

DELO[®] MONOPOX GE6515

modified epoxy resin | 1C | heat-curing

free of solvents | flowable, filled

Special features of product

- compliant with RoHS Directive 2015/863/EU

Function

- encapsulant / potting compound

Typical area of use

- -40 - 200 °C
- large-area encapsulation and potting

Curing

Typical curing time

| | | |
|-------------------------------|----|-----|
| <i>at +130 °C</i> | 15 | min |
| <i>in air convection oven</i> | | |

Processing

Conditioning time (typical)

| | | |
|--|----|---|
| <i>when stored in cold conditions in containers up to 50 ml</i> | 1 | h |
| <i>when stored in cold conditions in containers up to 600 ml</i> | 5 | h |
| <i>when stored in cold conditions in containers up to 10 l</i> | 10 | h |

Processing time

| | | |
|---|---|---|
| <i>in standard climate +23 °C / 50 % r. h.</i> | 7 | d |
| <i>tumble before processing for 1 h 1 – 2 l/min conditioned containers in containers up to 10 l</i> | 7 | d |

Storage life in unopened original container

| | | |
|---|---|----------|
| up to <= 55 ml at -45 °C to -15 °C Cartridge | 6 | month(s) |
| up to <= 600 ml at -45 °C to -15 °C Cartridge | 6 | month(s) |
| up to <= 10 l at 0 °C to +10 °C Barrel | 6 | month(s) |

Technical properties

| | |
|---|-------------|
| Color in cured condition in 1 mm layer thickness | white |
| Transparency in cured condition in 1 mm layer thickness | opaque |
| Filler particle type | minerals |
| Filler particle size | d95 = 65 µm |

Parameters

| | | |
|--|-------|-------------------|
| Density <i>by the criteria of DIN 66137-2 liquid</i> | 1.78 | g/cm ³ |
| Viscosity <i>liquid Rheometer Shear rate: 10 1/s Gap: 200 µm</i> | 10000 | mPa·s |
| Compression shear strength <i>DELO Standard 5 AI AI 130 °C 15 min</i> | 41 | MPa |
| Compression shear strength <i>DELO Standard 5 AI AI 130 °C 15 min Measuring temperature: 150 °C</i> | 20 | MPa |
| Compression shear strength <i>DELO Standard 5 AI AI 130 °C 15 min Measuring temperature: 200 °C</i> | 14 | MPa |
| Compression shear strength <i>DELO Standard 5 FR4 FR4 130 °C 15 min</i> | 25 | MPa |
| Compression shear strength <i>DELO Standard 5 PC PC 130 °C 15 min</i> | 38 | MPa |
| Tensile strength <i>by the criteria of DIN EN ISO 527 130 °C 15 min</i> | 60 | MPa |

| | | |
|--|-------|--------|
| Elongation at tear <i>by the criteria of DIN EN ISO 527 130 °C 15 min</i> | 0.5 | % |
| Young's modulus <i>by the criteria of DIN EN ISO 527 130 °C 15 min</i> | 13000 | MPa |
| Shore hardness D <i>by the criteria of DIN EN ISO 868 130 °C 15 min</i> | >90 | |
| Glass transition temperature <i>TMA 130 °C 15 min</i> | 155 | °C |
| Coefficient of linear expansion <i>DELO Standard 26 TMA Evaluation T: 30 °C - 115 °C 130 °C 15 min</i> | 23 | ppm/K |
| Coefficient of linear expansion <i>DELO Standard 26 TMA Evaluation T: 175 °C - 230 °C 130 °C 15 min</i> | 48 | ppm/K |
| Shrinkage <i>DELO Standard 13 130 °C 15 min</i> | 1.3 | vol. % |
| Water absorption <i>by the criteria of DIN EN ISO 62 Layer thickness: 4 mm 130 °C 20 min Type of storage: Media / Medium: Distilled water Storage temperature: at approx. +23 °C Duration: 24 h</i> | 0.1 | wt. % |
| Decomposition temperature <i>DELO Standard 36 130 °C 15 min</i> | 345 | °C |
| Extractable ions <i>Ion: Natrium</i> | <5 | ppm |
| Extractable ions <i>Ion: Kalium</i> | <5 | ppm |
| Extractable ions <i>Ion: Fluorid</i> | <10 | ppm |
| Extractable ions <i>Ion: Chlorid</i> | <5 | ppm |
| Comparative Tracking Index <i>by the criteria of DIN EN 60112 130 °C 15 min</i> | 600 | |

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 adhesive can be tumbled during conditioning if necessary, depending on the chemical basis and container size. After tumbling, a waiting time of 1 – 2 h must be maintained to enable air bubbles to escape.

Alternatively, a pressure tank with integrated stirring element can be used to keep the material continuously homogeneous.

The viscosity may decrease during tumbling. Cartridges are excluded from tumbling.

Further information can be found in the instructions for use. 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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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.

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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CONTACT

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ADHESIVES

DISPENSING

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