

# DELO<sup>®</sup>-ML DB140

**modified acrylate | 1C | UV- / VIS- / anaerobic-curing**

free of solvents | tension-equalizing, very good temperature resistance, dual-curing, fast fixation, high-strength

**Special features of product**

- compliant with RoHS Directive 2015/863/EU
- compliant with limits of VOC content in adhesive acc. to GB33372-2020
- passes ANSI/UL 94 HB Flame Test

**Function**

- structural adhesive
- construction adhesive

**Typical area of use**

- -60 - 180 °C
- glass/metal bondings
- screw locking and thread sealing
- small metal areas with high fitting accuracy

**Curing**

Suitable lamp types	LED 365 nm, LED 400 nm, UVA	
Intensity (maximum)	700	mW/cm <sup>2</sup>
Typical irradiation time		
<i>intensity 200 mW/cm<sup>2</sup> LED 400 nm</i>	10	s
Curing time		
<i>until initial strength at rt approx. +23 °C anaerobic on zinc-phosphated screws</i>	1 - 3	min
<i>until final strength at rt approx. +23 °C anaerobic on zinc-phosphated screws</i>	24	h

### Processing

Conditioning time (typical)

*when stored in cold conditions  
in containers up to 50 ml* 30 min

*when stored in cold conditions  
in containers up to 1,000 ml* 4 h

Processing time

*in standard climate +23 °C / 50 % r. h.* 28 d

Typical layer thickness 0.05 - 0.1 mm

Typical layer thickness with heat or activator 0.3 - 0.4 mm

Storage life in unopened original container

*up to <= 600 ml  
at 0 °C to +10 °C* 6 month(s)

*up to <= 600 ml  
at 0 °C to +25 °C* 3 month(s)

### Technical properties

Color in uncured condition colorless

Transparency transparent

Color in cured condition in 0.1 mm layer thickness yellowish

Color in cured condition in 1 mm layer thickness yellowish

Fluorescence fluorescent

### Parameters

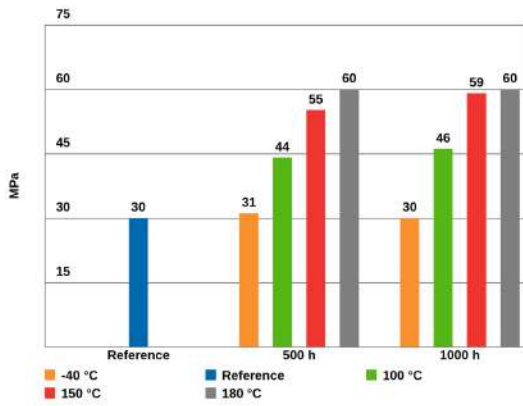
Density 1.09 g/cm<sup>3</sup>  
*liquid*

Viscosity 900 mPa·s  
*liquid | Rheometer | Shear rate: 10 1/s | Gap: 200 µm*

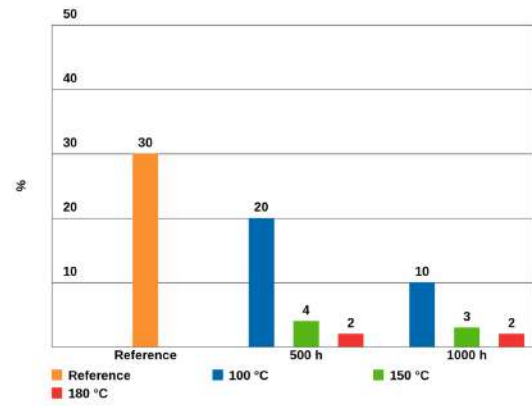
Maximum curable layer thickness 4 mm  
*DELO Standard 20 | White substrate | 400 nm | 200 mW/cm<sup>2</sup> | 60 s*

Tensile shear strength <i>by the criteria of DIN EN 1465   <b>Al   Al</b>   at approx. +23 °C   72 h</i>	6	MPa
Tensile shear strength <i>by the criteria of DIN EN 1465   <b>Steel   Steel</b>   at approx. +23 °C   72 h</i>	13	MPa
Compression shear strength <i>DELO Standard 5   <b>Glass   Glass</b>   400 nm   200 mW/cm<sup>2</sup>   60 s</i>	30	MPa
Compression shear strength <i>by the criteria of ISO 10123   <b>Steel shaft   Steel hub</b>   at approx. +23 °C   1 h</i>	30	MPa
Compression shear strength <i>by the criteria of ISO 10123   <b>Steel shaft   Steel hub</b>   at approx. +23 °C   72 h</i>	40	MPa
Tensile strength <i>by the criteria of DIN EN ISO 527   400 nm   200 mW/cm<sup>2</sup>   90 s</i>	30	MPa
Elongation at tear <i>by the criteria of DIN EN ISO 527   400 nm   200 mW/cm<sup>2</sup>   90 s</i>	30	%
Young's modulus <i>by the criteria of DIN EN ISO 527   400 nm   200 mW/cm<sup>2</sup>   90 s</i>	900	MPa
Shore hardness D <i>by the criteria of DIN EN ISO 868   400 nm   200 mW/cm<sup>2</sup>   90 s</i>	74	
Glass transition temperature <i>DMTA   400 nm   200 mW/cm<sup>2</sup>   60 s</i>	120	°C
Coefficient of linear expansion <i>DELO Standard 26   TMA   Evaluation T: 35 °C - 70 °C   400 nm   200 mW/cm<sup>2</sup>   60 s</i>	110	ppm/K
Coefficient of linear expansion <i>DELO Standard 26   TMA   Evaluation T: 100 °C - 160 °C   400 nm   200 mW/cm<sup>2</sup>   60 s</i>	179	ppm/K
Shrinkage <i>DELO Standard 13   400 nm   200 mW/cm<sup>2</sup>   90 s</i>	8.7	vol. %
Water absorption <i>by the criteria of DIN EN ISO 62   Layer thickness: 4 mm   400 nm   200 mW/cm<sup>2</sup>   90 s   Type of storage: Media   Medium: Distilled water   Storage temperature: at approx. +23 °C   Duration: 24 h</i>	0.8	wt. %

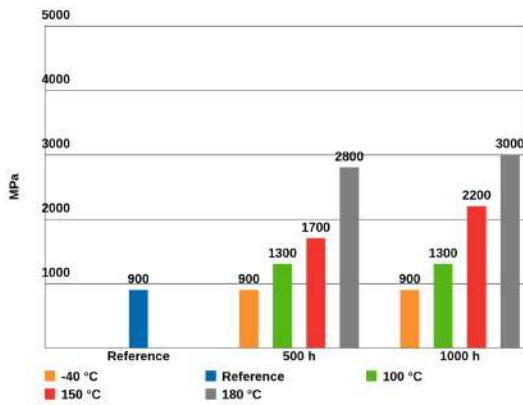
Tensile strength after temperature storage, by the criteria of DIN EN ISO 527



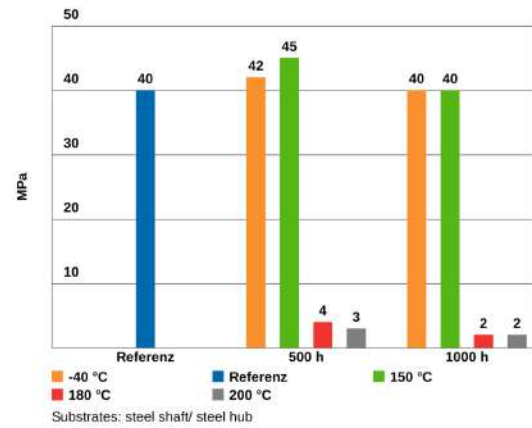
Elongation at tear after temperature storage, by the criteria of DIN EN ISO 527



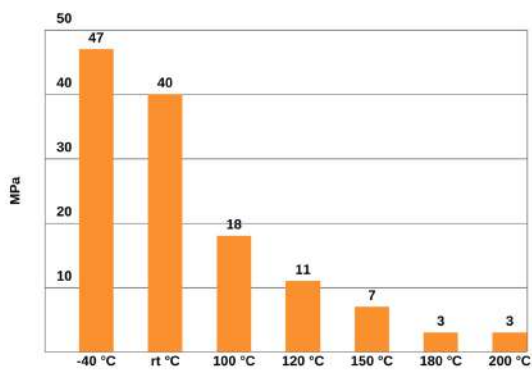
Young's modulus after temperature storage, by the criteria of DIN EN ISO 527



Compression shear strength after thermal storage, based on ISO 10123

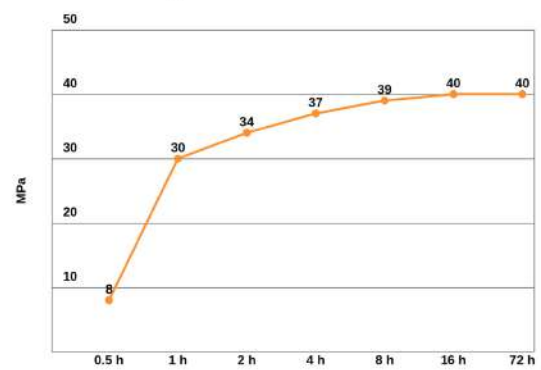


Compression shear strength measured at the stated temperatures



Substrates: steel shaft / steel hub

Compression shear strength for determining the curing process shaft-to-hub bonding substrates: steel shaft/steel hub, by the criteria of DELO standard 31



**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

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**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. All curing or light fixation parameters depend on material thickness and absorption, adhesive layer thickness, lamp type and distance between lamp and adhesive layer. 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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All products provided by DELO are subject to DELO's General Terms of Business. Verbal ancillary agreements are deemed not to exist.

**Instructions for use**

You can find further details in the instructions for use.

The instructions for use are available on [www.DELO-adhesives.com](http://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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