

DELO-DUOPOX® CR844

Multi-purpose 2c epoxy castin resin, cures at room temperature, medium-viscous, filled

Base

- epoxy resin
- two-component, thixotropic

Use

- multi-purpose casting resin
- high temperature and media resistance
- the cured product is normally used in a temperature range of -40 °C to +180 °C; depending on the application, other limits may be more reasonable
- compliant with RoHS directive 2011/65/EU

Processing

- components A and B must be mixed well or homogenized in the mixing ratio stated below
- supplied ready for use and can be processed well from the original container
- using the DELO-AUTOMIX system for processing is especially advantageous, see selection chart "DELO-AUTOMIX system"
- the surfaces to be bonded must be dry as well as free of dust, grease and other contaminations
- use DELOTHEN cleaners for the cleaning of bonding surfaces

Curing

- proceeds at room temperature (approx. 23 °C)
- increased temperatures accelerate curing
- applying heat could change physical characteristics

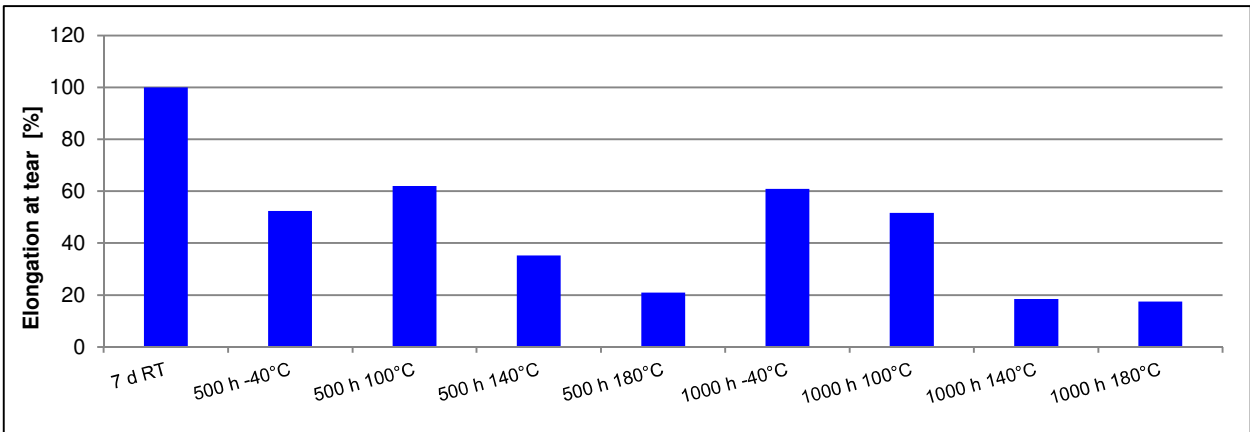
Technical data

<i>Color</i>	dark gray
Filler	minerals
Mixing ratio (A : B) according to weight (A : B) according to volume	0.89:1 1 : 1
Density of component A [g/cm ³] DELO Standard 13 at room temperature (approx. 23 °C)	1.18
Density of component B [g/cm ³] DELO Standard 13 at room temperature (approx. 23 °C)	1.33
<i>Viscosity of component A</i> [mPas] at 23 °C, rheometer	80000

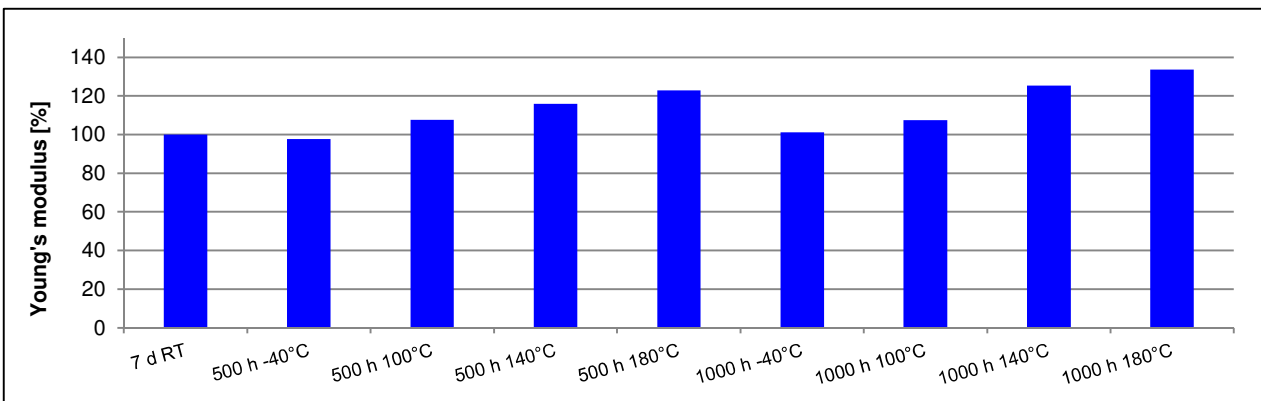
Viscosity of component B [mPas] at 23 °C, rheometer	70000
Processing time in 100 g preparation [min] at room temperature (approx. 23 °C)	100
Tensile shear strength A/AI [MPa] DIN EN 1465, sand-blasted component thickness: 1.6 mm curing: 7 d at room temperature (approx. 23 °C)	25
Tensile strength [MPa] DIN EN ISO 527 curing: 7 d room temperature (approx. 23 °C)	30
Elongation at tear [%] DIN EN ISO 527 curing: 7 d room temperature (approx. 23 °C)	5
Young's modulus [MPa] DIN EN ISO 527 curing: 7 d room temperature (approx. 23 °C)	1600
Glass transition temperature [°C] DELO Standard 24, Rheometer, 2nd heating process	65

Performance under temperature influence

Elongation at tear after temperature storage
based on initial value at room temperature
curing before storage: 7d at room temperature (approx. 23 °C)
measured at room temperature (approx. 23 °C)
according to DIN EN ISO 527

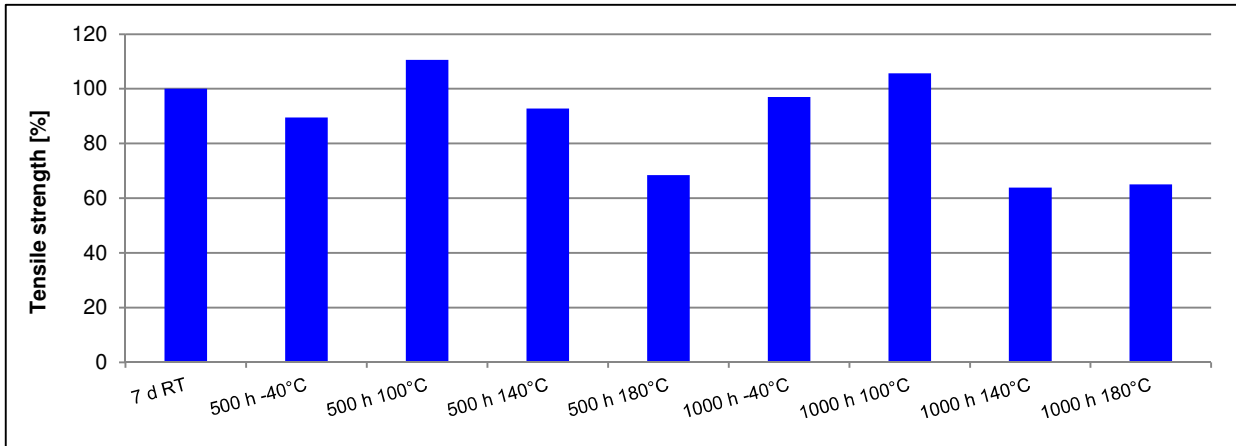


Young's modulus after temperature storage
based on initial value at room temperature
curing before storage: 7d at room temperature (approx. 23 °C)
measured at room temperature (approx. 23 °C)
according to DIN EN ISO 527

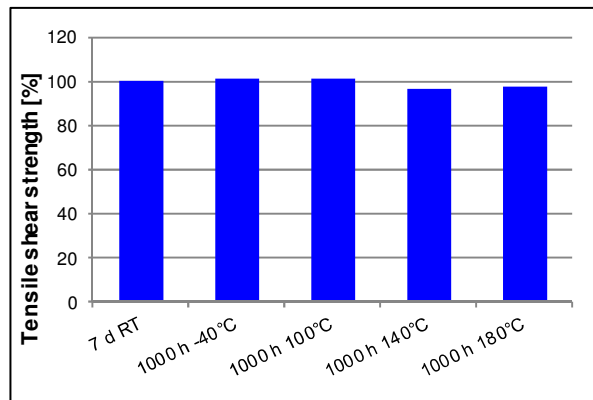
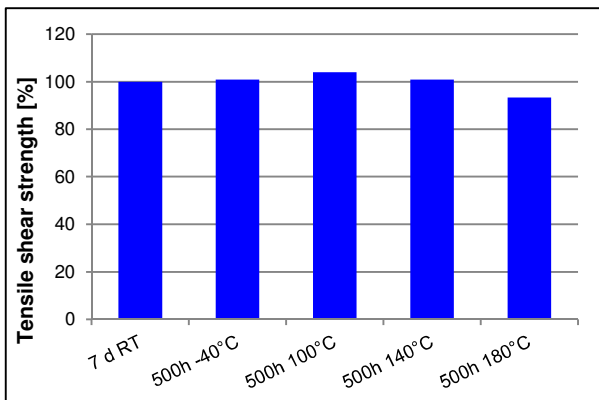


Performance under temperature influence

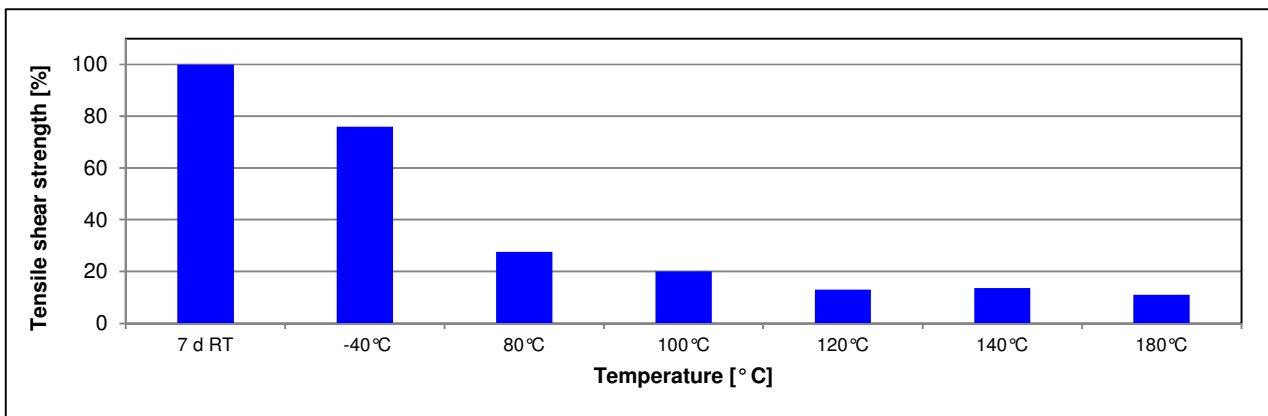
Tensile strength after temperature storage
 based on initial value at room temperature
 curing before storage: 7d at room temperature (approx. 23 °C)
 measured at room temperature (approx. 23 °C)
 according to DIN EN ISO 527



Tensile shear strength Al/Al (plated) after storage
 based on initial value at room temperature
 curing before storage: 7d at room temperature (approx. 23 °C)
 measured at room temperature (approx. 23 °C)
 according to DIN EN 1465, sand-blasted, component thickness: 1.6 mm



Tensile shear strength Al/Al (plated)
 based on initial value at room temperature
 measured at determined temperature
 according to DIN EN 1465, sand-blasted, component thickness: 1.6 mm



Storage life at room temperature (max. 25 °C)
 in unopened original container (volume per component < 1l)

6 months

Instructions and advice

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 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. The data and information provided are therefore no guarantee for specific product properties or the suitability of the product for the intended purpose.

Nothing contained herein shall be construed to indicate the non-existence of any relevant patents or to constitute a permission, encouragement or recommendation to practice any development covered by any patents, without permission of the owner of this patent.

All products provided by DELO are subject to DELOs' General Terms of Business. Verbal side agreements are not permitted. This document is subject to change.

Instructions for use

The instructions for use of DELO-DUOPOX are available on: www.DELO.de. We will be pleased to send them to you on demand.

Occupational health and safety

see material safety data sheet

Specification

The properties in italics are part of the specification. Ranges with clear limits are defined for them and others, where applicable. In the course of the QA test, each batch is tested for these properties and the maintenance of the limits is ensured. The measuring methods used can deviate from those specified in the data sheet. Details can be found in the QA test report.