

DELO-DUOPOX® 03 RAPID THIX

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

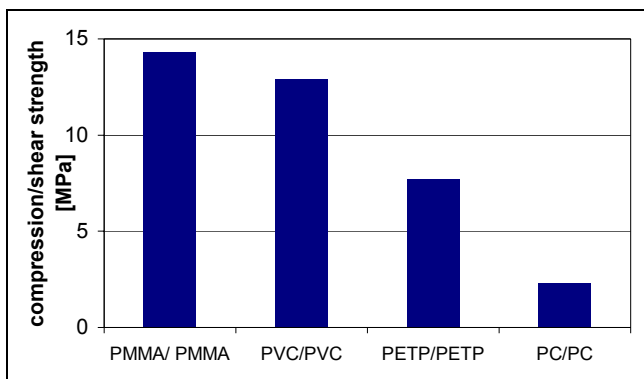
- at room temperature
- very fast reaction
- higher temperatures accelerate curing

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)	1.17
viscosity component A [mPas] brookfield at 23 °C	50000 thix
viscosity component B [mPas] brookfield at 23 °C	36000 thix

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viscosity mixture [mPas] brookfield at 23 °C	38000 thix
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	130
Curing time until firmness to touch [min] Tensile shear strength 1 - 2 MPa	13
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	60
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)	17
compression/shear strength standard DELO 5 curing: 7 d at room temperature (approx. 23 °C)	



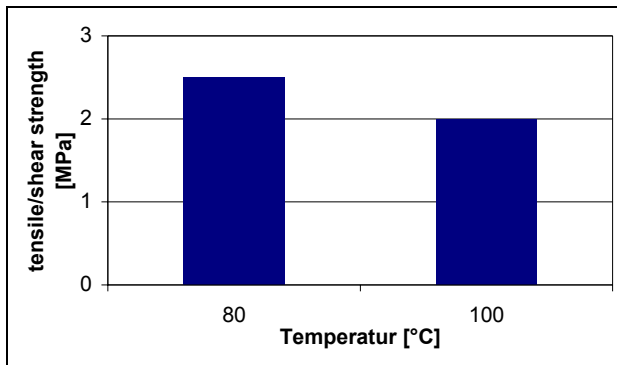
floating roller peel resistance St/St [N/mm] DIN 53289 according to EN 1465, sand-blasted join part thickness: 1.5 mm	2.5
temperature stability Al/Al at +100 °C [MPa] DIN 53286, sand-blasted join part thickness: 1.6 mm	2

temperature stability Al/Al

DIN EN 1465, sand-blasted

join part thickness: 1.6 mm

curing: 7 d at room temperature (approx. 23 °C)



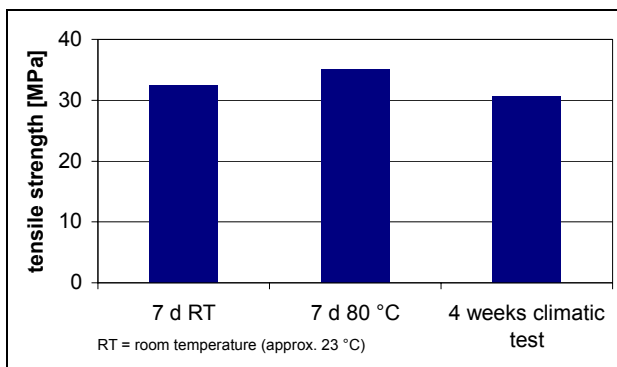
tensile strength [MPa]

DIN EN ISO 527

35

tensile strength

DIN EN ISO 527



elongation at tear [%]

DIN EN ISO 527

20

Young modulus [MPa]

DIN EN ISO 527

2000

shore hardness D

DIN 53505

75

indentation hardness [MPa]

ISO 2039, part 1

96

coefficient of elongation [ppm/K]

TMA, in a temperature range of +30 to +140 °C

224

water absorption [weight %]

DIN EN ISO 62, 24 h at room temperature (approx. 23 °C)

1.1

chemical stability

very good

Recommended long-term temperature range of use [°C]

-40 to +80

temperature resistance [°C]

280

Specific volume resistance [Ω cm]

VDE 0303, part 3

2.4xE12

surface resistance [Ω]

VDE 0303, part 3

1.5xE13

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	525 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