

# DELO-DUOPOX SJ8665

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

filled | very good temperature resistance, suitable for DELO-AUTOMIX

### Function

- construction adhesive
- electronic adhesive

### Typical area of use

- -40 - 180 °C

### Curing

#### Curing time

until initial strength at rt approx. +23 °C tensile shear strength 1 - 2 MPa	3.5	h
until functional strength at rt approx. +23 °C tensile shear strength > 10 MPa	5	h
until final strength at rt approx. +23 °C	7	d
until initial strength at +80 °C tensile shear strength 1 - 2 MPa	5	min
until functional strength at +80 °C tensile shear strength > 10 MPa	10	min
until final strength at +80 °C	60	min

### Processing

Mixing ratio A : B - volume	2 : 1	
Mixing ratio A : B - weight	1.65 : 1	
Processing time after mixing		
in 20 g batch at rt approx. +23 °C	15	min
in 100 g batch at rt approx. +23 °C	40	min

Reaction temperature (max.)

*in 100 g batch  
at rt approx. +23 °C* 166 °C

Storage life in unopened original container

*at +15 °C to +30 °C* 12 month(s)

**Technical properties**

Color in cured condition in 1 mm layer thickness black

Filler particle type minerals

Density of component A 1.16 g/cm<sup>3</sup>

Density of component B 1.41 g/cm<sup>3</sup>

**Parameters**

Viscosity of component A 250000 mPa·s  
*Liquid | Rheometer | Shear rate: 2 1/s | Gap: 500 µm*

Viscosity of component B 30000 mPa·s  
*Liquid | Rheometer | Shear rate: 2 1/s | Gap: 500 µm*

Tensile shear strength 24 MPa  
*Based on DIN EN 1465 | Steel | Steel | Pretreatment: sand-blasted | at approx. +23 °C | 7 d*

Tensile shear strength 32 MPa  
*Based on DIN EN 1465 | Al | Al | Pretreatment: sand-blasted | at approx. +23 °C | 168 h*

Compression shear strength 30 MPa  
*DELO Standard 5 | Al | Al | Pretreatment: sand-blasted | at approx. +23 °C | 7 d*

Tensile strength 46 MPa  
*Based on DIN EN ISO 527 | at approx. +23 °C | 7 d*

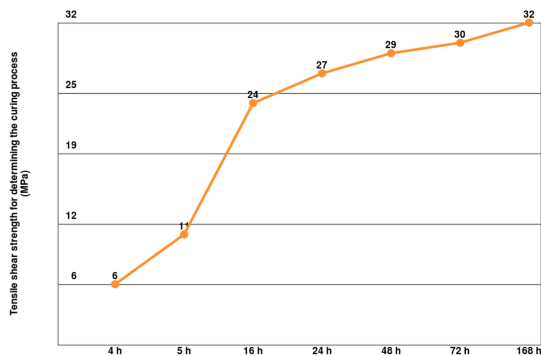
Elongation at tear 3.5 %  
*Based on DIN EN ISO 527 | at approx. +23 °C | 7 d*

Young's modulus 3300 MPa  
*Based on DIN EN ISO 527 | at approx. +23 °C | 7 d*

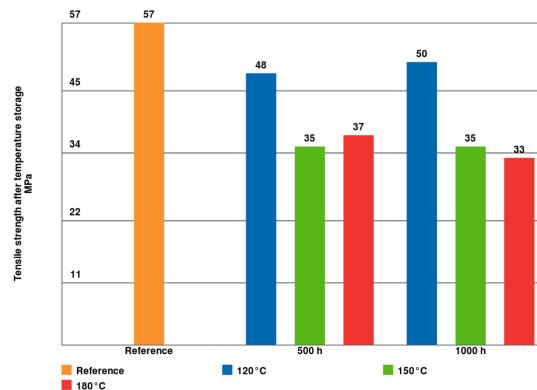
Shore hardness D <i>Based on DIN EN ISO 868   at approx. +23 °C   7 d</i>	77	
Shore hardness D <i>Based on DIN EN ISO 868   80 °C   1 h</i>	82	
Glass transition temperature <i>DMTA   at approx. +23 °C   7 d</i>	126	°C
Coefficient of linear expansion <i>DELO Standard 26   TMA   Evaluation T: 120 °C - 175 °C   at approx. +23 °C   7 d</i>	171	ppm/K
Coefficient of linear expansion <i>DELO Standard 26   TMA   Evaluation T: 35 °C - 100 °C   at approx. +23 °C   7 d</i>	82	ppm/K
Shrinkage <i>DELO Standard 13   at approx. +23 °C   7 d</i>	3	vol. %
Shrinkage <i>DELO Standard 13   80 °C   1 h</i>	3	vol. %
Water absorption <i>Based on DIN EN ISO 62   at approx. +23 °C   7 d   Type of storage: Desiccator   Duration: 72 h</i>	0.15	wt. %
Decomposition temperature <i>DELO Standard 36</i>	294	°C

Substrates: Al/Al, based on DIN EN 1465

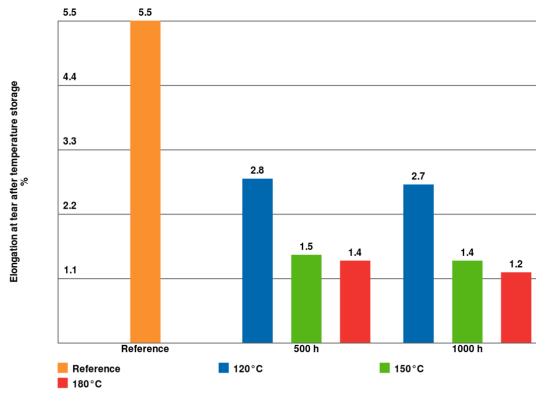
Tensile strength after temperature storage / based on DIN EN ISO 527



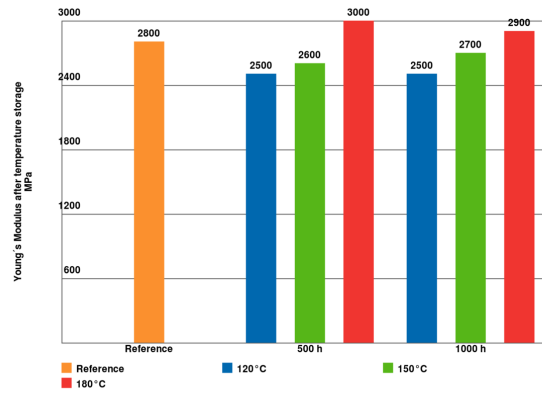
at roomtemperature (approx. 23°C)



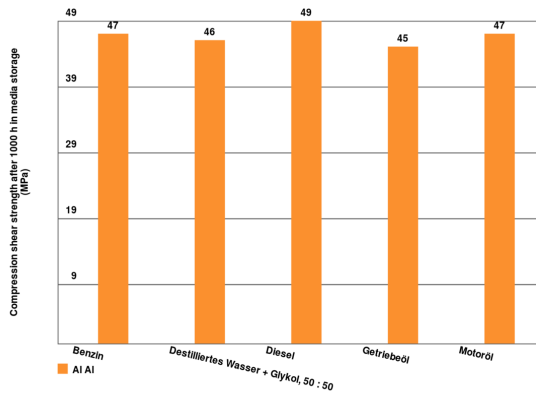
Elongation at tear after temperature storage / based on DIN EN ISO 527



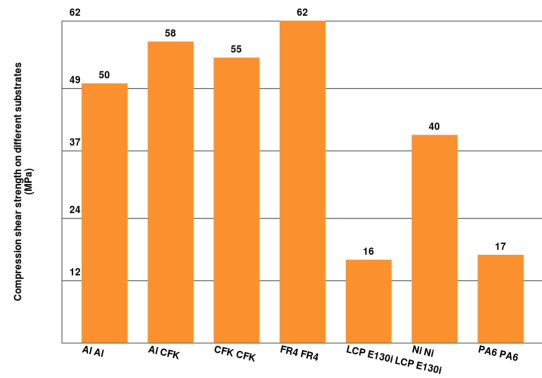
Young's Modulus after temperature storage / based on DIN EN ISO 527



Media resistance after 1000 h



Compression shear strength on different substrates



DELO-Norm 5

### 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.

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.

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](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 neither liable for any values and content of this Technical Datasheet nor for oral or written recommendations regarding the use, unless otherwise agreed in writing. This limitation of liability is not applicable for damages resulting from intent, gross negligence or culpable breach of cardinal obligations, nor shall it apply in case of death or personal injury or in case of liability under any applicable compulsory law.

# CONTACT

DELO-DUOPOX SJ8665 | as of 05.02.2020 14:48 | Page 5 of 5

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