

DELO® MONOPOX DA2258

modified epoxy resin | 1C | heat-curing

free of solvents | low-temperature-curing from + 60 °C, filled, thixotropic

Special features of product

- compliant with RoHS Directive 2015/863/EU
- halogen-free according to IEC 61249-2-21
- compliant with limits of VOC content in adhesive acc. to GB33372-2020

Function

- die attach adhesive
- electronic adhesive

Typical area of use

- -40 150 °C
- chip bonding
- bonding of temperature-sensitive substrates

Curing

Typical curing time		
at +60 °C in air convection oven	30	min
at +80 °C in air convection oven	10	min
Processing		
Conditioning time (typical)		
when stored in cold conditions in containers up to 10 ml	0.5	h
Processing time		
in standard climate +23 °C / 50 % r. h.	72	h
Storage life in unopened original container		
at -18 °C	6	month(s)
Technical properties		
Color in cured condition in 1 mm layer thickness	black	



opaque	
minerals	
d98 = 15 μm	
1.49	g/cm³
42000	mPa·s
3.3	
30	MPa
40	MPa
12	MPa
18	MPa
72	N
24	N
55	MPa
2	%
4400	MPa
85	
	minerals d98 = 15 µm 1.49 42000 3.3 30 40 12 18 72 24 55 2



Glass transition temperatu DMTA 80 °C 10 min	re	62	°C
Coefficient of linear expansion DELO Standard 26 TMA Evaluation T: -40 °C - 20 °C 80 °C 10 min		47	ppm/K
Coefficient of linear expans	sion tion T: 60 °C - 160 °C 80 °C 10 min	166	ppm/K
Shrinkage DELO Standard 13 80 °C 10 mir	7	4.3	vol. %
Water absorption by the criteria of DIN EN ISO 62 Layer thickness: 4 mm 80 °C 10 min Type of storage: Media Medium: Distilled water Storage temperature: at approx. +23 °C Duration: 24 h		0.1	wt. %
Extractable ions Ion: Chloride		<5	ppm
Extractable ions Ion: Fluoride		<5	ppm
Extractable ions Ion: Potassium		<5	ppm
Extractable ions Ion: Sodium		<5	ppm
Converting table			
°F = (°C x 1.8) + 32 1 inch = 25.4 mm 1 mil = 25.4 µm 1 oz = 28.3495 g	1 MPa = 145.04 psi 1 GPa = 145.04 ksi 1 cP = 1 mPa·s 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. 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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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

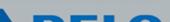
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CONTACT

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