

DELO-DUOPOX® 03 RAPID

Base

- epoxy resin
- two-part
- product free of nonylphenol

Use

- universally usable adhesive
- in machine and equipment manufacture
- in electrical engineering and electronics
- also for repairs and in the do-it-yourself sector
- fast reach of the initial strength

Processing

- components A and B must be mixed well or homogenised according to beneath stated mixing ratio
- supplied ready to use and best applied from the original container
- special advantage in using the DELO-AUTOMIX system, see selection chart about DELO-AUTOMIX system
- surfaces to be bonded should be dry, free from dust, grease and other contaminants
- DELOTHEN cleaners are recommended for cleaning

Curing

- at room temperature
- very fast reaction
- higher temperatures accelerate curing

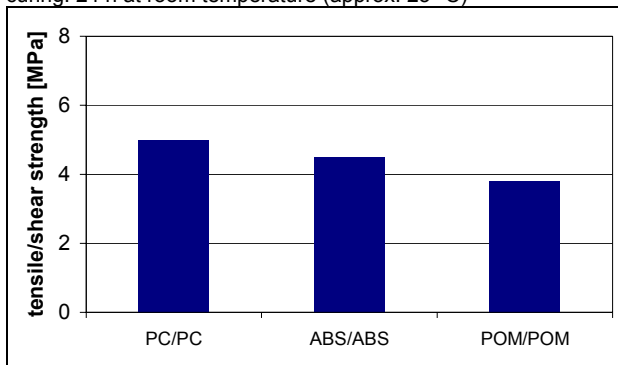
Technical data

Color	yellowish transparent
filler	not filled
mixing ratio (A : B) by weight	1 : 1
(A : B) by volume	1 : 1
Density [g/cm ³] mixture at room temperature (ca. 23 °C)	1.16
viscosity component A [mPas] brookfield at 23 °C	13000
viscosity component B [mPas] brookfield at 23 °C	18000

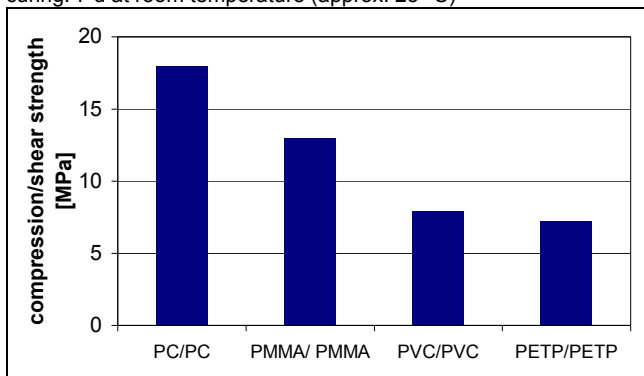
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viscosity mixture [mPas] brookfield at 23 °C	15000
pot life in 3 g preparation [min] DIN EN 14022, at 23°C	4
processing time in 3 g preparation [min] at room temperature (approx. 23 °C)	3
maximum reaction temperature [°C] in 20 g preparation	140
Curing time until firmness to touch [min] Tensile shear strength 1 - 2 MPa	11
curing time until functional strenght [h] tensile/shear strenght > 10 MPa	2
Curing time until final strength [h] at room temperature (approx. 23 °C)	24
Curing time until final strength [min] at +80 °C	40
Tensile shear strength Al/Al [MPa] DIN EN 1465, sand-blasted join part thickness: 1.6 mm after 24 h at room temperature (approx. 23 °C)	13
Tensile shear strength Al/Al [MPa] DIN 54451, sand-blasted join part thickness: 6 mm after 72 h at room temperature (approx. 23 °C)	16

tensile/shear strength
DIN EN 1465
curing: 24 h at room temperature (approx. 23 °C)



compression/shear strength
standard DELO 5
curing: 7 d at room temperature (approx. 23 °C)



floating roller peel resistance St/St [N/mm] DIN 53289 according to EN 1465, sand-blasted join part thickness: 1.5 mm	3
temperature stability Al/Al at +100 °C [MPa] DIN 53286, sand-blasted join part thickness: 1.6 mm	1
tensile strength [MPa] DIN EN ISO 527	31
elongation at tear [%] DIN EN ISO 527	19
Young modulus [MPa] DIN EN ISO 527	2000
shore hardness D DIN 53505	75
indentation hardness [MPa] ISO 2039, part 1	83
coefficient of elongation [ppm/K] TMA, in a temperature range of +30 to +140 °C	242
water absorption [weight %] DIN EN ISO 62, 24 h at room temperature (approx. 23 °C)	1.0
chemical stability	very good
Recommended long-term temperature range of use [°C]	-40 to +80
temperature resistance [°C]	280
Specific volume resistance [Ωcm] VDE 0303, part 3	1.5xE13
surface resistance [Ω] VDE 0303, part 3	4xE11
Dielectric strength [kV/mm] VDE 0303, part 2	18
Dielectric constant VDE 0303, part 4	2.9
creep resistance CTI VDE 0303, part 1, IEC 112	> 600 M
Storage life at room temperature (approx. 23 °C) in unopened original container	12 months

Instructions and advice

General

The data and information provided are based on tests performed under laboratory conditions. Reliable information about the behaviour of the product under practical conditions and its suitability for a specific purpose cannot be concluded from this.

It is the user's responsibility to test the suitability of the product for the intended purpose 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 behaviour of the product compared to its behaviour 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 are available on: 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