

DELO-DUOPOX[®] CR8021

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

tension-equalizing, flowable, very good media resistance, suitable for side-by-side cartridges, unfilled

Special features of product

- compliant with RoHS Directive 2015/863/EU
- Long-term preheating of components is possible
- Any formation of bubbles during homogenization or mixing can be significantly minimized by using a processing system with vacuum unit

Function

- encapsulant / potting compound
- electronic encapsulant

Typical area of use

- -40 - 140 °C

Curing

Curing time

<i>until initial strength at rt approx. +23 °C tensile shear strength 1 - 2 MPa</i>	5.5	h
<i>until functional strength at rt approx. +23 °C tensile shear strength > 10 MPa</i>	48	h
<i>until final strength at rt approx. +23 °C</i>	72	h
<i>until initial strength at +80 °C tensile shear strength 1 - 2 MPa</i>	5	min
<i>until functional strength at +80 °C tensile shear strength > 10 MPa</i>	15	min

Processing

Mixing ratio A : B - volume	0.5 : 1	
Mixing ratio A : B - weight	0.58 : 1	
Processing time after mixing		
<i>in 100 g batch at rt approx. +23 °C</i>	60	min

Storage life in unopened original container

at +18 °C to +25 °C 12 month(s)

Technical properties

Color in cured condition in 1 mm layer thickness yellowish

Transparency in cured condition in 1 mm layer thickness translucent

Parameters

Density 1.18 g/cm³
Component A | liquid

Density 1.03 g/cm³
Component B | liquid

Viscosity 34000 mPa·s
Component A | liquid | Rheometer | Shear rate: 2 1/s | Gap: 37 µm

Viscosity 10000 mPa·s
Component B | liquid | Rheometer | Shear rate: 2 1/s | Gap: 37 µm

Tensile shear strength 11 MPa
by the criteria of DIN EN 1465 | **Al | Al** | Pretreatment: sand-blasted | at approx. +23 °C | 168 h

Tensile shear strength 12 MPa
by the criteria of DIN EN 1465 | **Steel | Steel** | Pretreatment: sand-blasted | at approx. +23 °C | 168 h

Peel resistance 3 N/mm
DELO Standard 38 | **Steel | Steel** | Pretreatment: sand-blasted | at approx. +23 °C | 168 h

Tensile strength 9 MPa
by the criteria of DIN EN ISO 527 | at approx. +23 °C | 168 h

Elongation at tear 35 %
by the criteria of DIN EN ISO 527 | at approx. +23 °C | 168 h

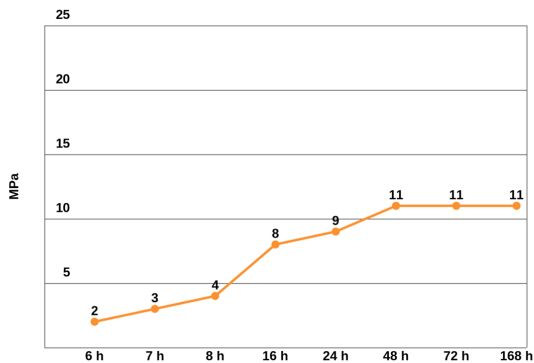
Young's modulus 100 MPa
by the criteria of DIN EN ISO 527 | at approx. +23 °C | 168 h

Shore hardness D 47
by the criteria of DIN EN ISO 868 | at approx. +23 °C | 168 h

Glass transition temperature 47 °C
DMTA | at approx. +23 °C | 168 h

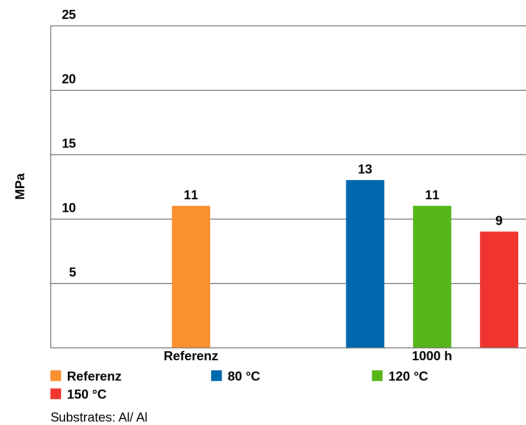
Coefficient of linear expansion <i>DELO Standard 26 TMA Evaluation T: 30 °C - 150 °C at approx. +23 °C 168 h</i>	250	ppm/K
Shrinkage <i>DELO Standard 13 at approx. +23 °C 168 h</i>	3	vol. %
Water absorption <i>by the criteria of DIN EN ISO 62 Layer thickness: 4 mm at approx. +23 °C 168 h Type of storage: Media Medium: Distilled water Storage temperature: at approx. +23 °C Duration: 24 h</i>	0.5	wt. %
Decomposition temperature <i>DELO Standard 36 at approx. +23 °C 168 h</i>	277	°C
Volume resistivity <i>by the criteria of DIN EN 62631-3-1 at approx. +23 °C 168 h</i>	>1E12	Ohm·cm
Surface resistance <i>by the criteria of DIN EN 62631-3-2 at approx. +23 °C 168 h</i>	>1E11	Ohm
Relative permittivity <i>by the criteria of RF-IV 1 MHz</i>	3.5	
Relative permittivity <i>by the criteria of RF-IV 1 GHz</i>	3.0	
Relative permittivity <i>by the criteria of RF-IV 10 MHz</i>	3.5	
Relative permittivity <i>by the criteria of RF-IV 100 MHz</i>	3.2	
Comparative Tracking Index <i>by the criteria of DIN EN 60112</i>	600	

Tensile shear strength for determining the curing process
Substrates: Al/Al, by the criteria of DIN EN 1465

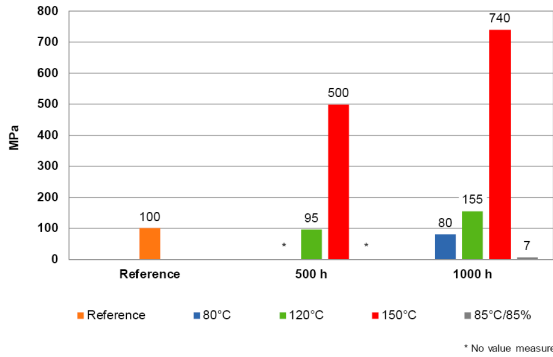


at room temperature (approx. +23 °C)

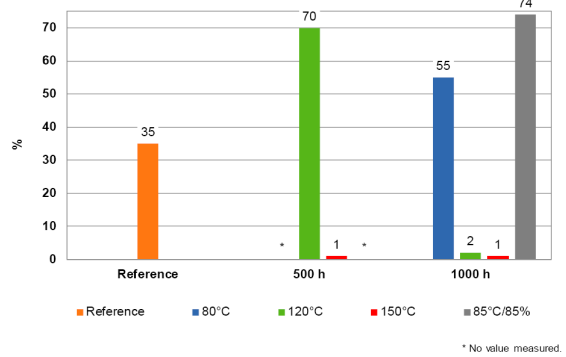
Tensile shear strength after thermal storage, by the criteria of DIN EN 1465



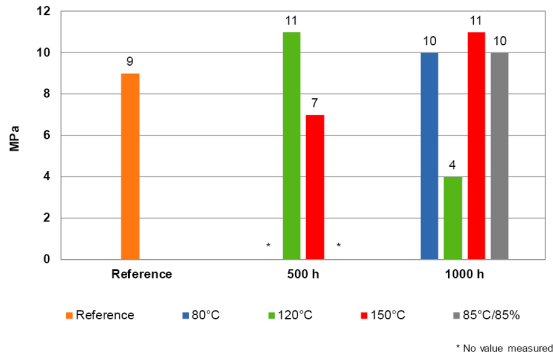
Young's Modulus after temperature storage, by the criteria of DIN EN ISO 527



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 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

DISPENSING

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