

1-component adhesives and casting resins

DELO MONOPOX®



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

## Application areas

DELOMONOPOX<sup>®</sup> are one-component, heat-curing products. They are predominantly used as adhesives and casting compounds in electronics, electrical engineering, mechanical engineering and tool 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.

## Processing

The products are supplied ready for use. Depending on the type of delivery, they can be processed manually directly from the container or by means of DELO dispensing units DELOMAT<sup>®</sup>. When applying DELOMONOPOX<sup>®</sup> to larger areas, it is recommendable to use a scraper or a notched trowel in order to achieve a good wetting.

### Euro cartridges:

1. Cut the Euro cartridge tip.
2. Screw on the dispensing tip.
3. Insert Euro cartridge into the dispensing gun.

### DELOMAT with Euro cartridge holder:

1. Insert the cartridge into the cartridge pipe.
2. Screw the swivel nut of the pressure tank cover tightly onto the cartridge pipe.
3. If necessary, put the cartridge pipe with the cartridge through the retaining bent.
4. Cut the cartridge tip at its upper end.
5. Carefully screw the cartridge into the thread of the valve or attach the adapter for the flexible discharge site. Caution!! Make sure that the o-ring is inserted correctly!

### Hobbock:

1. Remove the cover.
2. Insert the follower plate.

Remember that the storage life is dependent on the ambient temperature! Please contact our specialists if you have any questions!



**Caution!** An exothermic reaction during preheating is possible.  
Maximal preheating temperature +86 °F (+30 °C).  
Higher preheating temperatures depend on the product and are sometimes possible.

## **Curing**

The curing temperatures are product-specific and can be drawn from the respective technical data sheet.

The heating time of the components must be added to the curing time. The heating time must not exceed 15 minutes.

Heating can proceed in air convection ovens, with IR transmitters or other suitable heat sources, e. g. thermodes. It is important that the curing temperature is reached at the adhesive.

In case of curing temperatures below the temperature ranges specified in the technical data sheet, curing is decelerated or the product cures incompletely or not at all. The adhesive must not be heated beyond the resistance temperature.

In case of large areas, tensions during the heating, curing and cooling phases (e. g. tempering) must be avoided.

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.

# **DELO**

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