

DELO[®] MONOPOX GE6515

modified epoxy resin | 1C | heat-curing

free of solvents | filled | flowable

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 in air convection oven</i>	15	min
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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

<i>up to <= 600 ml at -45 °C to -15 °C Cartridge</i>	6	month(s)
<i>up to <= 10 l at 0 °C to +10 °C Barrel</i>	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 size	d95 = 65 µm

Parameters

Density <i>Based on 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>Based on DIN EN ISO 527 130 °C 15 min</i>	60	MPa
Elongation at tear <i>Based on DIN EN ISO 527 130 °C 15 min</i>	0.5	%
Young's modulus <i>Based on DIN EN ISO 527 130 °C 15 min</i>	13000	MPa
Shore hardness D <i>Based on DIN EN ISO 868 130 °C 15 min</i>	92	
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>Based on 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 fluoride ions	<10	ppm
Extractable chloride ions	<5	ppm
Extractable potassium ions	<5	ppm
Extractable sodium ions	<5	ppm
Creep resistance CTI <i>Based on 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.

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

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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ADHESIVES

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