

DELO-DUOPOX® AD895

Base

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

Use

- high strength construction adhesive
- universally usable
- has been tested for its biocompatibility and fulfils the requirements according to ISO 10993-5: test for cytotoxicity

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
- tested in dependence at UL 94 HB

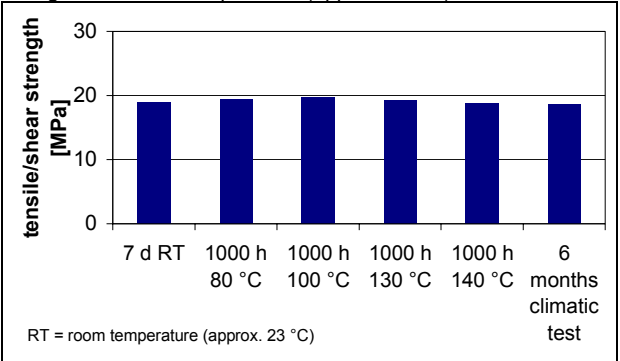
Curing

- at room temperature
- higher temperatures accelerate curing

Technical data

Color	grey
filler	minerals
mixing ratio (A : B) by weight	7 : 3
(A : B) by volume	2 : 1
density component A [g/cm ³] at room temperature (approx. 23°C)	1.37
density component B [g/cm ³] at room temperature (approx. 23°C)	1.19
viscosity component A [mPas] brookfield at 23 °C	100000
viscosity component B [mPas] brookfield at 23 °C	95000

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pot life in 100 g preparation [min] DIN EN 14022, at 23 °C	25														
processing time in 100 g preparation [min] at 23 °C	30														
maximum reaction temperature [°C] in 100 g preparation	98														
Curing time until firmness to touch [h] Tensile shear strength 1 - 2 MPa	5.5														
curing time until functional strenght [h] tensile/shear strenght > 10 MPa	8														
Curing time until final strength [h] at room temperature (approx. 23 °C)	24														
Tensile shear strength Al/Al [MPa] DIN EN 1465, sand-blasted join part thickness: 1.6 mm curing: 7 d at room temperature (approx. 23 °C)	19														
Tensile shear strength Al/Al DIN EN 1465, sand-blasted join part thickness: 1.6 mm curing: 7 d at room temperature (approx. 23 °C)															
 <table border="1"> <caption>Tensile/shear strength [MPa] vs. Curing Conditions</caption> <thead> <tr> <th>Curing Condition</th> <th>Tensile/shear strength [MPa]</th> </tr> </thead> <tbody> <tr> <td>7 d RT</td> <td>~19</td> </tr> <tr> <td>1000 h 80 °C</td> <td>~19</td> </tr> <tr> <td>1000 h 100 °C</td> <td>~19</td> </tr> <tr> <td>1000 h 130 °C</td> <td>~19</td> </tr> <tr> <td>1000 h 140 °C</td> <td>~19</td> </tr> <tr> <td>6 months climatic test</td> <td>~19</td> </tr> </tbody> </table> <p>RT = room temperature (approx. 23 °C)</p>		Curing Condition	Tensile/shear strength [MPa]	7 d RT	~19	1000 h 80 °C	~19	1000 h 100 °C	~19	1000 h 130 °C	~19	1000 h 140 °C	~19	6 months climatic test	~19
Curing Condition	Tensile/shear strength [MPa]														
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1000 h 100 °C	~19														
1000 h 130 °C	~19														
1000 h 140 °C	~19														
6 months climatic test	~19														
Tensile shear strength Al/Al [MPa] DIN 54451, sand-blasted join part thickness: 6 mm curing: 7 d room temperature (approx. 23 °C)	32														
tensile strength [MPa] DIN EN ISO 527	40														
elongation at tear [%] DIN EN ISO 527	2														
Young modulus [MPa] DIN EN ISO 527	2400														
shore hardness D DIN 53505	73														
glass transition temperature [°C] rheometer	66														
coefficient of elongation [ppm/K] TMA, in a temperature range of +30 to +50 °C	88														
coefficient of elongation [ppm/K] TMA, in a temperature range of +70 to +150 °C	178														
water absorption [weight %] DIN EN ISO 62, 24 h at room temperature (approx. 23 °C)	0.25														

chemical stability	very good
Recommended long-term temperature range of use [°C]	-40 to +140
temperature resistance [°C]	200
Specific volume resistance [Ωcm] VDE 0303, part 3	2.1xE16
surface resistance [Ω] VDE 0303, part 3	9.1xE13
Dielectric strength [kV/mm] DIN IEC 60243-1 at 50 Hz	13.7
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 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