

DELO MONOPOX LT204

modified epoxy resin | 1C | heat-curing

free of solvents | filled | low-temperature-curing from + 60 °C

Special features of product

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

Typical area of use

- -40 - 150 °C

Curing

Recommended curing time

| | | |
|---|----|-----|
| <i>at +60 °C in air convection oven</i> | 90 | min |
| <i>at +90 °C in air convection oven</i> | 15 | min |

Processing

Adhesive application screen-printable, jettable,
needle-dispensable

Conditioning time (typical)

| | | |
|---|-----|---|
| <i>stored at -18 °C in containers up to 10 ml</i> | 0.5 | h |
| <i>stored at -18 °C in containers up to 50 ml</i> | 1 | h |

Processing time

| | | |
|--|----|---|
| <i>in standard climate +23 °C / 50 % r. h.</i> | 72 | h |
|--|----|---|

Storage life in unopened original container

| | | |
|--|---|----------|
| <i>up to <= 55 ml at -18 °C</i> | 4 | month(s) |
|--|---|----------|

Technical properties

Color in uncured condition black

Filler particle type minerals

Filler particle size d98 = 15 µm

Parameters

Density 1.53 g/cm³
DELO Standard 13 | Liquid

Viscosity 28000 mPa·s
Liquid | Rheometer | Shear rate: 10 1/s | Gap: 100 µm

Compression shear strength 10 MPa
DELO Standard 5 | LCP E540i | LCP E540i | 60 °C | 90 min

Compression shear strength 9 MPa
DELO Standard 5 | PS | PS | 60 °C | 90 min

Compression shear strength 15 MPa
DELO Standard 5 | PPS | PPS | 60 °C | 90 min

Compression shear strength 16 MPa
DELO Standard 5 | PMMA | PMMA | 60 °C | 90 min

Compression shear strength 10 MPa
DELO Standard 5 | PBT | PBT | 60 °C | 90 min

Compression shear strength 19 MPa
DELO Standard 5 | PA6 | PA6 | Pretreatment: Annealing, Desiccator | 60 °C | 90 min

Compression shear strength 9 MPa
DELO Standard 5 | LCP E130i | LCP E130i | 60 °C | 90 min

Compression shear strength 26 MPa
DELO Standard 5 | FR4 | FR4 | Pretreatment: Annealing, Desiccator | 60 °C | 90 min

Compression shear strength 27 MPa
DELO Standard 5 | AI | AI | 60 °C | 90 min

Compression shear strength 13 MPa
DELO Standard 5 | ABS | ABS | 60 °C | 90 min

Tensile strength 20 MPa
Based on DIN EN ISO 527 | 60 °C | 90 min

Elongation at tear 35 %
Based on DIN EN ISO 527 | 60 °C | 90 min

Young's modulus 400 MPa
Based on DIN EN ISO 527 | 60 °C | 90 min

Shore hardness D 77
Based on DIN EN ISO 868 | 60 °C | 90 min

Glass transition temperature 30 °C
DELO Standard 26 | TMA | 60 °C | 90 min

Coefficient of linear expansion 43 ppm/K
DELO Standard 26 | TMA | Evaluation T: -10 °C - 20 °C | 60 °C | 90 min

Coefficient of linear expansion 149 ppm/K
DELO Standard 26 | TMA | Evaluation T: 55 °C - 170 °C | 60 °C | 90 min

Shrinkage 4 vol. %
DELO Standard 13 | 60 °C | 90 min

Water absorption 0.2 wt. %
Based on DIN EN ISO 62 | 60 °C | 90 min | Type of storage: Desiccator | Duration: 72 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. 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.

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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.

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