

2-component epoxy resin adhesives,  
casting resins and trowelling compounds

## DELO®-DUOPOX



**Instructions for use &  
General information  
on the product group**

## **Application areas**

DELO<sup>®</sup>-DUOPOX adhesives, casting resins and trowelling compounds are two-component epoxy resins curing at room temperature after mixing of the two components. They are predominantly used as adhesives and casting compounds in electronics, electrical engineering, mechanical engineering and tool construction.

Many DELO<sup>®</sup>-DUOPOX products are filled in double chamber cartridges and can be easily mixed and dispensed by means of dispensing gun and static mixing tube. These products are suitable for the use in the entire industry.

You can draw further information from the selection chart “DELO<sup>®</sup>-DUOPOX and DELO<sup>®</sup>-PUR adhesives in double chamber cartridge system”.

DELO<sup>®</sup>-DUOPOX trowelling compounds are two-component, filled, fast-curing epoxy resins and are used for coating, trowelling, filling, sealing, adjusting and equalizing in mechanical engineering and aggregate construction.

## **Preparation of the components to be bonded**

The contact surfaces must be free of oil, grease and other contaminations in order to achieve optimal bond strength. We provide our cleaners DELOTHEN. You can draw more detailed information from the technical information “DELOTHEN Cleaners”.

After cleaning, adhesion to the component can be further improved by means of surface pretreatment. You can draw additional details from the written information on surface pretreatment.

The suitability and strength of the adhesive are to be verified on original components under application-specific conditions.

## **Preparation of the adhesive**

Before mixing, the components containing fillers must be homogenized by stirring.

The data sheet and specification values are exclusively determined with components of the same batch and are only valid in this combination.

## **Processing**

### **Open containers:**

2-component products consist of the components A and B producing the ready-made adhesive only after proper, homogeneous mixing in the correct ratio. Due to the exothermal curing reaction, large preparations should be mixed in several portions or flat vessels for a better heat dissipation. In particular, filled products must be stirred properly and homogenized before use from an open container.

Weigh out the components A and B in the mixing ratio indicated. Mix the mixture properly, i. e. free of streaks, in a suitable vessel. It must be ensured that no air is stirred in and all weighed ingredients are mixed homogeneously. Processing must be completed within the pot life or processing time specified. Scrapers or notched trowels are suitable for application. In case of lathing or milling, the depth of cut and the processing speed should be possibly low in order to achieve a high dimensional stability.

## DELO®-DUOPOX in double chamber cartridges:

The adhesive is applied by means of dispensing guns which are operated manually or pneumatically. The mixing tube 050 short is not suitable for the adhesives DELO®-DUOPOX 02 rapid, 03 rapid and 03 rapid thix.

1. Insert double chamber cartridge in dispensing gun
  - Push the securing lever of the dispensing gun upwards
  - Insert the cograil from ahead to the end stop (cogging down)
  - Open the dispensing gun cover by flipping it upwards
  - Insert double chamber cartridge
  - Close the cover for cartridge arrangement
2. Equalize production-induced filling level deviations
  - Remove the closing cap from the cartridge top by turning
  - Remove possibly cured adhesive from the outlet (disposal according to safety data sheet)
  - Equalize filling level deviations by operating the trigger lever
  - The double chamber cartridges are overfilled beyond the adhesive amount specified so that no loss occurs while equalizing the filling level deviations
3. Attach mixing tube
  - Attach the mixing tube and lock it by a quarter turn
4. Avoid mixing errors
  - Before use, abandon one content of the mixing tube in order to prevent mixing errors and ensure optimal adhesive curing (disposal according to safety data sheet)
5. Adhesive application
  - Apply the homogeneously mixed adhesive to the component



When using the original closure cap for closing cartridges which have not been emptied completely, this can result in partially cured adhesive at the outlets of the cartridge. Therefore, use the filled mixing tube as closure.

If the processing pauses are shorter than the pot life of the 0.1 oz (3 g) preparation of the respective product, the same mixing tube can be further used.

In case of work finish or longer interruptions, the mixing tube can remain on the cartridge as closure. Before further processing, the old mixing tube is removed, the outlet at the cartridge is ridded of possibly cured adhesive and a new mixing tube is attached.

## Curing

The products cure at room temperature. When mixing the components, the pot life and the time available for processing the product begins. During curing, exothermal reaction heat is generated. The temperature depends on the product and on the product amount. After exceeding the pot life, the viscosity increases fast until complete curing or hardening. Temperatures below room temperature decelerate curing, in extreme cases the product cures incompletely or not at all. Curing conditions deviating from room temperature can influence the product properties. Special products require an additional tempering process.

DELO<sup>®</sup>-DUOPOX adhesives and DELO<sup>®</sup>-DUOPOX trowelling compounds:  
Complete curing of the majority of products is achieved at room temperature after 24 to 72 hours.  
The curing time can be reduced through temperature increases up to approx. 248 °F (120 °C).

DELO<sup>®</sup>-DUOPOX casting resins:  
The majority of casting resins cure at room temperature within 24 to 48 hours. The curing time can be reduced through temperature increases up to approx. 248 °F (120 °C).

You can draw the detailed, product-specific information on the processing of each product from the respective technical data sheet.

## **Instructions and advice for occupational health and safety**

see material safety data sheet

## **Storage**

In unopened original container

Storage life: see technical data sheet

## **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 user's responsibility to test the suitability of the product for the intended purpose by considering all specific requirements. Type and 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.

## **If you have any further questions**

Please contact us.

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