

DELO-DUOPOX® 1785

Multi-purpose 2c epoxy resin, cures at room temperature, low-viscous, filled

Base

- epoxy resin
- two-component, thixotropic
- contains nonylphenol

Use

- multi-purpose adhesive
- initial strength is reached very fast
- in mechanical engineering and tool construction
- in electrical engineering and electronics
- the cured product is normally used in a temperature range of -40 °C to +100 °C; depending on the application, other limits may be more reasonable
- compliant with RoHS directive 2015/863/EU

Processing

- supplied ready for use and can be processed well from the original container
- components A and B must be mixed homogeneously in the mixing ratio stated below
- using the DELO-AUTOMIX system for processing is especially advantageous
- the surfaces to be bonded must be dry as well as free of dust, grease and other contaminations
- use DELOTHEN cleaners for the cleaning of bonding surfaces

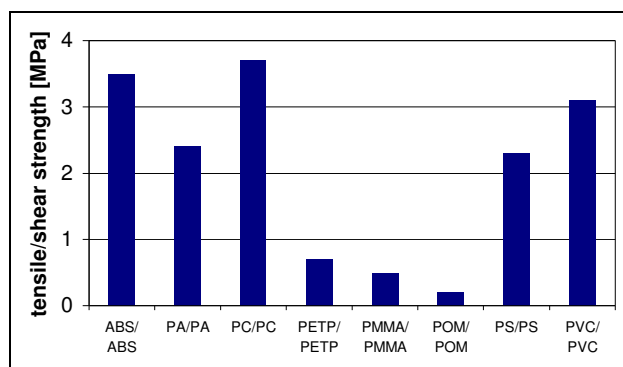
Curing

- at room temperature
- increased temperatures accelerate curing
- applying heat could change physical characteristics

Technical data

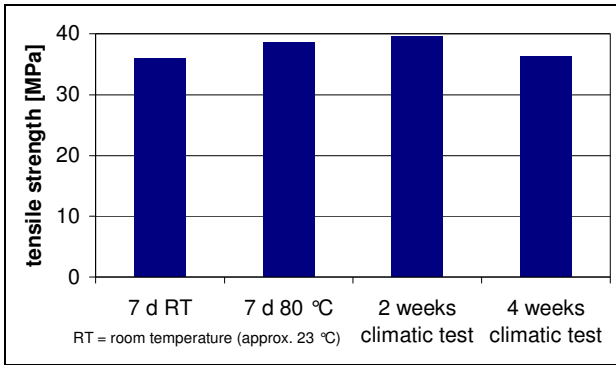
<i>Color</i>	beige
Filler	minerals
Mixing ratio (A : B) according to weight	1 : 1
(A : B) according to volume	1 : 1
Density of component A [g/cm ³] DELO Standard 13 at room temperature (approx. 23 °C)	1.17
Density of component B [g/cm ³] DELO Standard 13 at room temperature (approx. 23 °C)	1.15

Viscosity of component A [mPas] Brookfield at 23 °C	10000
Viscosity of component B [mPas] Brookfield at 23 °C	23000
Processing time in 3 g preparation [min] at room temperature (approx. 23 °C)	25
Processing time in 100 g preparation [min] at room temperature (approx. 23 °C)	10
Maximum reaction temperature [°C] in 100 g preparation	170
Curing time until initial strength [h] tensile shear strength 1 - 2 MPa at room temperature (approx. 23 °C)	2.5
Curing time until functional strength [h] tensile shear strength > 10 MPa at room temperature (approx. 23 °C)	7
Curing time until final strength [h] at room temperature (approx. 23 °C)	24
Curing time until final strength [min] at +80 °C	30
Tensile shear strength Al/Al [MPa] by the criteria of DIN EN 1465, sand-blasted component thickness 1.6 mm, gap 0.1 mm curing: 24 h at room temperature (approx. 23 °C)	22
Tensile shear strength Al/Al [MPa] DELO Standard 39, sand-blasted component thickness: 6 mm after 72 h at room temperature (approx. 23 °C)	25
Tensile shear strength According to standard DIN EN 1465 Curing: 7 d room temperature (approx. 23 °C)	



Floating roller peel resistance St/St [N/mm] DELO Standard 38, St/St sand-blasted component thickness: 1.6 mm and 0.5 mm	2.2
Temperature stability Al/Al at +100 °C [MPa] according to DIN EN 1465, at +100 °C, sand-blasted component thickness: 1.6 mm	2
Tensile strength [MPa] according to DIN EN ISO 527	36

Tensile strength
according to DIN EN ISO 527



Elongation at tear [%] according to DIN EN ISO 527	2.5
Young's modulus [MPa] according to DIN EN ISO 527	2400
Shore hardness D according to DIN EN ISO 868	67
Ball indentation hardness [MPa] ISO 2039, part 1	70
Decomposition temperature [°C] DELO Standard 36	180
Glass transition temperature [°C] Rheometer, 2nd heating process	70
Coefficient of linear expansion [ppm/K] TMA, in a temperature range of +25 to +45 °C	93
Coefficient of linear expansion [ppm/K] TMA, in a temperature range of +90 to +160 °C	200
Water absorption [weight %] according to DIN EN ISO 62, 24 h at room temperature (approx. 23 °C)	0.3
Specific volume resistance [Ωcm] VDE 0303, part 3	>1xE13
Surface resistance [Ω] VDE 0303, part 3	>1xE13
Dielectric strength [kV/mm] VDE 0303, part 2	21
Creep resistance CTI VDE 0303, part 1, IEC 112	600 M
Storage life at room temperature (approx. 23 °C) in unopened original container (volume per component < 1l)	6 months

Instructions and advice

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

The instructions for use of DELO-DUOPOX are available on: www.DELO.de. We will be pleased to send them to you on demand.

Occupational health and safety

see material safety data sheet

Specification

The properties in italics are part of the specification. Ranges with clear limits are defined for them and others, where applicable. In the course of the QA test, each batch is tested for these properties and the maintenance of the limits is ensured. The measuring methods used can deviate from those specified in the data sheet. Details can be found in the QA test report.