Short cycle times by curing within seconds

2C epoxy resins are suitable for structural bonding and protective potting. For many industrial applications, the time lapse before reaching initial strength was deemed a major disadvantage – until now:

The new light-fixable DELO-DUOPOX DB (DB = Dual Bonding) products are faster than any previous 2C epoxy resin. It secures the components against slipping in just a couple of seconds, so that processing of the entire assembly can go ahead immediately. Reliable final curing – even in shadowed areas – is the same as for regular 2C products at room temperature or speeded up by heat.

Your benefits

- **Fast light fixation within a few seconds**
  Production can continue quickly, short cycle times, increased throughput

- **Reliable final curing at room temperature**
  Investment and energy costs for heat curing are eliminated, less space required in production

- **Storage/transport at room temperature**
  Simple, cost-efficient logistics

- **High strength**
  Reliable protection of components, improved functionality

- **Excellent temperature resistance**
  Consistent adhesive properties over the entire lifetime of the components

- **Excellent media resistance**
  Reliable function over the entire lifetime of the components

- **Low outgassing, low shrinkage**
  Use in optoelectronic applications, such as cameras, possible

- **Low halogen content**
  Suitable for consumer electronics products
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). Types, 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 the patent. All products provided by DELO are subject to DELO’s General Terms of Business. Verbal ancillary agreements are deemed not to exist.

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Areas of use

- Sealing of plugs and switches
- Sensor potting
- Bonding of compact camera modules
- Bonding of structural connecting elements (ONSERT™)
- Magnet bonding for e-motors

Technical features

<table>
<thead>
<tr>
<th>Application</th>
<th>DELO-DUOPOX DB8989</th>
<th>DELO-DUOPOX VE 27412</th>
</tr>
</thead>
<tbody>
<tr>
<td>Color</td>
<td>whitish opaque</td>
<td>beige opaque</td>
</tr>
<tr>
<td>Viscosity [mPa-s]</td>
<td>170,000 comp. A, 160,000 comp. B</td>
<td>13,000 comp. A, 43,000 comp. B</td>
</tr>
<tr>
<td>Light fixation time until initial strength [s]</td>
<td>1 – 20*</td>
<td>1 – 10*</td>
</tr>
<tr>
<td>LED 400 nm, intensity 1,000 mW/cm² DELOLUXcontrol</td>
<td></td>
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<tr>
<td>Curing time until final strength [d]</td>
<td>7</td>
<td>7</td>
</tr>
<tr>
<td>at room temperature (approx. +23 °C), not irradiated</td>
<td></td>
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</tr>
<tr>
<td>Tensile shear strength Al/Al [MPa]</td>
<td>28</td>
<td>25</td>
</tr>
<tr>
<td>Storage life</td>
<td>6 months</td>
<td>3 months</td>
</tr>
<tr>
<td>at room temperature (approx. +23 °C)</td>
<td></td>
<td></td>
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</tbody>
</table>

* depending on component geometry and adhesive volume

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