

### **DELO-MONOPOX® 6095**

#### **Base**

- epoxy casting resin
- one-component, heat-curing, unfilled, low chloride ion content

#### **Use**

- for the casting, coating and fixing of components and assembly groups
- especially for the use in electronics
- excellent chemical resistance
- the product is normally used in a temperature range of -40 °C to +130 °C; depending on the application, other limits may be more reasonable
- compliant with RoHS directive 2002/95/EC

#### **Processing**

- to heat the components, increased temperatures can be used, as well
- the heating time of the components must be added to the actual curing time
- for curing, the inside of the adhesive layer must have the required temperature
- depending on the adhesive amount used, exothermic reaction heat is developed which can lead to overheating; in this case, the curing temperature must be reduced accordingly
- the adhesive is supplied ready for use and can be processed well from the original container or with DELO dispensing units
- the surfaces to be bonded must be dry as well as free of dust, grease and other contaminations
- use DELOTHEN cleaners for the cleaning of bonding surfaces
- adhesion to the components can be improved by sand blasting, grinding or pickling

#### **Curing**

- curing proceeds at temperatures between +100 and +130 °C
- increased temperatures shorten the curing process, lower temperatures extend it, and can change the properties of the cured product

#### **Technical data**

Color	black
Density [g/cm <sup>3</sup> ] DELO Standard 13 at room temperature (approx. 23 °C)	1.2
Viscosity [mPas] at 23 °C, Brookfield rpm 7/5	50000
Processing time at room temperature (max. 25 °C)	6 weeks
Curing time until final strength [min] at 130°C in a convection oven	30

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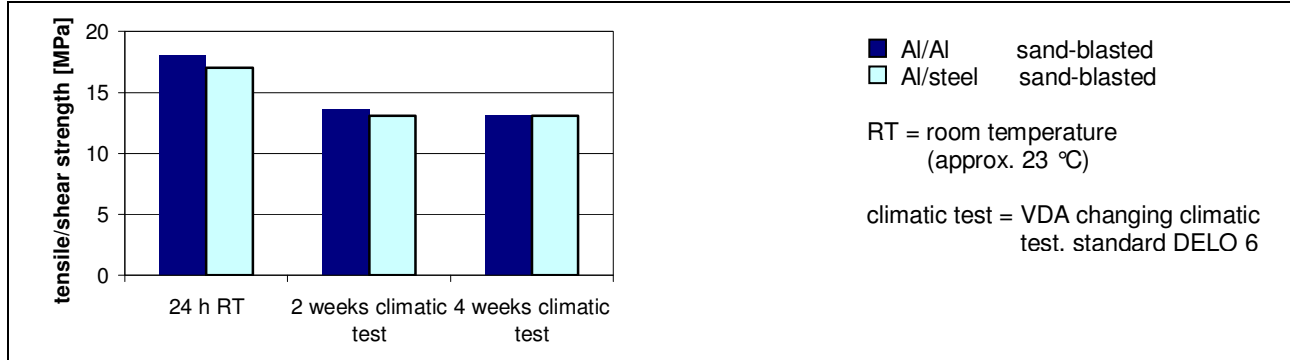
## Tensile shear strength Al/Al [MPa]

DIN EN 1465, sand-blasted  
component thickness: 1.6 mm  
after 30 min at +130 °C

18

## Tensile shear strength

DIN EN 1465, sand-blasted  
component thickness: 1.6 mm  
curing: 30 min at +150 °C



## Compression shear strength PETP/PETP [MPa]

DELO Standard 5  
after 30 min at +130 °C

13

## Tensile strength [MPa]

according to DIN EN ISO 527  
layer thickness: 2 mm  
after 30 min at +130 °C

45

## Elongation at tear [%]

according to DIN EN ISO 527  
layer thickness: 2 mm  
after 30 min at +130 °C

1.2

## Young's modulus [MPa]

according to DIN EN ISO 527  
layer thickness: 2 mm  
after 30 min at +130 °C

3800

## Shore hardness D

according to DIN EN ISO 868  
after 30 min at +100 °C

83

## Decomposition temperature [°C]

DELO Standard 36

300

## Glass transition temperature [°C]

rheometer

87

## Coefficient of linear expansion [ppm/K]

TMA, in a temperature range of +25 to +140 °C

117

## Coefficient of linear expansion [ppm/K]

TMA, in a temperature range of +30 to +70 °C

65

## Coefficient of linear expansion [ppm/K]

TMA, in a temperature range of +110 to +160 °C

183

## Shrinkage [vol. %]

DELO Standard 13

2.0

## Water absorption [weight %]

according to DIN EN ISO 62  
after 30 min at +100 °C

0.1

Thermal conductivity [W/m·K] DIN V 54462 at room temperature (approx. 23 °C)	0.2
Specific volume resistance [ $\Omega\text{cm}$ ] VDE 0303, part 3, after 30 min at +130 °C	>1x $E13$
Surface resistance [ $\Omega$ ] VDE 0303, part 3, after 30 min at +130 °C	>1x $E12$
Creep resistance CTI VDE 0303, part 1, IEC 112, after 30 min at +130 °C	100 M
Storage life at 0 °C to +8 °C in unopened original container	6 months

### Performance under chemical influence

compression shear strength after storage for 1,000 h  
based on initial value at room temperature  
measured at room temperature (approx. 23 °C)  
according to DELO Standard 5

Chemical medium	Compression/shear strength AI/AI [%]
acetone	92
ethanol denatured	121
ethanol 70 % denatured	96
ATF gear oil	121
petrol	132
diesel fuel	132
engine oil 10W40	131
demineralised water / glykol mixture 50:50	79
demineralised water	75

## **Instructions and advice**

### 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.

Many product properties are subject to temperature and may change permanently, especially at high temperatures.

It is the user's responsibility to test the suitability of the product for the intended purpose and temperature range of use by considering all specific requirements. Type and 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.

### Instructions for use

The instructions for use of DELO-MONOPOX are available on: [www.DELO.de](http://www.DELO.de). We will be pleased to send them to you on demand.

### Occupational health and safety

see material safety data sheet

### Specification

see quality assurance test report