

DELO DUALBOND SJ2718

modified epoxy resin | 1C | light-fixable / heat-curing

free of solvents | light-fixable

Special features of product

- halogen-free according to IEC 61249-2-21
- compliant with RoHS Directive 2015/863/EU

Typical area of use

- -40 - 180 °C

Curing

Suitable lamp types LED 365 nm, LED 400 nm

Recommended light fixation time

*intensity 100 mW/cm²
LED 400 nm* 1 - 5 s

Recommended curing time

*at +130 °C
in air convection oven* 20 min

Processing

Conditioning time (typical)

*stored at 0 °C to +10 °C
in containers up to 170 ml* 2 h

Processing time

in standard climate +23 °C / 50 % r. h. 21 d

Storage life in unopened original container

*up to <= 180 ml
at 0 °C to +10 °C* 6 month(s)

Technical properties

Color in cured condition in 1 mm layer thickness beige

Transparency in cured condition in 1 mm layer thickness opaque

Parameters

Density <i>Based on DIN 66137-2 Liquid</i>	1.23	g/cm ³
Viscosity <i>Based on DIN EN 12092 Liquid Rheometer Shear rate: 10 1/s</i>	24000	mPa·s
Tensile shear strength <i>Based on DIN EN 1465 Al Al Pretreatment: sand-blasted 130 °C 20 min</i>	20	MPa
Compression shear strength <i>DELO Standard 5 Al Al 130 °C 20 min</i>	60	MPa
Compression shear strength <i>DELO Standard 5 PPS PPS 130 °C 20 min</i>	27	MPa
Compression shear strength <i>DELO Standard 5 Al Al 90 °C 120 min</i>	58	MPa
Compression shear strength <i>DELO Standard 5 PA6 PA6 130 °C 20 min</i>	30	MPa
Compression shear strength <i>DELO Standard 5 PBT PBT 130 °C 20 min</i>	18	MPa
Tensile strength <i>Based on DIN EN ISO 527 130 °C 20 min</i>	66	MPa
Elongation at tear <i>Based on DIN EN ISO 527 130 °C 20 min</i>	2.7	%
Young's modulus <i>DMTA 130 °C 20 min</i>	4000	MPa
Shore hardness D <i>Based on DIN EN ISO 868 130 °C 20 min</i>	85	
Glass transition temperature <i>DMTA 130 °C 20 min</i>	126	°C
Coefficient of linear expansion <i>DELO Standard 26 TMA Evaluation T: 30 °C - 90 °C 130 °C 20 min</i>	68	ppm/K
Coefficient of linear expansion <i>DELO Standard 26 TMA Evaluation T: 115 °C - 180 °C 130 °C 20 min</i>	175	ppm/K

Shrinkage 3 vol. %
DELO Standard 13 | 130 °C | 20 min

Water absorption 0.2 wt. %
Based on DIN EN ISO 62 | 130 °C | 20 min

Dielectric strength 17 kV/mm
Based on DIN EN 60243-1 | 130 °C | 20 min

Comparative tracking index M 550
Based on DIN IEC 60112

Converting table

°F = (°C x 1.8) + 32 1 MPa = 145.04 psi
 1 inch = 25.4 mm 1 GPa = 145.04 ksi
 1 mil = 25.4 µm 1 cP = 1 mPa·s
 1 oz = 28.3495 g 1 N = 0.225 lb

General curing and processing information

The curing time stated in the technical data was determined in the laboratory. It can vary depending on the adhesive quantity and component geometry and is therefore a reference value. The heating time of the components must be added to the actual curing time. It depends on component size and oven type. The specified curing temperature must be reached directly at the adhesive. Increasing or decreasing the curing temperature and / or irradiation intensity shortens or prolongs the curing time and can lead to changed physical properties. Depending on the adhesive quantity used, exothermic reaction heat is generated which can lead to overheating. In this case, a lower curing temperature is to be selected. Values measured after 24 h at approx. 23 °C / 50 % r.h., unless otherwise specified.

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 customer's responsibility to test the suitability of a product for the intended purpose by considering all specific requirements and by applying standards the customer deems suitable (e. g. DIN 2304-1). Type, 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. Nothing contained herein shall be construed to indicate the non-existence of any relevant patents or to constitute a permission, encouragement or recommendation to practice any development covered by any patents, without permission of the owner of this patent. All products provided by DELO are subject to DELO's General Terms of Business. Verbal ancillary agreements are deemed not to exist.

Instructions for use

The instructions for use are available on www.DELO-adhesives.com. We will be pleased to send them to you on demand.

Occupational health and safety

See material safety data sheet.

Specification

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