

# DELO-DUOPOX<sup>®</sup> AD848

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

suitable for side-by-side cartridges, filled, thixotropic, high-strength

### Special features of product

- compliant with RoHS Directive 2015/863/EU
- tested for biocompatibility and meets the requirements according to DIN EN ISO 10993-5: test for cytotoxicity

### Function

- construction adhesive

### Typical area of use

- 40 - 150 °C

### Curing

Curing time

*until initial strength  
at rt approx. +23 °C  
tensile shear strength 1 - 2 MPa*

7 h

*until functional strength  
at rt approx. +23 °C  
tensile shear strength > 10 MPa*

16 h

*until final strength  
at rt approx. +23 °C*

168 h

### Processing

Mixing ratio A : B - volume

1 : 1

Mixing ratio A : B - weight

0.87 : 1

Processing time after mixing

*in 100 g batch  
at rt approx. +23 °C*

90 min

Storage life in unopened original container

*at +18 °C to +25 °C*

6 month(s)

**Technical properties**

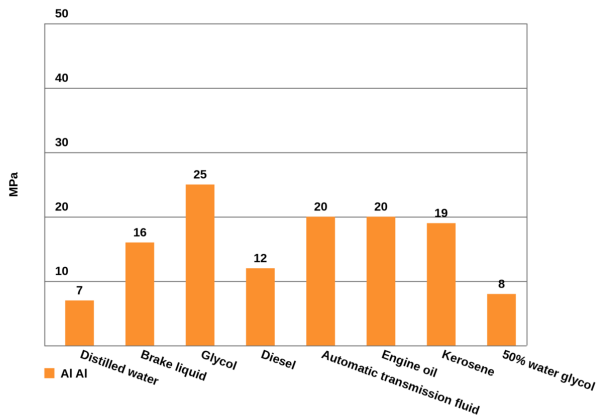
Color in cured condition in 1 mm layer thickness	gray
Filler particle type	minerals

**Parameters**

Density <i>Component A   DELO Standard 13   liquid</i>	1.19	g/cm <sup>3</sup>
Density <i>Component B   DELO Standard 13   liquid</i>	1.37	g/cm <sup>3</sup>
Viscosity <i>Component A   liquid   Rheometer   Shear rate: 1 1/s   Gap: 500 µm</i>	310000	mPa·s
Viscosity <i>Component B   liquid   Rheometer   Shear rate: 1 1/s   Gap: 500 µm</i>	530000	mPa·s
Tensile shear strength <i>by the criteria of DIN EN 1465   <b>AI   AI</b>   Pretreatment: sand-blasted   at approx. +23 °C   24 h</i>	16	MPa
Tensile shear strength <i>by the criteria of DIN EN 1465   <b>AI   AI</b>   Pretreatment: sand-blasted   at approx. +23 °C   168 h</i>	21	MPa
Tensile shear strength <i>by the criteria of DIN EN 1465   <b>AI   AI</b>   at approx. +23 °C   168 h</i>	17	MPa
Tensile shear strength <i>by the criteria of DIN EN 1465   <b>Stainless steel   Stainless steel</b>   at approx. +23 °C   168 h</i>	22	MPa
Tensile shear strength <i>by the criteria of DIN EN 1465   <b>Steel   Steel</b>   at approx. +23 °C   168 h</i>	19	MPa
Compression shear strength <i>DELO Standard 5   <b>FR4   FR4</b>   Pretreatment: Annealing   at approx. +23 °C   168 h</i>	32	MPa
Compression shear strength <i>DELO Standard 5   <b>PA6   PA6</b>   Pretreatment: Annealing   at approx. +23 °C   168 h</i>	18	MPa
Compression shear strength <i>DELO Standard 5   <b>PBT   PBT</b>   at approx. +23 °C   168 h</i>	5	MPa
Peel resistance <i>DELO Standard 38   <b>Steel   Steel</b>   Pretreatment: sand-blasted   at approx. +23 °C   168 h</i>	7	N/mm
Tensile strength <i>by the criteria of DIN EN ISO 527   at approx. +23 °C   168 h</i>	30	MPa

Elongation at tear <i>by the criteria of DIN EN ISO 527   at approx. +23 °C   168 h</i>	4	%
Young's modulus <i>by the criteria of DIN EN ISO 527   at approx. +23 °C   168 h</i>	1800	MPa
Shore hardness D <i>by the criteria of DIN EN ISO 868   at approx. +23 °C   168 h</i>	75	
Glass transition temperature <i>DELO Standard 24   Rheometer   at approx. +23 °C   168 h</i>	70	°C
Shrinkage <i>DELO Standard 13   at approx. +23 °C   168 h</i>	2	vol. %
Decomposition temperature <i>DELO Standard 36   at approx. +23 °C   168 h</i>	283	°C

Compression shear strength after media storage for 1000 h, DELO Standard 5



### 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.

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](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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