

DELO KATIOBOND GE680

modified epoxy resin | 1C | UV-curing

free of solvents | filled, thixotropic | low CTE

Special features of product

- compliant with RoHS Directive 2015/863/EU
- tested for biocompatibility and meets the requirements according to USP 30, NF 25, Class VI

Function

- encapsulant / potting compound

Typical area of use

- -40 - 150 °C

Curing

Suitable lamp types LED 365 nm, UVA

Recommended irradiation time

*intensity 200 mW/cm²
LED 365 nm* 30 s

Processing

Adhesive application needle-dispensable

Conditioning time (typical)

*when stored in cold conditions
in containers up to 50 ml* 1 h

*when stored in cold conditions
in containers up to 1,000 ml* 6 h

Processing time

*at rt approx. +23 °C
in containers up to 50 ml* 7 d

*at rt approx. +23 °C
in containers up to 900 ml* 3 d

Storage life in unopened original container

at 0 °C to +10 °C 6 month(s)

Technical properties

Transparency	translucent
Color in cured condition in 0.1 mm layer thickness	whitish
Transparency in cured condition in 1 mm layer thickness	translucent
Filler particle size	d99 = 90 µm
Filler content	78 wt. %

Parameters

Density <i>Liquid</i>	1.8 g/cm ³
Viscosity <i>Liquid Rheometer Shear rate: 10 1/s Gap: 500 µm</i>	70000 mPa·s
Thixotropy index <i>Liquid Rheometer Gap: 500 µm</i>	2
Minimum irradiation time <i>DELO Standard 37 DSC 365 nm 200 mW/cm² Measuring temperature: 30 °C</i>	5 s
Maximum curable layer thickness <i>DELO Standard 20 Cardboard 365 nm 200 mW/cm² 5 s Plus 24 h</i>	3.2 mm
Maximum curable layer thickness <i>DELO Standard 20 Cardboard 365 nm 200 mW/cm² 30 s Plus 24 h</i>	≥4 mm
Compression shear strength <i>DELO Standard 5 Glass PBT 365 nm 200 mW/cm² 5 s Plus 24 h</i>	11 MPa
Compression shear strength <i>DELO Standard 5 Glass LCP GF30 365 nm 200 mW/cm² 5 s Plus 24 h</i>	7 MPa
Compression shear strength <i>DELO Standard 5 Glass Glass 365 nm 200 mW/cm² 5 s Plus 24 h</i>	20 MPa

Compression shear strength 16 MPa

DELO Standard 5 | Glass | FR4 | 365 nm | 200 mW/cm² | 5 s | Plus | 24 h

Compression shear strength 20 MPa

DELO Standard 5 | Glass | Al | 365 nm | 200 mW/cm² | 5 s | Plus | 24 h

Tensile strength 37 MPa

Based on DIN EN ISO 527 | 365 nm | 200 mW/cm² | 5 s | Plus | 24 h

Elongation at tear 0.7 %

Based on DIN EN ISO 527 | 365 nm | 200 mW/cm² | 5 s | Plus | 24 h

Young's modulus 16800 MPa

DMTA | 365 nm | 200 mW/cm² | 5 s | Plus | 24 min

Shore hardness D >90

Based on DIN EN ISO 868 | 365 nm | 200 mW/cm² | 5 s | Plus | 24 h

Glass transition temperature 160 °C

DMTA | 365 nm | 200 mW/cm² | 5 s | Plus | 24 min

Coefficient of linear expansion 33 ppm/K

DELO Standard 26 | TMA | Evaluation T: 30 °C - 150 °C | 365 nm | 200 mW/cm² | 5 s | Plus | 24 h

Shrinkage 1.7 vol. %

DELO Standard 13 | 365 nm | 200 mW/cm² | 5 s | Plus | 24 h

Water absorption 0.06 wt. %

Based on DIN EN ISO 62 | 365 nm | 200 mW/cm² | 5 s | Plus | 24 h | Type of storage: Media | Medium:

Distilled water | Duration: 24 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

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. Increasing or decreasing the curing temperature and / or irradiation intensity and / or irradiation time shortens or prolongs the curing time and can lead to changed physical properties. All curing or light fixation parameters depend on material thickness and absorption, adhesive layer thickness, lamp type and distance between lamp and adhesive layer.

Curing until final strength proceeds within 24 hours at room temperature.
High temperatures during or after curing can lead to post-crosslinking of the adhesive which influences the physical properties of the bond.
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.
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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.
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

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ADHESIVES

DISPENSING

CURING

CONSULTING

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