

DELO-MONOPOX® MG063

Base

- epoxy casting resin
- one-part, heat curing, not filled

Use

- at temperatures between +100 and +150 °C
- higher temperatures accelerate, lower temperatures prolong curing process and may change the properties of cured product
- good tough-elastic characteristics
- for bonding of heat resistant plastics

Processing

- to heat components, higher temperatures can also be used
- the heating time for components has to be added to the actual curing time
- for curing, the inside of the adhesive layer has to have the required temperature
- development of an exothermal reaction heat depends on the adhesive quantity used thus, overheating may occur, in this case the curing temperature has to be reduced accordingly
- the resin is supplied ready-to-use and best applied from the original container or with DELO dispensing units
- surfaces to be bonded should be dry, free from dust, grease and other contaminants
- DELOTHEN cleaners are recommended for cleaning
- adherence can be improved by sand-blasting, grinding or pickling

Curing

- at temperatures between +100 and +150 °C
- higher temperatures accelerate, lower temperatures prolong curing process and may change the properties of cured product

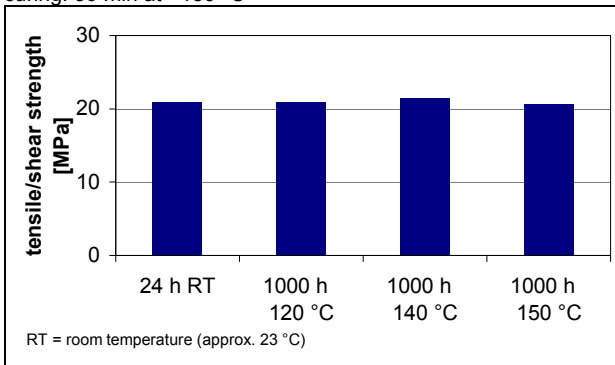
Technical data

Color	black
Density [g/cm ³] at room temperature (approx. 23 °C)	1.2
Viscosity [mPas] at 23 °C, Brookfield sp/r 7/5	180000 thix
Curing time until final strength [min] at +150 °C	30
Tensile shear strength Al/Al [MPa] DIN EN 1465, sand-blasted join part thickness: 1.6 mm after 30 min at +150 °C	21

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Tensile shear strength Al/Al

DIN EN 1465, sand-blasted
join part thickness: 1.6 mm
curing: 30 min at +150 °C



temperature stability Al/Al at +150 °C [MPa]

2.5

DIN 53286, sand-blasted
join part thickness: 1.6 mm

tensile strength [MPa]

35

DIN EN ISO 527, after 30 min at +150 °C

elongation at tear [%]

1.0

DIN EN ISO 527, after 30 min at +150 °C

Young modulus [MPa]

3000

DIN EN ISO 527, after 30 min at +150 °C

shore hardness D

80

corresponding to DIN 53505

glass transition temperature [°C]

113

rheometer

coefficient of elongation [ppm/K]

71

between +30 and +80 °C

coefficient of elongation [ppm/K]

188

between +100 and +160 °C

water absorption [weight %]

0.2

DIN EN ISO 62

chemical stability

good

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

-40 to 160

temperature resistance [°C]

200

ion content Na+ [ppm]

< 10

extraction

ion content K+ [ppm]

< 10

extraction

ion content Cl- [ppm]

< 10

extraction

ion content F- [ppm]

< 10

extraction

Specific volume resistance [Ω cm]

>0.3xE16

VDE 0303, part 3

surface resistance [Ω]

3.5xE12

VDE 0303, part 3

Dielectric strength [kV/mm] VDE 0303, part 2	21.8
Dielectric constant VDE 0303, part 4	4.3
creep resistance CTI VDE 0303, part 1, IEC 112	200 M
Storage life at room temperature (approx. 23 °C) in unopened original container	4 weeks
Storage life at approx. +5 °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 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 instruction for use is available under following address: www.DELO.de. If requested we will also be pleased to send it to you.

Occupational health and safety

see material safety data sheet

Specification

see quality assurance test report