

DELO-DUOPOX® AD894

Base

- epoxy resin
- two-component
- product is free of nonylphenol

Use

- high-strength construction adhesive
- multi-purpose
- good flowing behavior
- also suitable for small castings

Processing

- components A and B must be mixed well or homogenized in the mixing ratio stated below
- supplied ready for use and can be processed well from the original container
- using the DELO-AUTOMIX system for processing is especially advantageous, see selection chart "DELO-AUTOMIX system"
- 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

Curing

- at room temperature
- increased temperatures accelerate curing

Technical data

Color	black
Filler	minerals
Mixing ratio (A : B) according to weight	7 : 3
(A : B) according to volume	2 : 1
Density [g/cm ³] mixture at room temperature (ca. 23 °C)	1.31
Viscosity of component A [mPas] Brookfield at 23 °C	45000
Viscosity of component B [mPas] Brookfield at 23 °C	20000
Viscosity of mixture [mPas] Brookfield at 23 °C	16000

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Pot life in 100 g preparation [min] DIN EN 14022, at 23 °C	26
Processing time in 100 g preparation [min] at 23 °C	45
Maximal reaction temperature [°C] in 100 g preparation	98
Curing time until firmness to touch [h] tensile shear strength 1 - 2 MPa	5
Curing time until functional strength [h] tensile shear strength > 10 MPa	7
Curing time until final strength [h] at room temperature (approx. 23 °C)	24
Tensile shear strength Al/Al [MPa] DIN EN 1465, sand-blasted component thickness: 1.6 mm curing: 7 d at room temperature (approx. 23 °C)	19
Tensile shear strength Al/Al [MPa] DIN 54451, sand-blasted component thickness: 6 mm curing: 7 d at room temperature (approx. 23 °C)	31
Floating roller peel resistance St/St [N/mm] DIN 53289 according to EN 1464 join part thickness: 1.5 mm curing: 7 d room temperature (approx. 23 °C)	2
Tensile strength [MPa] DIN EN ISO 527	41
Elongation at tear [%] DIN EN ISO 527	2.1
Young's modulus [MPa] DIN EN ISO 527	2300
Shore hardness D DIN 53505	73
Glass transition temperature [°C] rheometer	63
Coefficient of linear expansion [ppm/K] TMA, in a temperature range of +30 to +50 °C	91
Coefficient of linear expansion [ppm/K] TMA, in a temperature range of +70 to +150 °C	178
Shrinkage [vol. %] DELO Standard 13	3.6
Water absorption [weight %] DIN EN ISO 62, 24 h at room temperature (approx. 23 °C)	0.3
Chemical resistance	very good
Recommended long-term temperature range of use [°C]	-40 to +140
Temperature resistance [°C]	215
Specific volume resistance [Ω cm] VDE 0303, part 3	1.2xE18

Surface resistance [Ω] VDE 0303, part 3	5.1xE13
Dielectric strength [kV/mm] DIN IEC 60243-1 at 50 Hz	14.3
Dielectric constant RF-IV method, 1 MHz	4.0
Dielectric constant RF-IV method, 10 MHz	4.0
Dielectric constant RF-IV method, 100 MHz	3.9
Dielectric constant RF-IV method, 1 GHz	3.7
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 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 of DELO-DUOPOX 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