

DELO DUALBOND[®] LT2208

modified epoxy resin | 1C | light-fixable / heat-curing

free of solvents | filled | light-fixable

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

Curing

Suitable lamp types LED 365 nm, LED 400 nm

Typical light fixation time

*intensity 200 mW/cm²
LED 400 nm* 1 - 5 s

Typical curing time

*at +60 °C
in air convection oven* 45 min

*at +80 °C
in air convection oven* 30 min

Processing

Typical adhesive application jetting, needle dispensing

Conditioning time (typical)

*when stored in cold conditions
in containers up to 10 ml* 0.5 h

Processing time

in standard climate +23 °C / 50 % r. h. 72 h

Storage life in unopened original container

at -25 °C to -15 °C 6 month(s)

Technical properties

Color in uncured condition	yellowish
Filler particle type	minerals
Filler particle size	d98 = 15 µm
Filler content	13 wt. %

Parameters

Density <i>DELO Standard 13 liquid</i>	1.3	g/cm ³
Viscosity <i>liquid Rheometer Shear rate: 10 1/s Gap: 200 µm</i>	1500	mPa·s
Compression shear strength <i>DELO Standard 5 ABS ABS 60 °C 90 min</i>	30	MPa
Compression shear strength <i>DELO Standard 5 FR4 FR4 60 °C 90 min</i>	25	MPa
Compression shear strength <i>DELO Standard 5 LCP GF30 LCP GF30 60 °C 90 min</i>	16	MPa
Compression shear strength <i>DELO Standard 5 PC PC 60 °C 90 min</i>	21	MPa
Compression shear strength <i>DELO Standard 5 PMMA PMMA 60 °C 90 min</i>	13	MPa
Tensile strength <i>Based on DIN EN ISO 527 60 °C 90 min</i>	22	MPa
Elongation at tear <i>Based on DIN EN ISO 527 60 °C 90 min</i>	70	%
Young's modulus <i>Based on DIN EN ISO 527 60 °C 90 min</i>	180	MPa
Shore hardness D <i>Based on DIN EN ISO 868 60 °C 90 min</i>	69	
Glass transition temperature <i>DMTA 60 °C 90 min</i>	32	°C

Coefficient of linear expansion <i>DELO Standard 26 TMA Evaluation T: -50 °C - 10 °C 60 °C 90 min</i>	57	ppm/K
Coefficient of linear expansion <i>DELO Standard 26 TMA Evaluation T: 50 °C - 150 °C 60 °C 90 min</i>	185	ppm/K
Shrinkage <i>DELO Standard 13 60 °C 90 min</i>	5	vol. %
Water absorption <i>Based on DIN EN ISO 62 60 °C 90 min Type of storage: Media Medium: Distilled water Storage temperature: at approx. +23 °C</i>	0.2	wt. %
Relative permittivity <i>Based on DIN 53483-2 60 °C 90 min 100 kHz</i>	4.39	

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. The heating time of the components must be added to the actual curing time. It depends on component size and type of heat input. The specified curing temperature must be reached directly at the adhesive. 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. In Abhängigkeit der eingesetzten Klebstoffmenge entsteht exotherme Reaktionswärme, die zu Überhitzung führen kann. In diesem Fall ist eine niedrigere Aushärtungstemperatur zu wählen. All curing or light fixation parameters depend on material thickness and absorption, adhesive layer thickness, lamp type and distance between lamp and adhesive layer. Optional prefixation is performed with light. Heat curing is mandatory. 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.
 Nothing contained herein shall be construed to indicate the non-existence of any relevant patents or to constitute a permission, encouragement or recommendation to practice any development covered by any patents, without permission of the owner of this patent.
 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 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