

DELO[®]-ML DB154

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

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

Special features of product

- compliant with RoHS Directive 2015/863/EU

Function

- construction adhesive
- structural 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
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Typical irradiation time

<i>intensity 60 mW/cm² UVA</i>	6	s
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Curing time

<i>until initial strength at rt approx. +23 °C anaerobic on zinc-phosphated screws</i>	2 - 4	min
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Processing

Conditioning time (typical)

<i>when stored in cold conditions in containers up to 50 ml</i>	30	min
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<i>when stored in cold conditions in containers up to 1,000 ml</i>	4	h
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Processing time

<i>in standard climate +23 °C / 50 % r. h.</i>	28	d
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Storage life in unopened original container

up to <= 600 ml
at 0 °C to +25 °C

6 month(s)

Technical properties

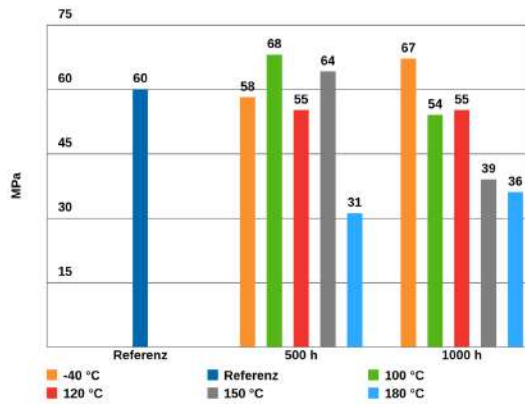
Color in uncured condition	yellow
Transparency	translucent
Color in cured condition in 0.1 mm layer thickness	yellow
Color in cured condition in 1 mm layer thickness	yellow
Fluorescence	fluorescent

Parameters

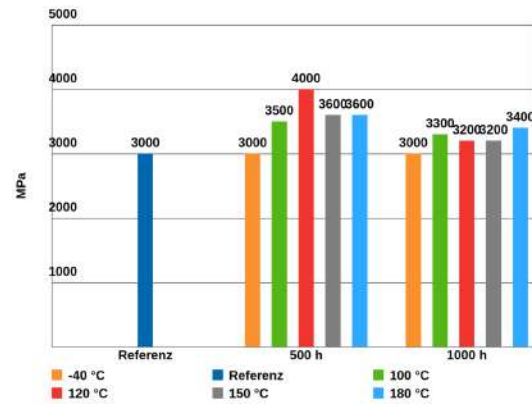
Density <i>DELO Standard 13 liquid</i>	1.1	g/cm ³
Viscosity <i>liquid Viscosimeter</i>	6000	mPa·s
Maximum curable layer thickness <i>DELO Standard 20 White substrate 400 nm 200 mW/cm² 60 s</i>	4	mm
Off-torque <i>by the criteria of ISO 10964 Steel, zinc-phosphated Steel, zinc-phosphated liquid Tightening torque: 46 N·m</i>	34	N·m
Off-torque <i>by the criteria of ISO 10964 Steel, zinc-phosphated Steel, zinc-phosphated liquid</i>	34	N·m
Tensile shear strength <i>by the criteria of DIN EN 1465 Al Al Pretreatment: sand-blasted liquid</i>	13	MPa
Tensile shear strength <i>by the criteria of DIN EN 1465 Steel Steel Pretreatment: sand-blasted liquid</i>	16	MPa
Compression shear strength <i>DELO Standard 5 Glass Glass 400 nm 200 mW/cm² 60 s</i>	11	MPa
Compression shear strength <i>DELO Standard 5 PA6 Stainless steel Pretreatment: Annealing 400 nm 200 mW/cm² 60 s</i>	6	MPa

<p>Compression shear strength <i>DELO Standard 5 PA6 Stainless steel Pretreatment: Activator Activator for component 1: DELO-QUICK 5002 72 h</i></p>	4	MPa
<p>Compression shear strength <i>DELO Standard 5 PA6 PA6 Pretreatment: Annealing 400 nm 200 mW/cm² 60 s</i></p>	7	MPa
<p>Compression shear strength <i>DELO Standard 5 PPA Stainless steel Pretreatment: Activator Activator for component 1: DELO-QUICK 5002 24 h</i></p>	6	MPa
<p>Compression shear strength <i>by the criteria of ISO 10123 Steel shaft Steel hub at approx. +23 °C 1 h</i></p>	20	MPa
<p>Compression shear strength <i>by the criteria of ISO 10123 Steel shaft Steel hub at approx. +23 °C 72 h</i></p>	35	MPa
<p>Tensile strength <i>by the criteria of DIN EN ISO 527 liquid</i></p>	60	MPa
<p>Elongation at tear <i>by the criteria of DIN EN ISO 527 liquid</i></p>	4	%
<p>Young's modulus <i>by the criteria of DIN EN ISO 527 liquid</i></p>	3000	MPa
<p>Shore hardness D <i>by the criteria of DIN EN ISO 868 60 mW/cm² 90 s</i></p>	84	
<p>Glass transition temperature <i>Rheometer 60 mW/cm²</i></p>	110	°C
<p>Shrinkage <i>DELO Standard 13 60 mW/cm² 90 s</i></p>	8.4	vol. %
<p>Water absorption <i>by the criteria of DIN EN ISO 62 60 mW/cm² 90 s Type of storage: Media Medium: Distilled water Storage temperature: at approx. +23 °C Duration: 24 h</i></p>	0.7	wt. %

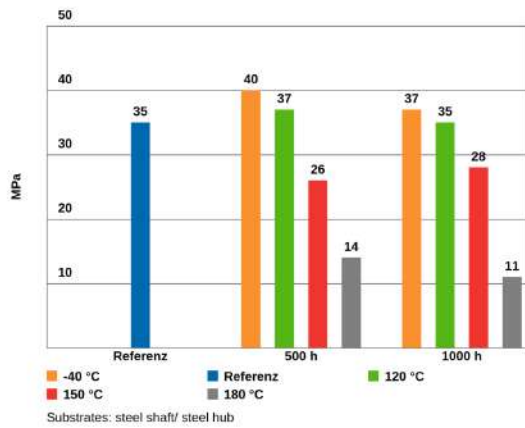
Tensile strength after thermal storage, based on DIN EN ISO 527



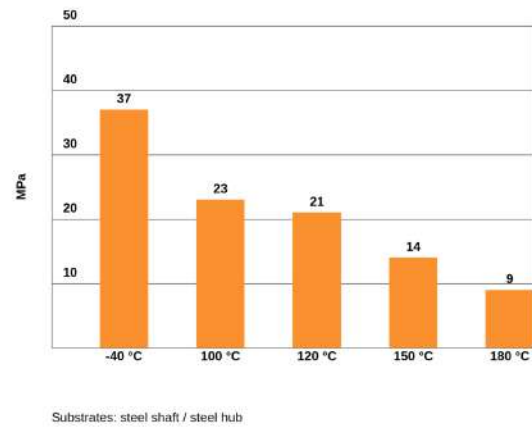
Young's modulus after thermal storage
Curing 60 mW/cm² 90 s /



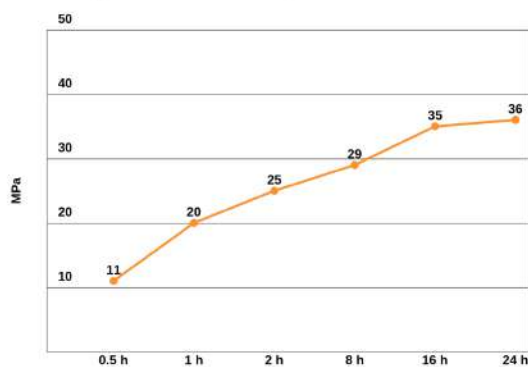
Compression shear strength after thermal storage, based on ISO 10123



Compression shear strength measured at the stated temperatures



Compression shear strength for determining the curing process
shaft-to-hub bonding, substrates: steel shaft/steel hub, based on ISO 10123



at room temperature (approx. +23 °C)

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

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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Instructions for use

You can find further details in the 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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ADHESIVES

DISPENSING

CURING

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