

DELO[®] MONOPOX LT2224

modified epoxy resin | 1C | heat-curing

free of solvents | filled, thixotropic | low-temperature-curing from + 60 °C

Special features of product

- compliant with RoHS Directive 2015/863/EU

Typical area of use

- -40 - 150 °C

Curing

Typical curing time

<i>at +60 °C</i>	30	min
<i>in air convection oven</i>		

Processing

Typical adhesive application	jetting, screen printing
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Conditioning time (typical)

<i>when stored in cold conditions</i>	0.5	h
<i>in containers up to 10 ml</i>		

<i>when stored in cold conditions</i>	1	h
<i>in containers up to 50 ml</i>		

Processing time

<i>in standard climate +23 °C / 50 % r. h.</i>	24	h
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Storage life in unopened original container

<i>at -18 °C</i>	4	month(s)
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Technical properties

Color in cured condition in 0.1 mm layer thickness	white
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Fluorescence	fluorescent
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Filler particle type	polymer
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Filler particle size	d50 = 15 µm
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Filler content 25 wt. %

Parameters

Density 1.17 g/cm³
DELO Standard 13

Viscosity 20000 mPa·s
Rheometer | Shear rate: 10 1/s

Compression shear strength 12 MPa
*DELO Standard 5 | **AI** | **AI** | 60 °C | 30 min*

Compression shear strength 8 MPa
*DELO Standard 5 | **PMMA** | **PMMA** | 60 °C | 30 min*

Compression shear strength 8 MPa
*DELO Standard 5 | **LCP GF30** | **LCP GF30** | 60 °C | 30 min*

Compression shear strength 7 MPa
*DELO Standard 5 | **PA6** | **PA6** | 60 °C | 30 min*

Compression shear strength 19 MPa
*DELO Standard 5 | **FR4** | **FR4** | 60 °C | 30 min*

Compression shear strength 4 MPa
*DELO Standard 5 | **PBT** | **PBT** | 60 °C | 30 min*

Tensile strength 5 MPa
Based on DIN EN ISO 527 | 60 °C | 30 min

Elongation at tear 90 %
Based on DIN EN ISO 527 | 60 °C | 30 min

Young's modulus 100 MPa
DMTA | 60 °C | 30 min

Shore hardness A 76
Based on DIN EN ISO 868 | 60 °C | 30 min

Glass transition temperature 25 °C
DMTA | 60 °C | 30 min

Shrinkage 3.8 vol. %
DELO Standard 13 | 60 °C | 30 min

Water absorption 0.6 wt. %
Based on DIN EN ISO 62 | 60 °C | 30 min | Type of storage: Media | Medium: Distilled water | Storage temperature: at approx. +23 °C

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.

Depending on the adhesive quantity used, exothermic reaction heat is generated which can lead to overheating. In this case, a lower curing temperature is to be selected.

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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