

### **DELO-DUOPOX® AD821**

#### **Base**

- epoxy resin
- two-part, unfilled, flexible
- product free of nonylphenol

#### **Use**

- universally useable
- for machine and equipment manufacture
- for electrical engineering and electronics
- good flow properties

#### **Curing**

- at room temperature
- increased temperatures accelerate curing

#### **Processing**

- components A and B must be mixed well or homogenized in the mixing ratio stated below until the preparation is free of streaks
- supplied ready for use and can be applied well from the original container
- 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

#### **Technical data**

Color	yellowish transparent
Filler	not filled
Mixing ratio (A : B) according to volume	0.5 : 1
(A : B) according to weight	0.58 : 1
Density mixture at room temperature (ca. 23 °C)	1,08
Viscosity of component A [mPas] at 23 °C, rheometer	65000
Viscosity of component B [mPas] at 23 °C, rheometer	19000
Viscosity of mixture [mPas] at 23 °C, rheometer	21000
Pot life in 100 g preparation [min] DIN EN 14022, at 23 °C	30

DELO Industrial Adhesives  
DELO-Allee 1 · D-86949 Windach  
Phone +49 8193 9900-0  
Fax +49 8193 9900-144  
E-Mail [info@DELO.de](mailto:info@DELO.de) · [www.DELO.de](http://www.DELO.de)

Processing time in 100 g preparation [min] at 23 °C	20
Max. reaction temperature [°C] in 100 g preparation	69
Curing time until firmness to touch [h] tensile shear strength 1 - 2 MPa	5.5
Curing time until functional strength [h] tensile shear strength > 10 MPa	24
Curing time until final strength [d] at room temperature (approx. 23 °C)	7
Tensile shear strength Al/Al [MPa] DIN EN 1465, sand-blasted component thickness: 1.6 mm after 7d at room temperature (ca. 23 °C)	14
Floating roller peel resistance St/St [N/mm] DELO-Norm 38, sand-blasted join part thickness: 1.5 mm curing: 7 d at room temperature (approx. 23 °C)	4
Tensile strength [MPa] DIN EN ISO 527	10
Elongation at tear [%] DIN EN ISO 527	60
Young's modulus [MPa] DIN EN ISO 527	114
Shore hardness D DIN EN ISO 868 Curing: 7 d at room temperature	50
Coefficient of linear expansion [ppm/K] TMA, in a temperature range of +30 to +140 °C	149
Water absorption [%] according to DIN EN ISO 62, 7 d at room temperature (approx. 23°C)	0,63
Specific volume resistance [Ωcm] VDE 0303, part 3	6,07xE14
Creep resistance CTI VDE 0303, part 1, IEC 112	> 600 M
Storage life at room temperature (approx. 23 °C) in unopened original container	6 months

## **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.

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 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 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