

# DELO-DUOPOX<sup>®</sup> SJ8665

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

filled, high-strength | very good temperature resistance, suitable for side-by-side cartridges

### Special features of product

- compliant with limits of VOC content in adhesive acc. to GB33372-2020

### Function

- structural adhesive
- electronic adhesive

### Typical area of use

- 40 - 180 °C
- metal bondings

### Curing

Curing time

until initial strength at rt approx. +23 °C tensile shear strength 1 - 2 MPa	3.5	h
until functional strength at rt approx. +23 °C tensile shear strength > 10 MPa	5	h
until final strength at rt approx. +23 °C	7	d
until initial strength at +80 °C tensile shear strength 1 - 2 MPa	5	min
until functional strength at +80 °C tensile shear strength > 10 MPa	10	min
until final strength at +80 °C	60	min

### Processing

Mixing ratio A : B - volume	2 : 1
Mixing ratio A : B - weight	1.65 : 1

Processing time after mixing

<i>in 20 g batch at rt approx. +23 °C</i>	15	min
<i>in 100 g batch at rt approx. +23 °C</i>	40	min

Reaction temperature (max.)

<i>in 100 g batch at rt approx. +23 °C</i>	166	°C
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Storage life in unopened original container

<i>up to &lt;= 1 l at +15 °C to +30 °C</i>	12	month(s)
<i>at +15 °C to +30 °C</i>	9	month(s)

**Technical properties**

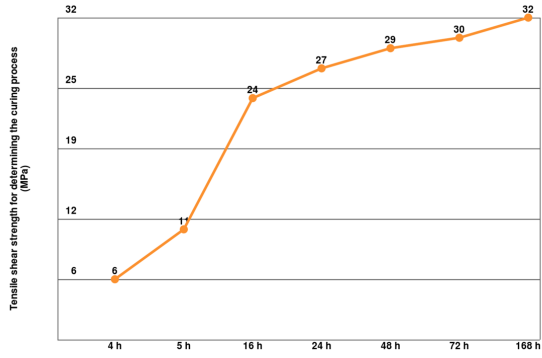
Color in cured condition in 1 mm layer thickness	black
Filler particle type	minerals

**Parameters**

Density <i>Component A   liquid</i>	1.16	g/cm <sup>3</sup>
Density <i>Component B   liquid</i>	1.41	g/cm <sup>3</sup>
Viscosity <i>Component A   liquid   Rheometer   Shear rate: 2 1/s   Gap: 500 µm</i>	300000	mPa·s
Viscosity <i>Component B   liquid   Rheometer   Shear rate: 2 1/s   Gap: 500 µm</i>	30000	mPa·s
Tensile shear strength <i>Based on DIN EN 1465   <b>AI</b>   <b>AI</b>   Pretreatment: sand-blasted   at approx. +23 °C   168 h</i>	32	MPa
Tensile shear strength <i>Based on DIN EN 1465   <b>Steel</b>   <b>Steel</b>   Pretreatment: sand-blasted   at approx. +23 °C   7 d</i>	24	MPa
Compression shear strength <i>DELO Standard 5   <b>AI</b>   <b>AI</b>   Pretreatment: sand-blasted   at approx. +23 °C   7 d</i>	30	MPa

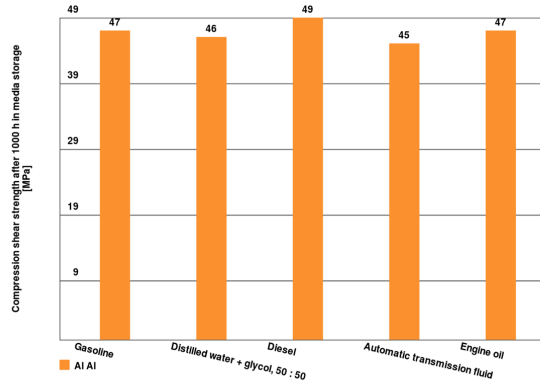
Tensile strength <i>Based on DIN EN ISO 527   at approx. +23 °C   7 d</i>	46	MPa
Elongation at tear <i>Based on DIN EN ISO 527   at approx. +23 °C   7 d</i>	3.5	%
Young's modulus <i>Based on DIN EN ISO 527   at approx. +23 °C   7 d</i>	3300	MPa
Shore hardness D <i>Based on DIN EN ISO 868   at approx. +23 °C   7 d</i>	77	
Shore hardness D <i>Based on DIN EN ISO 868   80 °C   1 h</i>	82	
Glass transition temperature <i>DMTA   at approx. +23 °C   7 d</i>	126	°C
Coefficient of linear expansion <i>DELO Standard 26   TMA   Evaluation T: 35 °C - 100 °C   at approx. +23 °C   7 d</i>	82	ppm/K
Coefficient of linear expansion <i>DELO Standard 26   TMA   Evaluation T: 120 °C - 175 °C   at approx. +23 °C   7 d</i>	171	ppm/K
Shrinkage <i>DELO Standard 13   at approx. +23 °C   7 d</i>	3	vol. %
Shrinkage <i>DELO Standard 13   80 °C   1 h</i>	3	vol. %
Water absorption <i>Based on 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</i>	0.15	wt. %
Decomposition temperature <i>DELO Standard 36   at approx. +23 °C   7 d</i>	294	°C

Substrates: Al/Al, based on DIN EN 1465



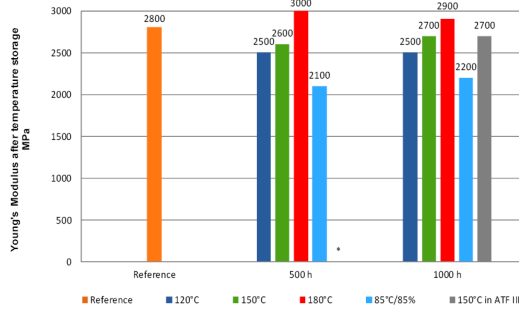
at roomtemperature (approx. 23°C)

Media resistance after 1000 h

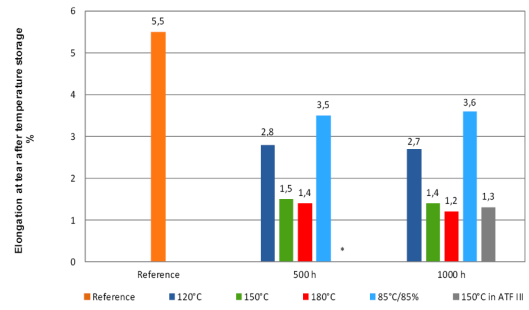


Al/Al

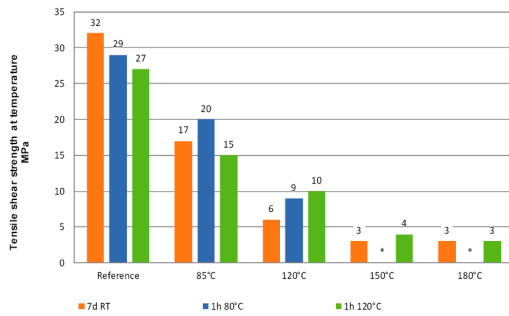
Young's Modulus after temperature storage / based on DIN EN ISO 527



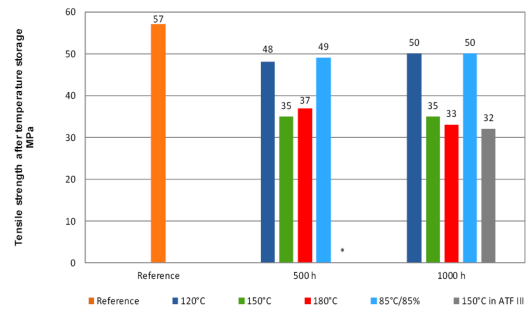
Elongation at tear after temperature storage / based on DIN EN ISO 527



Tensile shear strength at temperature / based on DIN EN 1465

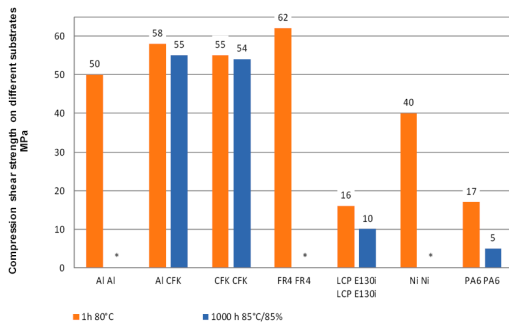


Tensile strength after temperature storage / based on DIN EN ISO 527

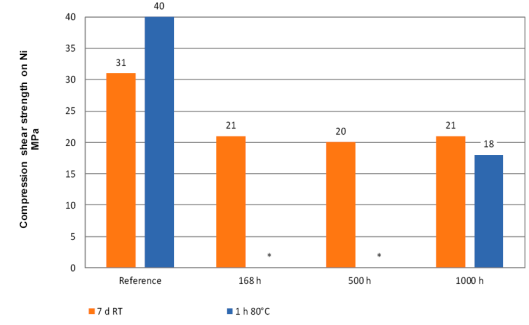


\* No value measured

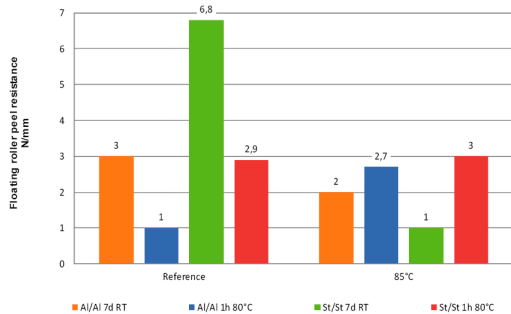
Compression shear strength on different substrates / based on DELO standard 5



Compression shear strength on Ni after 85 °C / 85 % r.h. storage



Floating roller peel resistance / based on DELO standard 38



**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](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**

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