

Agomet® F311 with Hardener Powder or Hardener Pastes Two part methacrylate mixing adhesive system

Key properties

- Systems suitable for hand or machine mixing with selected hardeners
- 20 minute work-life, 35 minute handling strength
- Gap filling to 8 mm
- Bonds well to a wide range of metals and plastic materials
- Good temperature performance

Description

Agomet F311 with hardener powder or hardener paste is a room temperature curing, methacrylate adhesive suitable for bonding metals and plastics. Its high setting rate at room temperature allows handling of the bonded parts within a very short time. The adhesive has a potlife of 20 minutes. As early as 35 minutes after joining (curing at room temperature), the parts can be handled. The final strength is attained within 24 hours. Bonds produced with Agomet F311 show good tensile shear and peel strengths as well as good thermal stability between -40°C and +130°C.

Product data

Properties	Agomet F 311	Hardener Paste	Hardener Powder
Colour (visual)	Beige	White or Red	White Powder
Specific gravity	ca.1.0	-	-
Viscosity (Pas)	ca. 25	Paste	Powder
Gelation time (mins) at 23°C	Mixed system ca. 20 minutes		

Processing

Pretreatment

The strength and durability of a bonded joint are dependant on proper pretreatment of the surfaces to be bonded, however the methacrylate adhesives can be used effectively with little surface preparation.

Ideally joint surfaces should be cleaned with a good degreasing agent such as acetone, iso-propanol or proprietary degreasing agent in order to remove all traces of oil, grease and dirt. Low grade alcohol, gasoline (petrol) or paint thinners should never be used.

The strongest and most durable joints are obtained by either mechanically abrading or chemically etching ("pickling") the degreased surfaces.

Mixing ratio	Parts by weight			Parts by volume		
Agomet F311	100	100	100	100	100	100
Hardener Powder	3 (2-5)	-	-	-	-	-
Hardener Paste white or red	-	3 (2-5)	-	-	3 (2-5)	-
Hardener D (or K100 Red)	-	-	10	-	-	10

For mixing by hand use hardener powder or hardener paste and stir until homogenous.

For automatic metering units use Agomet Hardener D at 10:1 ratio by volume. Mixing by machine can be made using commercially available static mixers.

Application of adhesive

Agomet F311 can be processed in temperatures ranging from 15 to 30°C. Higher temperatures may significantly reduce the work-life.

The resin/hardener mix is applied directly to the prepared and dry joint surfaces.

Apply adhesive directly to one surface. A layer of adhesive 0.15 to 0.25 mm thick will normally impart the greatest lap shear strength to a joint, although joints of up to 8 mm gap can be assembled.

The joint components should be assembled and clamped as soon as the adhesive has been applied. An even contact pressure throughout the joint area will ensure optimum cure.

Mechanical processing

Specialist firms have developed metering, mixing and spreading equipment that enables the bulk processing of adhesive. We will be pleased to advise customers on the choice of equipment for their particular needs.

Equipment maintenance

All tools should be cleaned before adhesives residues have had time to cure. The removal of cured residues is a difficult and time-consuming operation.

If solvents such as acetone are used for cleaning, operatives should take the appropriate precautions and, in addition, avoid skin and eye contact.

Curing speed

Times to minimum shear strength

Temperature	°C	10	15	23	40
Cure time to reach	hours	2½	1½	-	-
LSS > 1N/mm ²	minutes	-	-	35	15
Cure time to reach	hours	3	2	-	-
LSS > 10N/mm ²	minutes	-	-	50	25

LSS = Lap shear strength.

Typical cured properties

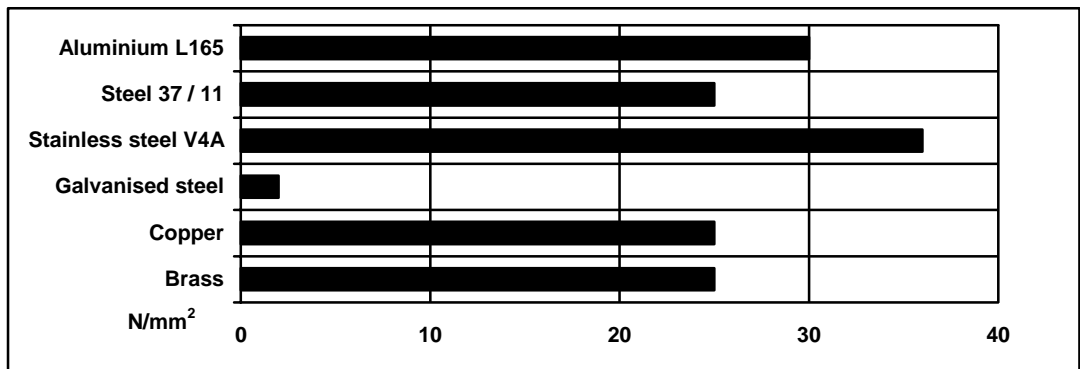
Unless otherwise stated, the figures given below were all determined by testing standard specimens made by lap-jointing 170 x 25 x 1.5 mm strips of aluminium alloy. The joint area was 12.5 x 25 mm in each case.

The figures were determined with typical production batches using standard testing methods. They are provided solely as technical information and do not constitute a product specification.

Average lap shear strengths of typical metal-to-metal joints (ISO 4587)

Cured for 7 days at 23°C and tested at 23°C

Pretreatment - Sand blasting

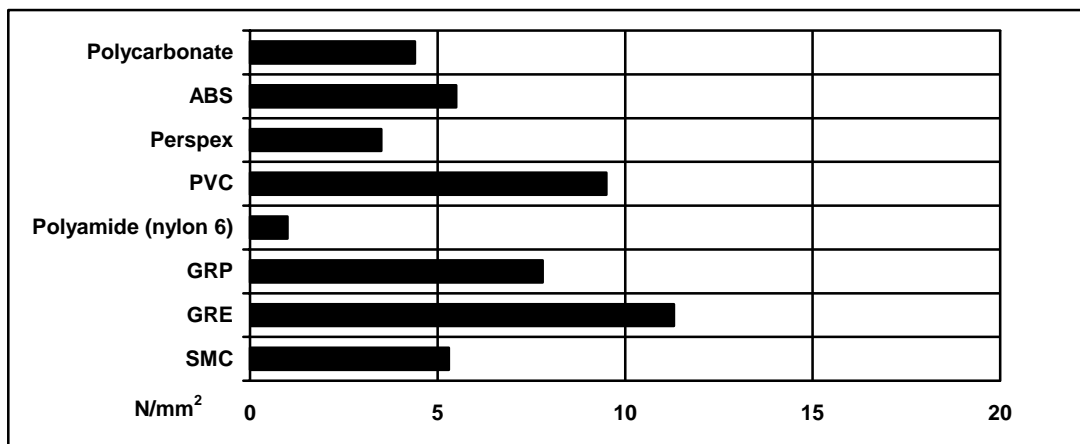


Average lap shear strengths of typical plastic-to-plastic joints (ISO 4587)

Cured for 7 days at 23°C and tested at 23°C

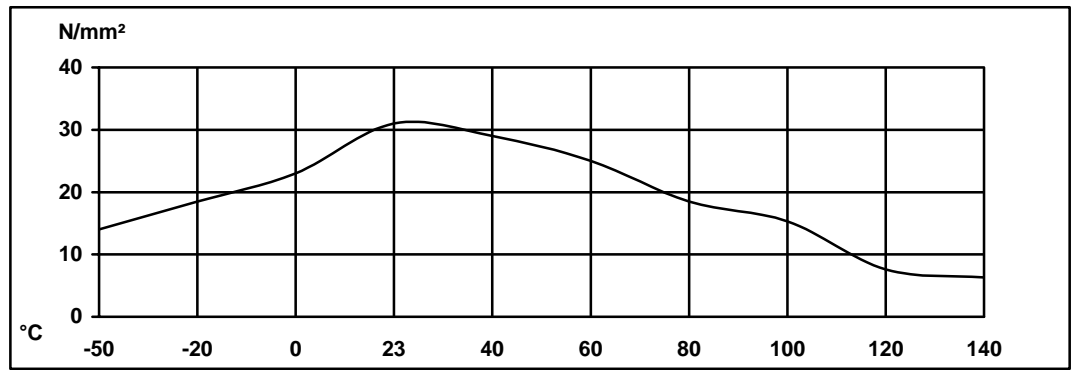
Pretreatment - Lightly abrade and isopropanol degrease.

Note - failure modes are mainly substrate failure



Lap shear strength versus temperature (ISO 4587) (typical average values)

Cure: = 7 days at 23°C



Roller peel test (ISO 4578) at 23°C

6 N/mm

Glass Transition Temperature (Tg)

No clear transition – refer to LSS/temp. and G'/temp

Tensile strength ISO R527 type 1

32 MPa

Elongation at break:

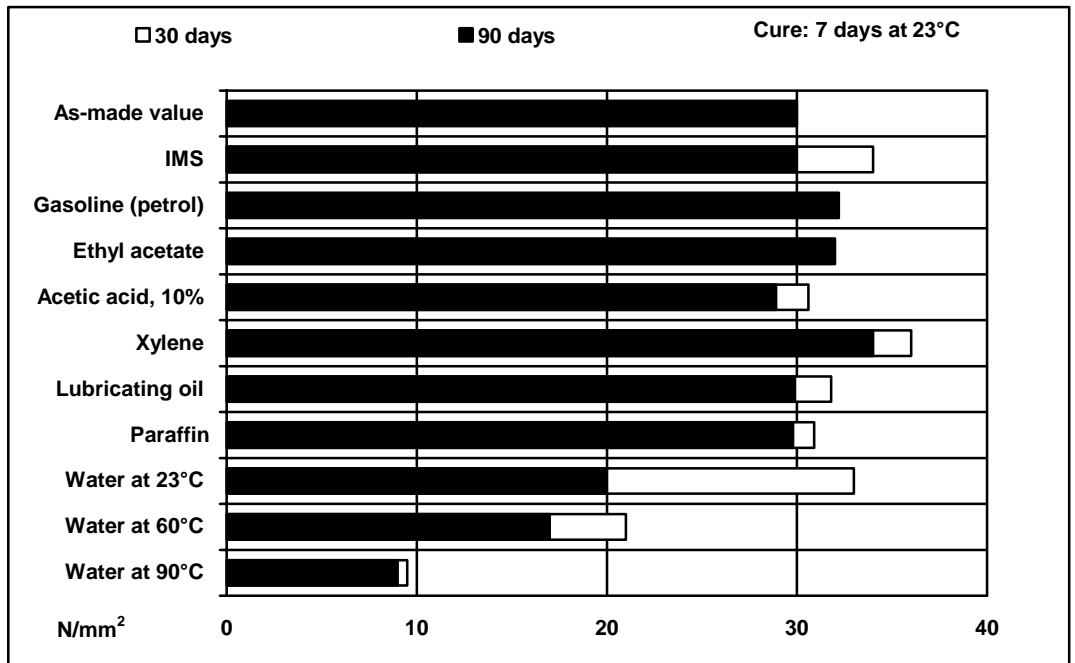
2.3%

Coefficient of thermal expansion (-30°C/+30°C)

$70 \times 10^{-6} / ^\circ K$ (Cured 7 days at 23°C)

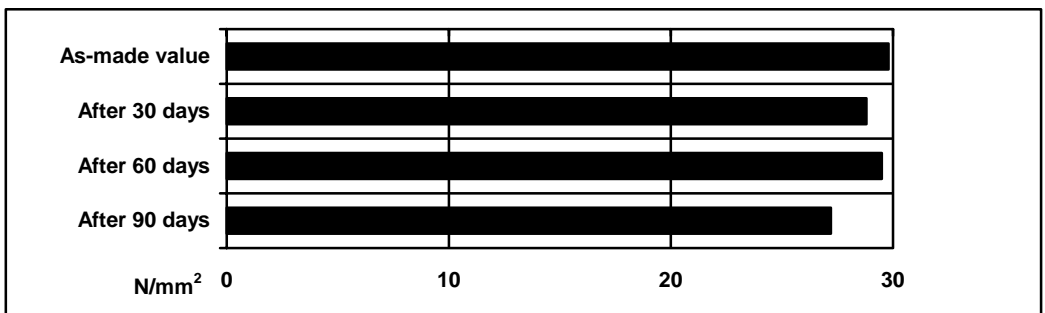
Lap shear strength versus immersion in various media at 23°C (typical average values)

Substrate – gritblasted aluminium



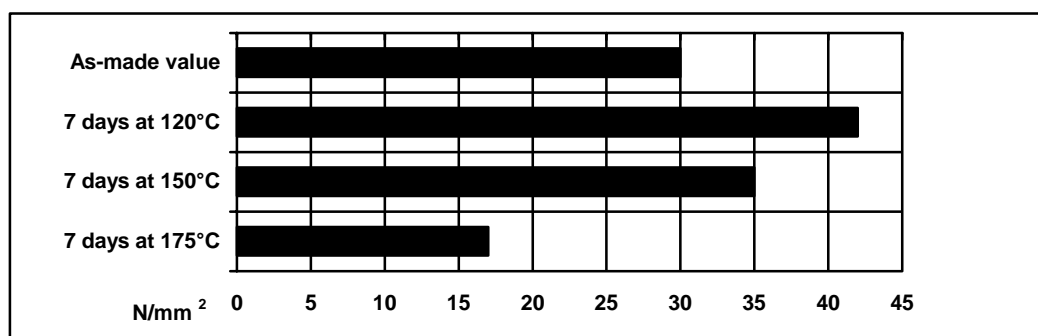
Lap shear strength versus tropical weathering (40/92, DIN 50015; typical average values)

Cure: 7 days at 23°C



Lap strength versus heat ageing

Cure: 7 days at 23°C



Shear modulus (DIN 53345)

cured 7 days at 23°C

Temperature	G' modulus	^ (Tan delta)
30°C	0.85 GPa	9.6×10^{-2}
50°C	0.7 GPa	1.0×10^{-1}
70°C	0.4 GPa	1.7×10^{-1}
90°C	0.2 GPa	3.2×10^{-1}
110°C	53 MPa	5.0×10^{-1}
130°C	10 MPa	6.2×10^{-1}

Storage

Agomet F311 and Agomet hardeners may be stored for up to 36 months at 2-8°C provided the components are stored in sealed containers. When stored at 23°C the life is a maximum of 6 months. The expiry date, assuming 2-8°C storage, is indicated on the packaging.

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.

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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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