

# DELO

Instructions for Use &  
General Information  
on the Product Group

## DELO® MONOPOX Aminic

One-component adhesives  
and casting resins



### Application areas

DELO® MONOPOX products are one-component, heat-curing products. They are predominantly used as adhesives and casting compounds in electronics, electrical engineering, mechanical engineering and tool construction.

### Processing

Preparation/pretreatment → Application → Joining → Heat curing

## 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 DELOTHEN cleaners. You can find more details about “DELOTHEN Cleaners” on the DELOTHEN Technical Data Sheet.

After cleaning, adhesion to the component can be further improved by surface pretreatment. You can find further information on surface pretreatment section.

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

## Processing of the adhesive

The products are supplied ready for use. Depending on the scope of delivery, they can be processed manually directly from the container or by means of devices such as DELOMAT dispensing units.

The adhesive must be conditioned to room temperature for the appropriate amount of time before bonding without heat addition in the supplied original container (see Technical Data Sheet).

Condensation water on the adhesive and the substrate must be prevented.

Freezing and thawing the adhesive again is not permitted!

When applying DELO® MONOPOX to larger areas, DELO recommends using a scraper or a notched trowel to achieve good wetting of the components to be bonded.

Euro cartridges:

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

DELOMAT with Euro cartridge retainer:

1. Insert the cartridge into the cartridge pipe.
2. Tightly screw the swivel nut of the pressure tank cover 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!

Hobcock:

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

Remember that the storage life depends on the ambient temperature! Please contact our experts if you have any questions!



### CAUTION!

**An exothermic reaction during preheating is possible!**

Maximum preheating temperature: +86 °F. Higher preheating temperatures depend on the product and are sometimes feasible.

## Curing

The curing temperatures and times are product-specific and can be found in the appropriate Technical Data Sheet. The heating time of the components must be added to the curing time.

Heat curing can be achieved in air convection ovens, with IR transmitters, or with other suitable heat sources, such as thermodes or induction systems. It is important that the adhesive, and not the joining parts, reach the specified curing temperature. Otherwise the adhesive will not be fully cured.

If the temperatures used for curing are 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 maximum curing temperature specified in the Technical Data Sheet.

When bonding large areas, tensions during the heating, curing and cooling phases (for example by tempering) must be avoided.

You can find the detailed, product-specific information on the processing of each product in the specific Technical Data Sheet.

## Cleaning

Isopropanol and acetone are generally suitable cleaners for aminic DELO® MONOPOX adhesives.

The type of cleaner to be used depends on the specifications of the dispensing device manufacturer. The manufacturer's instructions must be followed in any case.

Details about cleaning of valves and systems can be found in the cleaning instructions for aminic DELO® MONOPOX products.

## Instructions and advice for occupational health and safety

See Material Safety Data Sheet

## Storage

After delivery, remove the package from the transport packaging and condition to the storage temperature in unopened condition for at least 4 h (see figure).

Please make sure that frozen container is only minimally touched as large temperature difference between container and adhesive may lead to the adhesive becoming “detached” from the inner cartridge wall. It is recommended that the container is removed at its rear end or thermally insulating gloves are used.




Storage life and storage temperature can be drawn from the Technical Data Sheet  
 The product may be stored in the unopened original container only.  
 The storage temperature specified in the Technical Data Sheet must not be undershot.

Innen/Inside

**DELO**

**Instructions for cooled package (0 °C – +10 °C)**  
 How to handle cooled DELO adhesives after arrival

**冷藏包裝使用說明 (0 °C – +10 °C)**  
 怎樣處理冷藏包裝的 DELO 胶水

<p><b>1 Unpacking</b> Unpack the adhesive</p> <p><b>1 打开外包装</b> 取出裝有胶水的紙筒</p> 	<p><b>2 Storage</b> Store in a fridge at 0 °C to +10 °C for at least 4 hours prior to step 3</p> <p><b>2 儲存</b> 進入第三步前，請在 0 – +10 °C 冷藏室中至少儲存 4 小時</p> 	<p><b>3 Conditioning</b> Allow the adhesive to adjust to room temperature prior to use</p> <p><b>3 回溫</b> 使用前，請將胶水的溫度恢復至室溫 (+23 °C)</p> 
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Innen/Inside

**DELO**

**Instructions for frozen package (-18 °C)**  
 How to handle frozen DELO adhesives after arrival

**冷凍包裝操作指南 (-18 °C)**  
 怎樣處理冷凍包裝的 DELO 胶水

<p><b>1 Unpacking</b> Unpack the adhesive</p> <p><b>1 打开外包装</b> 取出裝有胶水的紙筒</p> 	<p><b>2 Storage</b> Store in a freezer at -18 °C in unopened box for at least 4 hours prior to step 3</p> <p><b>2 儲存</b> 進入第三步前，請將紙筒密封不動在 -18 °C 冷凍室中至少儲存 4 小時</p> 	<p><b>3 Conditioning</b> Allow the adhesive to adjust to room temperature prior to use</p> <p><b>3 回溫</b> 使用前，請將胶水的溫度恢復至室溫 (+23 °C)</p> 
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*Handling of cooled package*  
 +32 °F – +50 °F (0 °C – +10 °C) storage

*Handling of dry ice package*  
 -0,4 °F (-18 °C) storage

# CONTACT

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