

# DELO-DUOPOX AD895

## modified epoxy resin | 2C | room-temperature-curing

pasty, filled | suitable for DELO-AUTOMIX

### Special features of product

- compliant with RoHS Directive 2015/863/EU
- tested for biocompatibility and meets the requirements according to DIN EN ISO 10993-5: test for cytotoxicity

### Function

- construction adhesive

### Typical area of use

- -40 - 140 °C

### Curing

Curing time

*until initial strength  
at rt approx. +23 °C  
tensile shear strength 1 - 2 MPa*

5.5 h

*until functional strength  
at rt approx. +23 °C  
tensile shear strength > 10 MPa*

8 h

*until final strength  
at rt approx. +23 °C*

24 h

### Processing

Mixing ratio A : B - volume

2 : 1

Mixing ratio A : B - weight

7 : 3

Processing time after mixing

*in 100 g batch  
at rt approx. +23 °C*

30 min

Reaction temperature (max.)

*in 100 g batch*

98 °C

Storage life in unopened original container

up to <= 1 l per component at +15 °C to +30 °C	12	month(s)
at +15 °C to +30 °C	6	month(s)

**Technical properties**

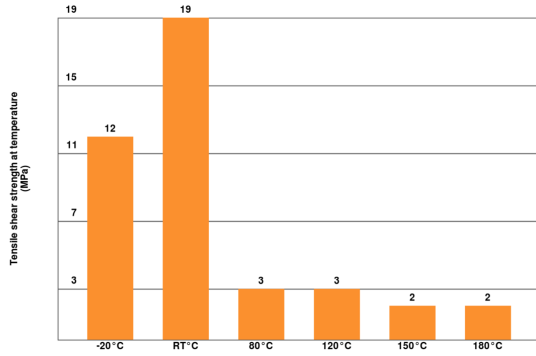
Color in cured condition in 1 mm layer thickness	gray
Transparency in cured condition in 1 mm layer thickness	opaque
Filler particle type	minerals

**Parameters**

Density of component A <i>DELO Standard 13   Liquid</i>	1.37	g/cm <sup>3</sup>
Density of component B <i>DELO Standard 13   Liquid</i>	1.19	g/cm <sup>3</sup>
Tensile shear strength <i>DELO Standard 39   Al   Al   Pretreatment: sand-blasted   at approx. +23 °C   7 d</i>	32	MPa
Tensile shear strength <i>Based on DIN EN 1465   Al   Al   Pretreatment: sand-blasted   at approx. +23 °C   7 d</i>	19	MPa
Peel resistance <i>DELO Standard 38   Steel   Steel   Pretreatment: sand-blasted   at approx. +23 °C   7 d</i>	1.2	N/mm
Tensile strength <i>Based on DIN EN ISO 527   at approx. +23 °C   7 d</i>	40	MPa
Elongation at tear <i>Based on DIN EN ISO 527   at approx. +23 °C   7 d</i>	2	%
Young's modulus <i>Based on DIN EN ISO 527   at approx. +23 °C   7 d</i>	2400	MPa
Shore hardness D <i>Based on DIN EN ISO 868   at approx. +23 °C   7 d</i>	73	

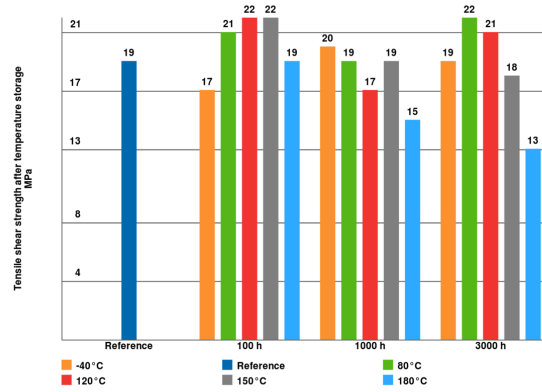
Glass transition temperature <i>DELO Standard 24   Rheometer</i>	66	°C
Coefficient of linear expansion <i>DELO Standard 26   TMA   Evaluation T: 30 °C - 50 °C</i>	88	ppm/K
Coefficient of linear expansion <i>DELO Standard 26   TMA   Evaluation T: 70 °C - 150 °C</i>	178	ppm/K
Shrinkage <i>DELO Standard 13   at approx. +23 °C   7 d</i>	4	vol. %
Water absorption <i>Based on DIN EN ISO 62   at approx. +23 °C   7 d   Type of storage: Desiccator   Duration: 72 h</i>	0.25	wt. %
Decomposition temperature <i>DELO Standard 36</i>	200	°C
Volume resistivity <i>Based on VDE 0303 (30)   at approx. +23 °C   7 d</i>	>1xE13	Ohm·cm
Surface resistance <i>Based on VDE 0303 (30)   at approx. +23 °C   7 d</i>	>1xE13	Ohm
Dielectric strength <i>Based on DIN EN60243-1</i>	13.7	kV/mm
Relative permittivity <i>Based on RF-IV   at approx. +23 °C   7 d   1.00 MHz</i>	4.0	
Relative permittivity <i>Based on RF-IV   at approx. +23 °C   7 d   100.00 MHz</i>	3.9	
Relative permittivity <i>Based on RF-IV   at approx. +23 °C   7 d   10.00 MHz</i>	4.0	
Relative permittivity <i>Based on RF-IV   at approx. +23 °C   7 d   1.00 GHz</i>	3.7	
Comparative tracking index M <i>Based on DIN IEC 60112</i>	600	

Tensile shear strength measured at stated temperatures



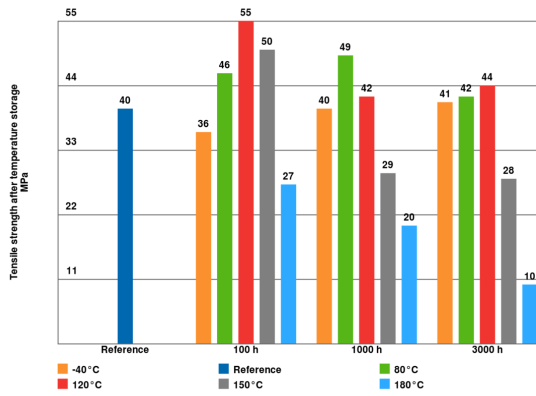
Substrates: Al / Al

Tensile shear strength after temperature storage / based on DIN EN 1465

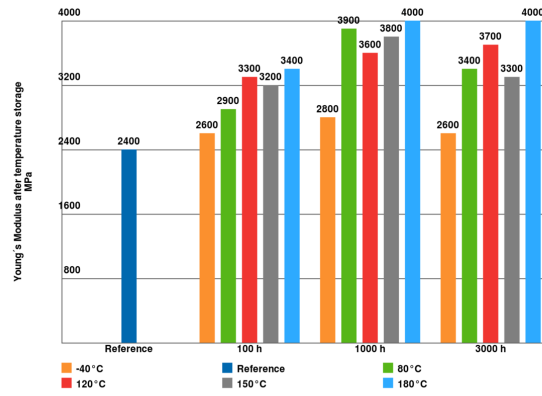


Substrates: Al / Al

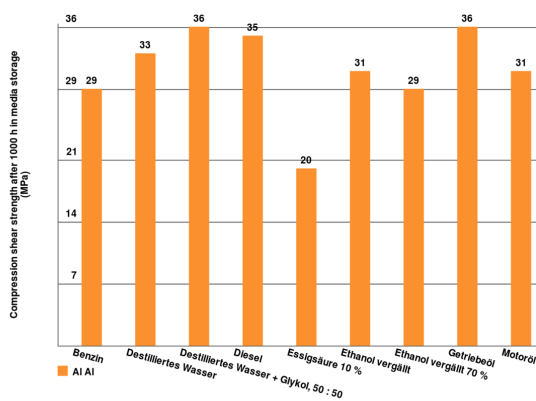
Tensile strength after temperature storage / based on DIN EN ISO 527



Young's Modulus after temperature storage / based on DIN EN ISO 527



Media resistance after 1000 h



**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

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**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.

Curing can be supported or accelerated by heat input. Additional heat input can change the physical properties of the product.

All curing or light fixation parameters depend on material thickness and absorption, adhesive layer thickness, lamp type and distance between lamp and adhesive layer.

Unless otherwise specified, the values were measured after 168 h at approx. 23 °C / 50 % r. h., and the values of heat-cured samples were measured after 24 h at approx. 23 °C / 50 % r. h.

**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.

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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](http://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**

Nothing contained in this Technical Datasheet shall be interpreted as any express warranty or guarantee. This Technical Datasheet is for reference only and does not constitute a product specification. Please ask our responsible Sales Engineer for the applicable product specification which includes defined ranges. DELO is

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## CONTACT

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ADHESIVES

DISPENSING

CURING

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