

DELO-DUOPOX® 6823

Base

- epoxy casting resin
- two-part, not filled, elastic

Use

- casting applications in electronics
- equalizing, very flexible
- extremely liquid, low exothermia

Application

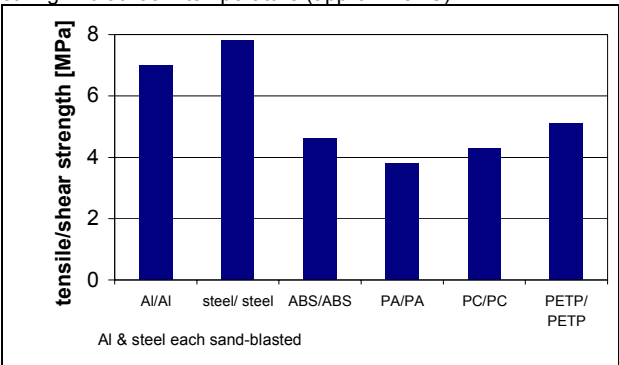
- components A and B must be mixed well or homogenised according to beneath stated mixing ratio
- supplied ready to use and best applied from the original container
- surfaces to be bonded should be dry, free from dust, grease and other contaminants
- DELOTHEN cleaners are recommended for cleaning

Curing

- at room temperature
- higher temperatures accelerate curing

Technical data

colour	yellowish
filler	not filled
mixing ratio (A : B) by weight	5 : 2
(A : B) by volume	13 : 6
density [g/cm ³] mixture at room temperature (ca. 23 °C)	1.09
viscosity component A [mPas] brookfield at 23 °C	700
viscosity component B [mPas] brookfield at 23 °C	70
viscosity mixture [mPas] brookfield at 23 °C	160
pot life in 100 g preparation [min] DIN EN 14022, at 23 °C	45
pot life in 1 kg preparation [min] DIN EN 14022, at 23 °C	45

processing time in 100 g preparation [min] at 23 °C	110														
maximum reaction temperature [°C] in 100 g preparation	40														
maximum reaction temperature [°C] in 1 kg preparation	150														
curing time until final strength [h] at room temperature (approx. 23 °C)	48														
tensile/shear strength Al/Al [MPa] DIN En 1465, sand-blasted join part thickness: 1.6 mm	7														
tensile/shear strength DIN EN 1465 curing: 7 d at room temperature (approx. 23 °C)															
 <table border="1"> <caption>Tensile/Shear Strength Data from Chart</caption> <thead> <tr> <th>Material Combination</th> <th>Tensile/Shear Strength [MPa]</th> </tr> </thead> <tbody> <tr> <td>Al/Al</td> <td>7.0</td> </tr> <tr> <td>steel/steel</td> <td>7.8</td> </tr> <tr> <td>ABS/ABS</td> <td>4.6</td> </tr> <tr> <td>PA/PA</td> <td>3.8</td> </tr> <tr> <td>PC/PC</td> <td>4.3</td> </tr> <tr> <td>PETP/PETP</td> <td>5.1</td> </tr> </tbody> </table>		Material Combination	Tensile/Shear Strength [MPa]	Al/Al	7.0	steel/steel	7.8	ABS/ABS	4.6	PA/PA	3.8	PC/PC	4.3	PETP/PETP	5.1
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tensile strength [MPa] DIN EN ISO 527	4														
elongation at tear [%] DIN EN ISO 527	70														
Young modulus [MPa] DIN EN ISO 527	< 10														
shore hardness D DIN 53505	22														
indentation hardness [MPa] ISO 2039, part 1	not measurable														
glass transition temperature [°C] rheometer	37														
coefficient of elongation [ppm/K] TMA, in a temperature range of +30 to +140 °C	210														
shrinkage [vol. %] standard DELO 13	1 - 2														
water absorption [weight %] DIN EN ISO 62, 24 h at room temperature (approx. 23 °C)	0.4														
chemical stability	very good														
recommended long-time temperature range of use [°C]	-40 to +120														
short-time temperature of use [°C]	+200														
specific volume resistance [Ω cm] VDE 0303, part 3	6.0xE11														

surface resistance [Ω] VDE 0303, part 3	1.9E11
breakdown voltage [kV/mm] VDE 0303, part 2	20
dielectric constant VDE 0303, part 4	3.6
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

Recommendations

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.

Instruction 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.

Industrial health and safety standards

see material safety data sheet

Specification

see quality assurance certificate