

DELO[®] MONOPOX GE6525

modified epoxy resin | 1C | heat-curing

free of solvents | filled, thixotropic | flowable, low CTE

Special features of product

- compliant with RoHS Directive 2015/863/EU

Function

- Fill for Dam&Fill
- encapsulant / potting compound

Typical area of use

- 65 - 200 °C

Curing

Typical curing time

<i>at +100 °C in air convection oven</i>	30	min
<i>at +150 °C in air convection oven</i>	5	min

Processing

Conditioning time (typical)

<i>when stored in cold conditions in containers up to 50 ml</i>	1	h
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Processing time

<i>in standard climate +23 °C / 50 % r. h.</i>	48	h
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Storage life in unopened original container

<i>at -45 °C to -35 °C</i>	6	month(s)
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Technical properties

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

Parameters

Density 1.87 g/cm³
by the criteria of DIN 66137-2 | liquid

Viscosity 18000 mPa·s
liquid | Rheometer | Shear rate: 10 1/s | Gap: 500 µm

Compression shear strength 38 MPa
*DELO Standard 5 | **AI** | **AI** | Pretreatment: sand-blasted | 150 °C | 5 min*

Compression shear strength 48 MPa
*DELO Standard 5 | **G11** | **G11** | Pretreatment: Annealing | 150 °C | 5 min*

Compression shear strength 17 MPa
*DELO Standard 5 | **PBT** | **PBT** | 150 °C | 5 min*

Compression shear strength 16 MPa
*DELO Standard 5 | **PPS** | **PPS** | 150 °C | 5 min*

Tensile strength 60 MPa
by the criteria of DIN EN ISO 527 | 150 °C | 5 min

Elongation at tear 0.5 %
by the criteria of DIN EN ISO 527 | 150 °C | 5 min

Young's modulus 23000 MPa
DMTA | 150 °C | 5 min

Shore hardness D >90
by the criteria of DIN EN ISO 868 | 150 °C | 5 min

Glass transition temperature 187 °C
DMTA | 150 °C | 5 min

Coefficient of linear expansion 13 ppm/K
DELO Standard 26 | TMA | Evaluation T: -40 °C - 60 °C | 150 °C | 5 min

Coefficient of linear expansion 40 ppm/K
DELO Standard 26 | TMA | Evaluation T: 190 °C - 235 °C | 150 °C | 5 min

Shrinkage 1.1 vol. %
DELO Standard 13 | 150 °C | 5 min

Water absorption 0.07 wt. %
by the criteria of DIN EN ISO 62 | Layer thickness: 4 mm | 150 °C | 5 min | Type of storage: Media | Medium: Distilled water | Storage temperature: at approx. +23 °C | Duration: 24 h

Extractable chloride ions	<10	ppm
Extractable potassium ions	<10	ppm
Extractable sodium ions	<10	ppm
Specific thermal conductivity <i>by the criteria of ASTM D 5470 150 °C 5 min</i>	0.9	W/(m·K)
Volume resistivity <i>by the criteria of DIN EN 62631-3-1 150 °C 5 min</i>	>1E+15	Ohm·cm
Surface resistance <i>by the criteria of DIN EN 62631-3-2 150 °C 5 min</i>	>1E+13	Ohm
Dielectric strength <i>by the criteria of DIN EN 60243-1 150 °C 5 min</i>	34	kV/mm
Relative permittivity <i>by the criteria of DIN 53483-2 150 °C 5 min 1 kHz</i>	3.6	
Relative permittivity <i>by the criteria of DIN 53483-2 150 °C 5 min 1 MHz</i>	2.8	
Relative permittivity <i>by the criteria of DIN 53483-2 150 °C 5 min 100 kHz</i>	3.0	

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. 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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DELO Industrial Adhesives
Headquarters

► Germany · Windach / Munich ... www.DELO-adhesives.com

ADHESIVES

DISPENSING

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