

DELO DUALBOND[®] AD761

modified epoxy resin | 1C | UV- / VIS- / heat-curing

free of solvents | filled, thixotropic

Special features of product

- compliant with RoHS Directive 2015/863/EU

Typical area of use

- -40 - 150 °C

Curing

Suitable lamp types LED 365 nm, LED 400 nm, UVA

Typical light fixation time

*intensity 200 mW/cm²
LED 400 nm* 15 s

Typical curing time

*at +130 °C
in air convection oven* 5 min

*at +150 °C
in air convection oven* 3 min

Processing

Typical adhesive application needle dispensing

Conditioning time (typical)

*when stored in cold conditions
in containers up to 50 ml* 1.5 h

*when stored in cold conditions
in containers up to 1,000 ml* 4 h

*when stored in cold conditions
in containers up to 10 l* 10 h

Processing time

at rt approx. +23 °C 28 d

Storage life in unopened original container

<i>up to <= 1 l at 0 °C to +10 °C</i>	6	month(s)
<i>up to > 10 l per component at 0 °C to +10 °C</i>	3	month(s)

Technical properties

Color in cured condition in 1 mm layer thickness	yellowish
Transparency in cured condition in 1 mm layer thickness	transparent

Parameters

Density <i>Based on DIN EN ISO 2811-3 liquid</i>	1.14	g/cm ³
Viscosity <i>liquid Rheometer Shear rate: 10 1/s</i>	6000	mPa·s
Thixotropy index <i>liquid Rheometer</i>	1.5	
Maximum curable layer thickness <i>DELO Standard 20 White substrate 400 nm 200 mW/cm² 15 s Plus at approx. +23 °C 24 h</i>	2.5	mm
Maximum curable layer thickness <i>DELO Standard 20 White substrate 400 nm 200 mW/cm² 30 s Plus at approx. +23 °C 24 h</i>	≥ 4	mm
Compression shear strength <i>DELO Standard 5 Glass FR4 400 nm 200 mW/cm² 15 s Plus 130 °C 10 min</i>	20	MPa
Compression shear strength <i>DELO Standard 5 PC PC 130 °C 10 min</i>	40	MPa
Compression shear strength <i>DELO Standard 5 Glass Glass 130 °C 10 min</i>	20	MPa
Tensile strength <i>Based on DIN EN ISO 527 400 nm 200 mW/cm² 60 s Plus 130 °C 10 min</i>	22	MPa
Elongation at tear <i>Based on DIN EN ISO 527 400 nm 200 mW/cm² 60 s Plus 130 °C 10 min</i>	86	%

Young's modulus <i>DMTA 400 nm 200 mW/cm² 60 s Plus 130 °C 10 min</i>	1000	MPa
Shore hardness D <i>Based on DIN EN ISO 868 400 nm 200 mW/cm² 15 s Plus 130 °C 10 min</i>	56	
Glass transition temperature <i>DMTA 400 nm 200 mW/cm² 60 s Plus 130 °C 10 min</i>	48	°C
Coefficient of linear expansion <i>DELO Standard 26 TMA Evaluation T: 60 °C - 140 °C 400 nm 200 mW/cm² 15 s Plus 130 °C 10 min</i>	214	ppm/K
Coefficient of linear expansion <i>DELO Standard 26 TMA Evaluation T: -40 °C - -20 °C 400 nm 200 mW/cm² 15 s Plus 130 °C 10 min</i>	91	ppm/K
Shrinkage <i>DELO Standard 13 400 nm 200 mW/cm² 15 s Plus 130 °C 10 min</i>	3.3	vol. %
Water absorption <i>Based on DIN EN ISO 62 400 nm 200 mW/cm² 15 s Plus 130 °C 10 min Type of storage: Media Medium: Distilled water Storage temperature: at approx. +23 °C Duration: 24 h</i>	0.5	wt. %
Volume resistivity <i>Based on DIN EN 62631-3-1 400 nm 200 mW/cm² 15 s Plus 130 °C 10 min</i>	>1xE13	Ohm·cm
Surface resistance <i>Based on DIN EN 62631-3-2 400 nm 200 mW/cm² 15 s Plus 130 °C 10 min</i>	6xE11	Ohm
Creep resistance CTI <i>Based on DIN EN 60112 400 nm 200 mW/cm² 60 s Plus 130 °C 10 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 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.

Parameters can vary for pure light curing, pure heat curing and a combination of light and heat curing.

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.

All curing or light fixation parameters depend on material thickness and absorption, adhesive layer thickness, lamp type and distance between lamp and adhesive layer.

Curing until final strength proceeds within 24 hours at room temperature.

Light and heat curing mechanisms can be used independently.

High temperatures during or after curing can lead to post-crosslinking of the adhesive which influences the physical properties of the bond.

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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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 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

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CONTACT

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ADHESIVES

DISPENSING

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