

DELO-DUOPOX[®] SJ8281

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

flow-resistant, suitable for side-by-side cartridges, filled, pasty

Special features of product

- compliant with RoHS Directive 2015/863/EU

Function

- structural adhesive

Typical area of use

- 40 - 120 °C

Curing

Curing time

<i>until initial strength at rt approx. +23 °C tensile shear strength 1 - 2 MPa</i>	30	min
<i>until functional strength at rt approx. +23 °C tensile shear strength > 10 MPa</i>	120	min
<i>until final strength at rt approx. +23 °C</i>	168	h

Processing

Mixing ratio A : B - volume	1 : 2	
Mixing ratio A : B - weight	0.42 : 1	
Processing time after mixing		
<i>in 10 g batch at rt approx. +23 °C</i>	13	min
Storage life in unopened original container		
<i>at +18 °C to +25 °C</i>	6	month(s)

Technical properties

Color in cured condition in 1 mm layer thickness	gray
Transparency in cured condition in 1 mm layer thickness	opaque

Filler particle type minerals

Parameters

Density 1.18 g/cm³
Component A | liquid

Density 1.44 g/cm³
Component B | liquid

Viscosity 70000 mPa·s
Component A | liquid | Rheometer | Shear rate: 2 1/s | Gap: 500 µm

Viscosity 250000 mPa·s
Component B | liquid | Rheometer | Shear rate: 2 1/s | Gap: 500 µm

Tensile shear strength 14 MPa
*by the criteria of DIN EN 1465 | **AI | AI** | Pretreatment: sand-blasted | at approx. +23 °C | 168 h*

Tensile shear strength 2 MPa
*by the criteria of DIN EN 1465 | **AI | AI** | Pretreatment: sand-blasted | at approx. +23 °C | 168 h | Measuring temperature: 80 °C*

Tensile shear strength 15 MPa
*by the criteria of DIN EN 1465 | **Steel | Steel** | Pretreatment: sand-blasted | at approx. +23 °C | 168 h*

Tensile shear strength 7 MPa
*by the criteria of DIN EN 1465 | **Steel | Steel** | at approx. +23 °C | 168 h*

Compression shear strength 8 MPa
*DELO Standard 5 | **AI | AI** | at approx. +23 °C | 168 h*

Compression shear strength 3 MPa
*DELO Standard 5 | **AI | AI** | at approx. +23 °C | 168 h | Type of storage: Constant climate | Storage temperature: 85 °C | Humidity: 85 % | Duration: 1000 h*

Compression shear strength 13 MPa
*DELO Standard 5 | **Glass | AI** | at approx. +23 °C | 168 h*

Compression shear strength 6 MPa
*DELO Standard 5 | **PA6 | PA6** | Pretreatment: Annealing | at approx. +23 °C | 168 h*

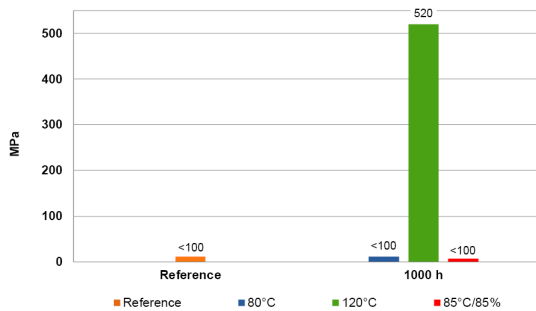
Compression shear strength 6 MPa
*DELO Standard 5 | **PA66 | PA66** | at approx. +23 °C | 168 h*

Compression shear strength 6 MPa
*DELO Standard 5 | **PC | ABS** | at approx. +23 °C | 168 h*

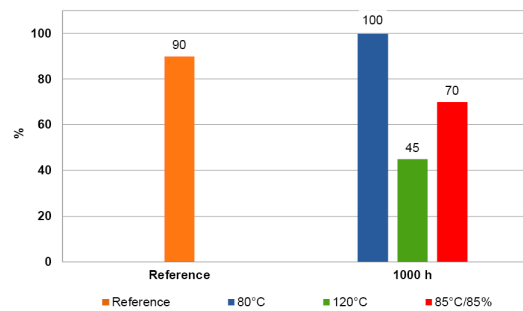
Compression shear strength 5 MPa
*DELO Standard 5 | **PC | PC** | at approx. +23 °C | 168 h*

Peel resistance <i>DELO Standard 38 Steel Steel 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>	5	MPa
Elongation at tear <i>by the criteria of DIN EN ISO 527 at approx. +23 °C 168 h</i>	90	%
Young's modulus <i>by the criteria of DIN EN ISO 527 at approx. +23 °C 168 h</i>	<100	MPa
Shore hardness A <i>by the criteria of DIN EN ISO 868 at approx. +23 °C 168 h</i>	75	
Shore hardness D <i>by the criteria of DIN EN ISO 868 at approx. +23 °C 168 h</i>	36	
Water absorption <i>by the criteria of DIN EN ISO 62 Layer thickness: 4 mm at approx. +23 °C 168 h Type of storage: Media Medium: Distilled water</i>	0.5	wt. %

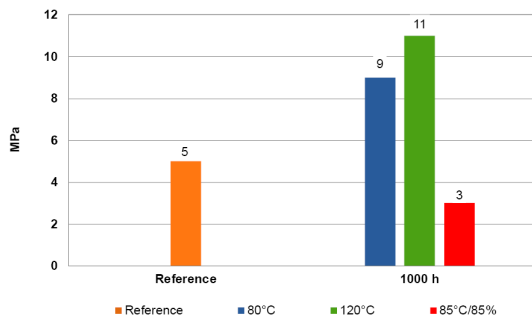
Young's Modulus after temperature storage, by the criteria of DIN EN ISO 527



Elongation at tear after temperature storage, by the criteria of DIN EN ISO 527



Tensile strength after temperature storage, by the criteria of DIN EN ISO 527



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.

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

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CONTACT

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ADHESIVES

DISPENSING

CURING

CONSULTING