

Agomet® P 79 A/B

Two component epoxy adhesive for general purpose bonding

Properties

Agomet P 79 A/B, a cold-curing two-component epoxy adhesive, consists of a light grey epoxy resin (component B) and a blue-grey hardener (component A).

The flash point is above 100 °C.

Joints produced with Agomet P 79 A/B have good shear strength, good thermal and moisture resistance. Agomet P 79 A/B also fills gaps. Similar viscosity, flow behavior, and specific weight of the two components permit simple processing by means of dosing and mixing equipment.

Bondable Materials	Metals, including non-ferrous metals. Rigid plastics, and suitably pretreated PA, PE and POM. Wood, glass, and ceramic materials.
Viscosity (23 °C)	Component B (resin): appr. 100 Pa.s Component A (hardener): appr. 140 Pa.s
Specific gravity (23° C)	Component A: appr. 1.6 Component B: appr. 1.6

Processing

Surface Preparation	The surfaces to be joined must be free of all contaminants and, most important, free of grease and dust. A mechanical roughening must be recommended. Plastics which are difficult to bond, such as PE, PP, or POM, must be subjected to a special pretreatment before bonding such as exposure to flames, pickling, corona or plasma treatment.
Mixing Ratio	Resin (component B) and hardener (component A) are mixed homogeneously in the ratio of 1 : 1.
Potlife at Room Temperature	The processing time of the mixed material is approximately 60 minutes, depending on the application temperature.
Bonding Process	The adhesive mixture is applied to the surfaces to be joined. After fitting the parts together, they must be fixed in place (contact pressure). The final strength is reached after about 24 hours. The curing time can be greatly shortened by raising the curing temperature: at 50 °C it is still about 4 hours, at 120 °C it is only about 10 minutes.

Bonding Performance

Tensile Shear Strength	Aluminium AlCuMg 2 pl (Bondur F 44) appr. 15 N/mm ² <i>according to DIN 53 283, test specimen 100 x 25 x 1.6 mm, bonded area 300 mm², overlap 12 mm, pretreatment degreased, roughened.</i>
Peel Strength	Aluminum F 13.3 appr. 1.5 N/mm <i>measured by the T-peel test according to DIN 53 282, test specimen 100 x 30 x 0.5 mm, pretreatment degreased, roughened.</i>

Thermal
Stability

The thermal stability of bonded joints, such as those obtained by use of Agomet[®] adhesives, depends on the bonded materials themselves as well as their pretreatment. In general, the following applies: A long-term serviceability of the bond is maintained between about -30 °C up to about +80 °C. Above 80 °C, the strength decreases distinctly up to a temperature of about 120 °C, and at higher temperatures it decreases very rapidly. Brief periods of heating to temperatures of 180 - 200 °C without mechanical loading, such as during a paint bake cycle, detract only slightly from the bonded joint.

Advice

Storage
Stability

Please see labels: a minimum of 4 months in the original unopened container.

Before processing, and especially after an extended storage period, resin and hardener must be stirred thoroughly.

**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 therefore. 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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