing ratio A : B - weight 7 : 3

Processing time after mixing

*in 100 g batch  
at rt approx. +23 °C* 30 min

Storage life in unopened original container

up to <= 1 l at +18 °C to +25 °C	12	month(s)
from > 1 l at +18 °C to +25 °C	6	month(s)

**Technical properties**

Color in cured condition in 1 mm layer thickness	gray
Transparency in cured condition in 1 mm layer thickness	opaque
Filler particle type	minerals

**Parameters**

Density <i>Component A   DELO Standard 13   liquid</i>	1.37	g/cm <sup>3</sup>
Density <i>Component B   DELO Standard 13   liquid</i>	1.19	g/cm <sup>3</sup>
Tensile shear strength <i>by the criteria of DIN EN 1465   <b>AI</b>   <b>AI</b>   Pretreatment: sand-blasted   at approx. +23 °C   168 h</i>	19	MPa
Tensile shear strength <i>DELO Standard 39   <b>AI</b>   <b>AI</b>   Pretreatment: sand-blasted   at approx. +23 °C   168 h</i>	32	MPa
Peel resistance <i>DELO Standard 38   <b>Steel</b>   <b>Steel</b>   Pretreatment: sand-blasted   at approx. +23 °C   168 h</i>	1.2	N/mm
Tensile strength <i>by the criteria of DIN EN ISO 527   at approx. +23 °C   168 h</i>	40	MPa
Elongation at tear <i>by the criteria of DIN EN ISO 527   at approx. +23 °C   168 h</i>	2	%
Young's modulus <i>by the criteria of DIN EN ISO 527   at approx. +23 °C   168 h</i>	2400	MPa
Shore hardness D <i>by the criteria of DIN EN ISO 868   at approx. +23 °C   168 h</i>	73	
Glass transition temperature <i>DELO Standard 24   Rheometer</i>	66	°C

Coefficient of linear expansion 88 ppm/K  
*DELO Standard 26 | TMA | Evaluation T: 30 °C - 50 °C*

Coefficient of linear expansion 178 ppm/K  
*DELO Standard 26 | TMA | Evaluation T: 70 °C - 150 °C*

Shrinkage 4 vol. %  
*DELO Standard 13 | at approx. +23 °C | 168 h*

Water absorption 0.25 wt. %  
*by the criteria of DIN EN ISO 62 | Layer thickness: 4 mm | at approx. +23 °C | 168 h | Type of storage: Media | Medium: Distilled water | Storage temperature: at approx. +23 °C | Duration: 24 h*

Decomposition temperature 200 °C  
*DELO Standard 36 | at approx. +23 °C | 168 h*

Volume resistivity >1E13 Ohm·cm  
*by the criteria of DIN EN 62631-3-1 | at approx. +23 °C | 168 h*

Surface resistance >1E13 Ohm  
*by the criteria of DIN EN 62631-3-2 | at approx. +23 °C | 168 h*

Dielectric strength 13.7 kV/mm  
*by the criteria of DIN EN60243-1*

Relative permittivity 3.7  
*by the criteria of RF-IV | at approx. +23 °C | 168 h | 1 GHz*

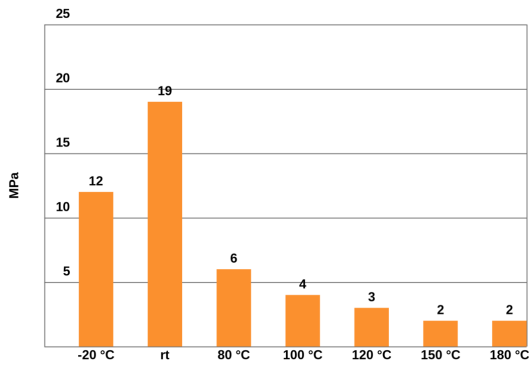
Relative permittivity 4.0  
*by the criteria of RF-IV | at approx. +23 °C | 168 h | 1 MHz*

Relative permittivity 4.0  
*by the criteria of RF-IV | at approx. +23 °C | 168 h | 10 MHz*

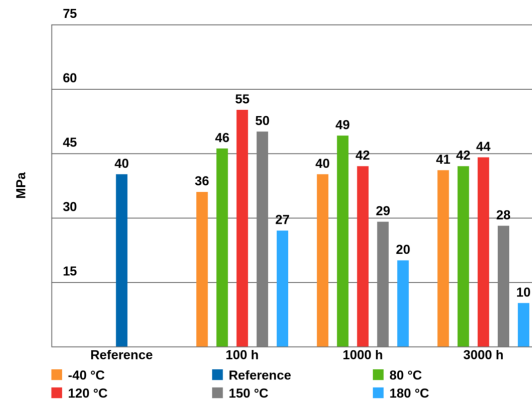
Relative permittivity 3.9  
*by the criteria of RF-IV | at approx. +23 °C | 168 h | 100 MHz*

Comparative Tracking Index M 600  
*by the criteria of DIN EN 60112*

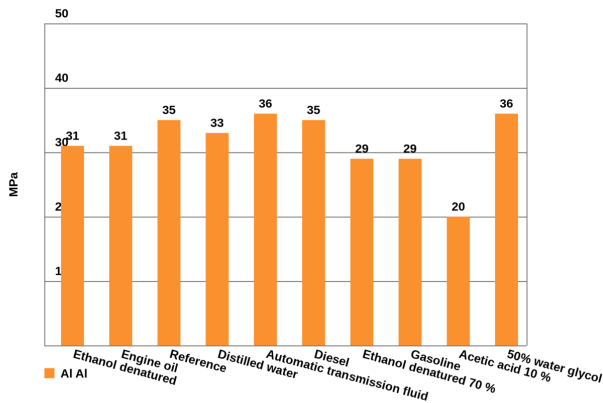
Tensile shear strength measured at the stated temperatures  
Substrates: Al/Al, by the criteria of DIN EN 1465



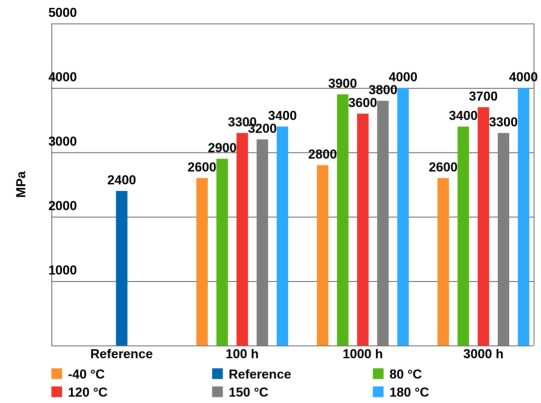
Tensile strength after temperature storage, by the criteria of DIN EN ISO 527



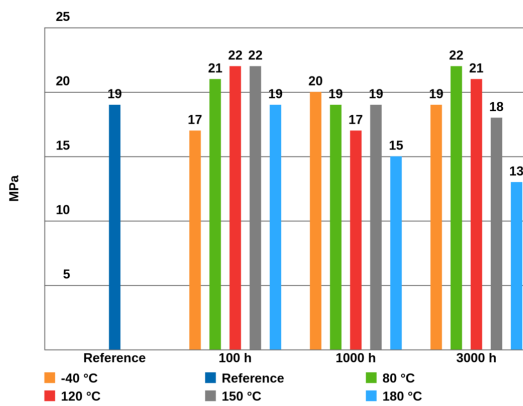
Compression shear strength after media storage for 1000 h, DELO Standard 5



Young's modulus after temperature storage, by the criteria of DIN EN ISO 527



Tensile shear strength after temperature storage  
Substrates: Al/Al, by the criteria of DIN EN 1465



**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

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**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](http://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-DUOPOX AD895 | as of 10.02.2023 10:29 | Page 6 of 6

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