## 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**

<table>
<thead>
<tr>
<th>Temperature</th>
<th>Time</th>
</tr>
</thead>
<tbody>
<tr>
<td>at +60 °C</td>
<td>90 min</td>
</tr>
<tr>
<td>in air convection oven</td>
<td></td>
</tr>
<tr>
<td>at +90 °C</td>
<td>15 min</td>
</tr>
<tr>
<td>in air convection oven</td>
<td></td>
</tr>
</tbody>
</table>

### Processing

**Adhesive application**

- screen-printable, jettable, needle-dispensable

**Conditioning time (typical)**

<table>
<thead>
<tr>
<th>Condition</th>
<th>Time</th>
</tr>
</thead>
<tbody>
<tr>
<td>stored at -18 °C</td>
<td>0.5 h</td>
</tr>
<tr>
<td>in containers up to 10 ml</td>
<td></td>
</tr>
<tr>
<td>stored at -18 °C</td>
<td>1 h</td>
</tr>
<tr>
<td>in containers up to 50 ml</td>
<td></td>
</tr>
</tbody>
</table>

**Processing time**

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

**Storage life in unopened original container**

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

### Technical properties

**Color in uncured condition**

- black

**Filler particle type**

- minerals
## Parameters

<table>
<thead>
<tr>
<th>Parameter</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Filler particle size</td>
<td>d98 = 15 µm</td>
</tr>
<tr>
<td>Density</td>
<td>1.53 g/cm³</td>
</tr>
<tr>
<td>Viscosity</td>
<td>28000 mPa·s</td>
</tr>
<tr>
<td>Compression shear strength</td>
<td>10 MPa</td>
</tr>
<tr>
<td>Compression shear strength</td>
<td>9 MPa</td>
</tr>
<tr>
<td>Compression shear strength</td>
<td>15 MPa</td>
</tr>
<tr>
<td>Compression shear strength</td>
<td>16 MPa</td>
</tr>
<tr>
<td>Compression shear strength</td>
<td>10 MPa</td>
</tr>
<tr>
<td>Compression shear strength</td>
<td>19 MPa</td>
</tr>
<tr>
<td>Compression shear strength</td>
<td>9 MPa</td>
</tr>
<tr>
<td>Compression shear strength</td>
<td>26 MPa</td>
</tr>
<tr>
<td>Compression shear strength</td>
<td>27 MPa</td>
</tr>
<tr>
<td>Compression shear strength</td>
<td>13 MPa</td>
</tr>
<tr>
<td>Tensile strength</td>
<td>20 MPa</td>
</tr>
<tr>
<td>Elongation at tear</td>
<td>35 %</td>
</tr>
</tbody>
</table>
Young's modulus  
Based on DIN EN ISO 527 | 60 °C | 90 min  
400 MPa

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

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

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

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

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

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

Converting table

°F = (°C × 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
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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
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