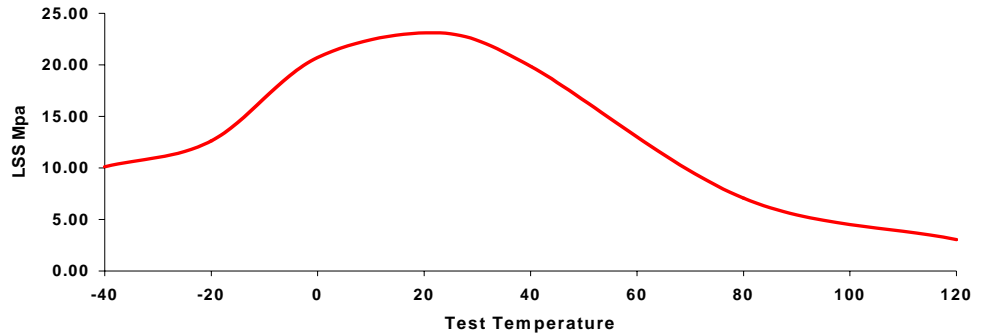


### Agomet® A 350

#### Low odour two part methacrylate adhesive for Metal Bonding

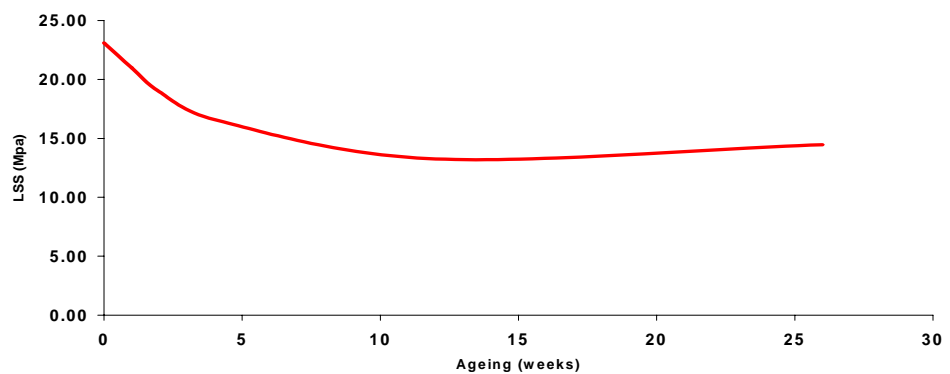
<b><u>Properties</u></b>	<p>Agomet A 350 is a low odour reactive adhesive for ambient temperature bonding of metals. Agomet A 350 with Hardener K 105 Red is available in 10:1 ratio cartridges, ensuring correct mix ratio.</p> <p>The mixed adhesive has a working life of ca. 10 – 11 minutes, and cures to light handling strength in 15 – 20 minutes. Full properties are reached within 24 hours.</p> <p>Agomet A 350 gives bonds with high peel and shear strengths combined with resistance to humid environments.</p>
<b><u>Substrates</u></b>	Most common metals, including steel, galvanised steel, aluminium, copper, brass, etc.
<b><u>Viscosity</u></b>	ca. 60 Pas
<b><u>Specific Gravity</u></b>	ca. 1.3
<b><u>Processing</u></b>	
Surface Preparation	Even without special surface pre-treatment, Agomet A 350 bonds develop good strength values. To optimise bonding strength, however, all joints must be free of loose impurities such as dust, oxides, grease, mould release agents or plasticizers. A simple wipe with a solvent such as acetone or – for plastics – alcohol, is sufficient. Normal residues of rolling or drawing oil are compatible with the adhesive and can remain on the surfaces to be joined.
Application Weight	The optimal adhesive weight is 150 – 250 g/m <sup>2</sup> (0.15 – 0.25 mm). Thicknesses of 5 mm and above can be applied without difficulty where necessary.
Temperature	Agomet A 350 can be used between 15 and 30°C. Higher temperatures will significantly reduce working time.
<b><u>Application</u></b>	Clean, easy and accurate application is possible with the 2-component cartridge system. The cartridge gives optimal mixing ratio and delivers ready for use product which can be applied directly to one of the bonding surfaces. The parts can then be joined using contact pressure, and held until the adhesive has reached sufficient strength for light handling
<b><u>Properties</u></b>	
Lap Shear Strength*	Aluminium ca. 23 MPa Mild steel ca. 22 MPa V4A stainless steel ca. 22 Mpa Galvanised steel ca. 15 MPa Copper ca. 21 MPa Brass ca. 24 MPa
	*tested according to DIN 53283 (ISO 4587) Test pieces 100 mm x 25 mm x 1.6 mm overlap area 300 mm <sup>2</sup> Substrate degreased and abraded

Lap Shear Strength versus Temperature (tested as above)



Short term Temperature resistance up to 180°C can be obtained with Agomet® A 350 without destruction of the bond. Temperatures of 220°C for 30 minutes will result in halving of the Lap Shear Strength.

Lap Shear Strength during Tropical Ageing (40°C/98% RH)



**Storage**

At least 6 months in unopened containers

**Handling Precautions**

**Caution**

Our products are generally quite harmless to handle provided that certain precautions normally taken when handling chemicals are observed. The uncured materials must not, for instance, be allowed to come into contact with foodstuffs or food utensils, and measures should be taken to prevent the uncured materials from coming in contact with the skin, since people with particularly sensitive skin may be affected. The wearing of impervious rubber or plastic gloves will normally be necessary; likewise the use of eye protection. The skin should be thoroughly cleansed at the end of each working period by washing with soap and warm water. The use of solvents is to be avoided. Disposable paper - not cloth towels - should be used to dry the skin. Adequate ventilation of the working area is recommended. These precautions are described in greater detail in the Material Safety Data sheets for the individual products and should be referred to for fuller information.

All recommendations for the use of our products, whether given by us in writing, verbally, or to be implied from the results of tests carried out by us, are based on the current state of our knowledge. Notwithstanding any such recommendations the Buyer shall remain responsible for satisfying himself that the products as supplied by us are suitable for his intended process or purpose. Since we cannot control the application, use or processing of the products, we cannot accept responsibility therefor. The Buyer shall ensure that the intended use of the products will not infringe any third party's intellectual property rights. We warrant that our products are free from defects in accordance with and subject to our general conditions of supply.

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