

DELO-MONOPOX® AD066

Base

- epoxy resin, construction adhesive
- one-component, heat-curing, unfilled

Use

- for the fixing and bonding of metal, temperature-resistant plastic and rubber
- for fast and high-strength connections with good thermal and chemical resistance

Processing

- to heat the components, increased temperatures can be used, as well
- the heating time of the components must be added to the actual curing time
- for curing, the inside of the adhesive layer must have the required temperature
- depending on the adhesive amount used, exothermic reaction heat is developed which can lead to overheating; in this case, the curing temperature must be reduced accordingly
- the adhesive is supplied ready for use and can be processed well from the original container or with DELO dispensing units
- 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
- adhesion to the components can be improved by sand blasting, grinding or pickling

Curing

- curing proceeds at temperatures between +120 and +150 °C
- increased temperatures shorten the curing process, lower temperatures extend it, and can change the properties of the cured product

Technical data

Color
cured

beige

Density [g/cm³]
at room temperature (approx. 23 °C)

1.2

Viscosity [mPas]
at 23 °C, rheometer, shear rate 10 1/s

20000

Curing time until final strength [min]
at +130 °C

20

Tensile shear strength Al/Al [MPa]
DIN En 1465, sand-blasted
component thickness: 6 mm

35

Tensile strength [MPa]
DIN EN ISO 527, after 20 min at +130 °C

50

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Elongation at tear [%] DIN EN ISO 527, after 20 min at +130 °C	2.5
Young's modulus [MPa] DIN EN ISO 527, after 20 min at +130 °C	2900
Shore hardness D	83
Glass transition temperature [°C] rheometer	132
Coefficient of linear expansion [ppm/K] in a temperature range of +30 to +70 °C	62
Water absorption [weight %] according to DIN EN ISO 62, 24 h at room temperature (approx. 23 °C)	0.2
Recommended long-term temperature range of use [°C]	-40 to +150
Short-term temperature of use [°C]	+180
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 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-MONOPOX 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