

DELO-DUOPOX[®] FR898

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

filled | suitable for side-by-side cartridges

Special features of product

- compliant with RoHS Directive 2015/863/EU
- UL listing: UL file E467212 (Yellow Card)
- passes ANSI/UL 94 V-0 Flame Test

Typical area of use

- -40 - 140 °C

Curing

Curing time

*until initial strength
tensile shear strength 1 - 2 MPa*

4.5 h

*until functional strength
at rt approx. +23 °C
tensile shear strength > 10 MPa*

8 h

*until final strength
at rt approx. +23 °C*

168 h

Processing

Mixing ratio A : B - volume

2 : 1

Mixing ratio A : B - weight

7 : 3

Processing time after mixing

*in 100 g batch
at rt approx. +23 °C*

18 min

Storage life in unopened original container

*up to <= 1 l
at +15 °C to +30 °C*

9 month(s)

at +15 °C to +30 °C

6 month(s)

Technical properties

Color in cured condition in 1 mm layer thickness

gray

Density of component A

1.32 g/cm³

Density of component B 1.13 g/cm³

Parameters

Viscosity 150000 mPa·s
Component A | liquid | Viscosimeter

Viscosity 50000 mPa·s
Component B | liquid | Viscosimeter

Tensile shear strength 18 MPa
*Based on DIN EN 1465 | **Al | Al** | Pretreatment: sand-blasted | at approx. +23 °C | 24 h*

Peel resistance 3 N/mm
*DELO Standard 38 | **Steel | Steel** | Pretreatment: sand-blasted | at approx. +23 °C | 7 d*

Tensile strength 36 MPa
Based on DIN EN ISO 527 | at approx. +23 °C | 7 d

Elongation at tear 2 %
Based on DIN EN ISO 527 | at approx. +23 °C | 7 d

Young's modulus 2400 MPa
Based on DIN EN ISO 527 | at approx. +23 °C | 7 d

Shore hardness D 77
Based on DIN EN ISO 868 | at approx. +23 °C | 7 d

Glass transition temperature 54 °C
DELO Standard 24 | Rheometer | at approx. +23 °C | 7 d

Coefficient of linear expansion 102 ppm/K
DELO Standard 26 | TMA | Evaluation T: 30 °C - 50 °C | at approx. +23 °C | 7 d

Coefficient of linear expansion 172 ppm/K
DELO Standard 26 | TMA | Evaluation T: 80 °C - 160 °C | at approx. +23 °C | 7 d

Shrinkage 4 vol. %
DELO Standard 13 | at approx. +23 °C | 7 d

Water absorption 0.22 wt. %
Based on DIN EN ISO 62 | Layer thickness: 4 mm | at approx. +23 °C | 7 d | Type of storage: Media | Medium: Distilled water | Storage temperature: at approx. +23 °C | Duration: 24 h

Decomposition temperature 253 °C
DELO Standard 36 | at approx. +23 °C | 7 d

Volume resistivity >1xE15 Ohm·cm

Surface resistance	>1xE15	Ohm
Dielectric strength <i>Based on DIN EN 60243-2</i>	18	kV/mm
Creep resistance CTI <i>Based on DIN EN 60112</i>	300	
Relative permittivity <i>Based on DIN 53483-2 1 kHz</i>	4.4	
Relative permittivity <i>Based on DIN 53483-2 1 MHz</i>	3.6	
Relative permittivity <i>Based on DIN 53483-2 100 kHz</i>	3.9	

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.

Nothing contained herein shall be construed to indicate the non-existence of any relevant patents or to constitute a permission, encouragement or recommendation to practice any development covered by any patents, without permission of the owner of this patent.

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