

Advanced Materials**Araldite® F348 / Hardener F348**

Structural Adhesives

TECHNICAL DATA SHEET**Araldite® F348 / Hardener F348**

Two component toughened methacrylate adhesive system

Key properties

- **Fast setting**
- **Bonds well to a wide range of metals and plastics materials**
- **Tolerant to "less than ideal" pretreatment**
- **Gap filling up to 8 mm**
- **Tough flexible bonds for use in dynamic environment**

Description

Araldite® F348 / Hardener F348 is two component, room temperature curing, flexible, methacrylate adhesive. It is a fast setting product, ideal for bonding and repair on metals, composites and thermoplastics.

Product data

Property	Araldite® F348	Hardener F348	Mix
Colour (visual)	Beige	Red	Red
Specific gravity	1.0	1.1	1.0
Viscosity at 25°C (Pas)	thixotropic	60	thixotropic
Pot Life (100 gm at 25°C)			10 min.

Processing**Pretreatment**

The strength and durability of a bonded joint are dependant on proper treatment of the surfaces to be bonded.

At the very least, joint surfaces should be cleaned with a good degreasing agent such as acetone or other proprietary degreasing agents 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. Abrading should be followed by a second degreasing treatment.

Mix ratio	Parts by weight	Parts by volume
Araldite® F348	100	100
Hardener F348	11	10

Araldite® F348 / Hardener F348 is available in cartridges incorporating mixers and can be applied as ready to use adhesive with the aid of the tool recommended by Huntsman Advanced Materials.

Application of adhesive

The resin/hardener mix may be applied manually or robotically to the pretreated and dry joint surfaces. Huntsman's technical support group can assist the user in the selection of a suitable application method as well as suggest a variety of reputable companies that manufacture and service adhesive dispensing equipment.

A layer of adhesive 0.05 to 0.10 mm thick will normally impart the greatest lap shear strength to the joint. Huntsman stresses that proper adhesive joint design is also critical for a durable bond. The joint components should be assembled and secured in a fixed position as soon as the adhesive has been applied.

For more detailed explanations regarding surface preparation and pretreatment, adhesive joint design, and the dual syringe dispensing system, visit www.araldite2000plus.com.

Equipment maintenance

All tools should be cleaned with hot water and soap 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.

Times to minimum shear strength

Temperature	°C	10	15	23	40
Cure time to reach	hours				
LSS > 1MPa	minutes	25	20	15	< 5
Cure time to reach	hours				
LSS > 10MPa	minutes	35	30	20	10

LSS = Lap shear strength.

Typical cured properties

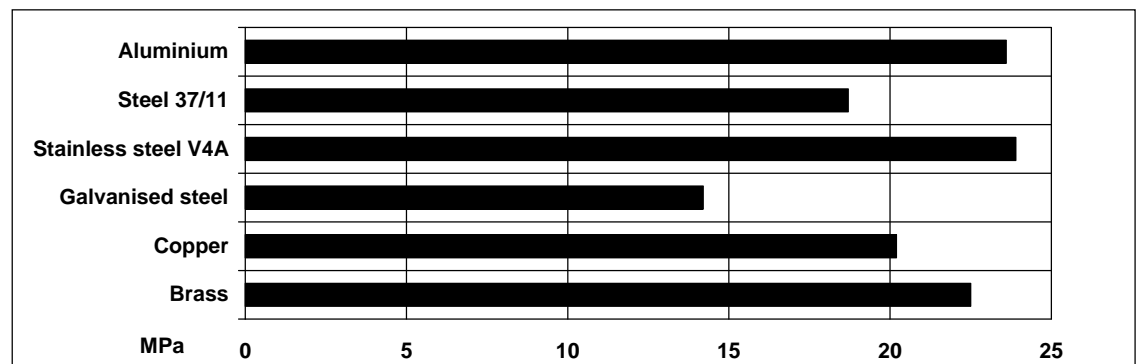
Unless otherwise stated, the figures given below were all determined by testing standard specimens made by lap-jointing 114 x 25 x 1.6 mm strips of aluminium alloy. The joint area was 12.5 x 25 mm in each case.

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)

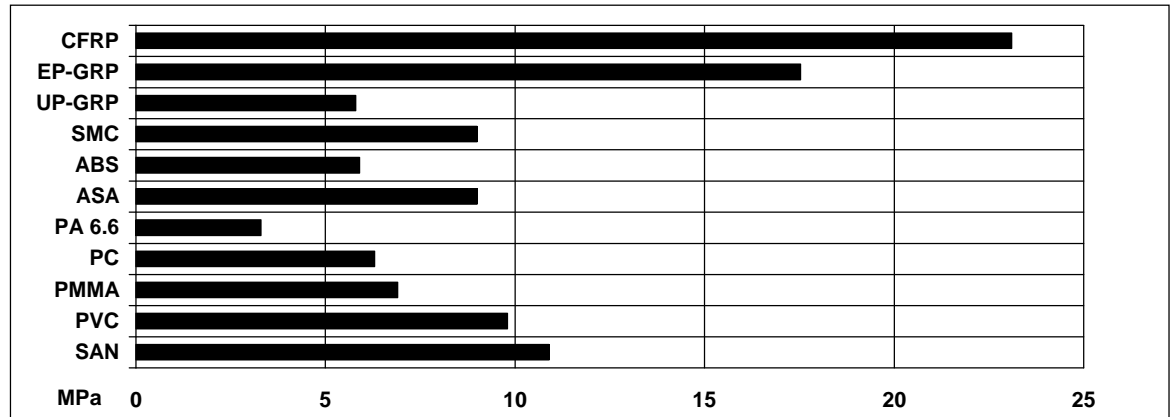
Cured for 16 hours at 40°C and tested at 23°C

Pretreatment - Sand blasting



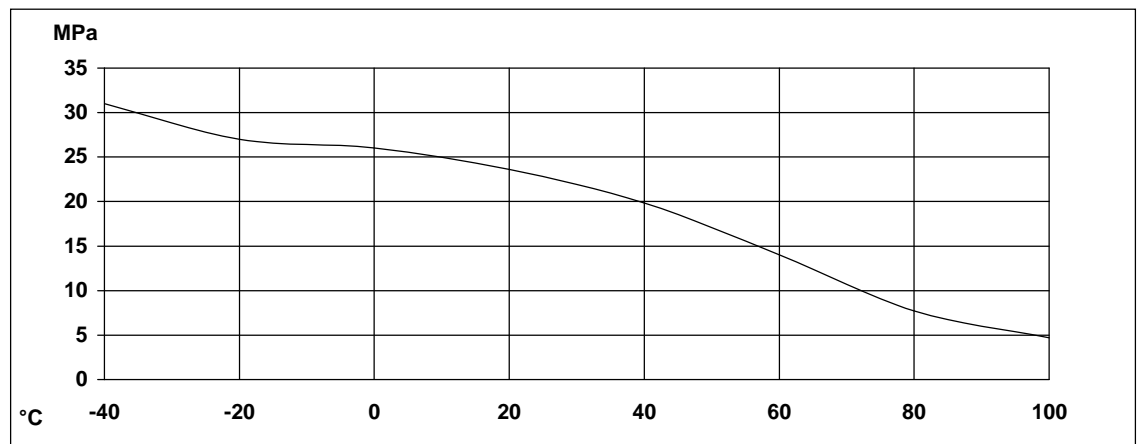
Average lap shear strengths of typical plastic-to-plastic joints (ISO 4587)

Cured for 16 hours at 40°C and tested at 23°C. Pretreatment - Lightly abrade and alcohol degrease.



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

Cure: (a) = 16 hrs at 40°C



Roller peel test (ISO 4578)

Cured: 16 hours/40°C

5.4 N/mm

Glass transition temperature (DMA) ISO 6721

Cure: 16 hours at 40°C

67°C

Shear modulus G' (DIN 53445)

Cure: 16 hours/40°C

-40°C	-	1.1 GPa
0°C	-	353 MPa
23°C	-	166 MPa
80°C	-	2.8 MPa
120°C	-	1.5 MPa

Shore Hardness D (ISO868/03)

D 48

Thermal cycling

100 cycles of 6 hours duration from -30°C to 70°C:

19.8 MPa

E - modulus (ISO R527) at 23°C

364 MPa

Tensile strength (ISO R527) at 23°C

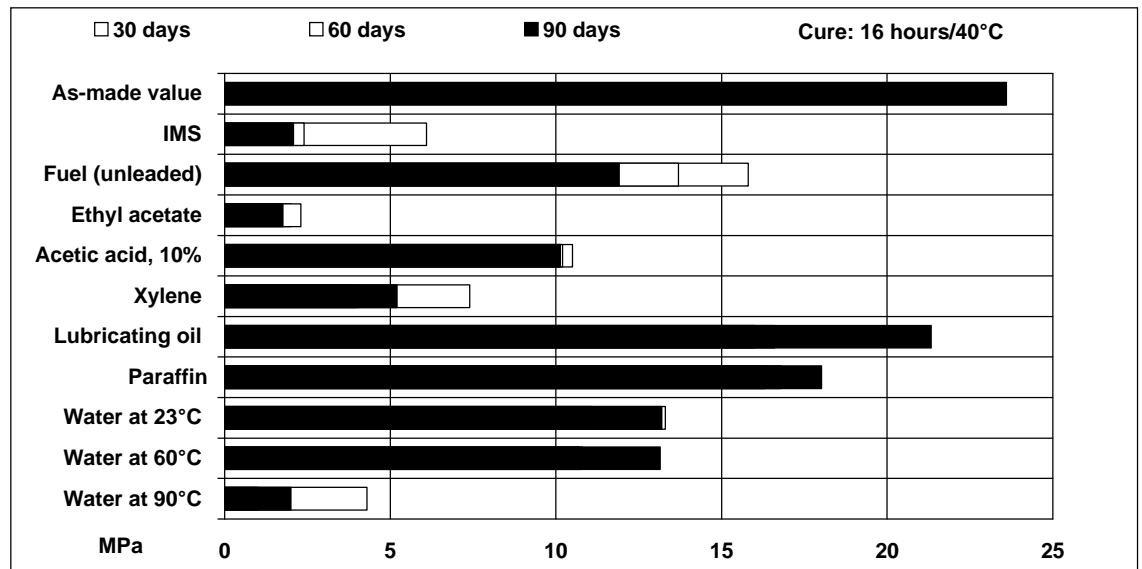
13 MPa

Elongation at break

91 %

Lap shear strength versus immersion in various media (typical average values)

Unless otherwise stated, L.S.S. was determined after immersion for 90 days at 23°C

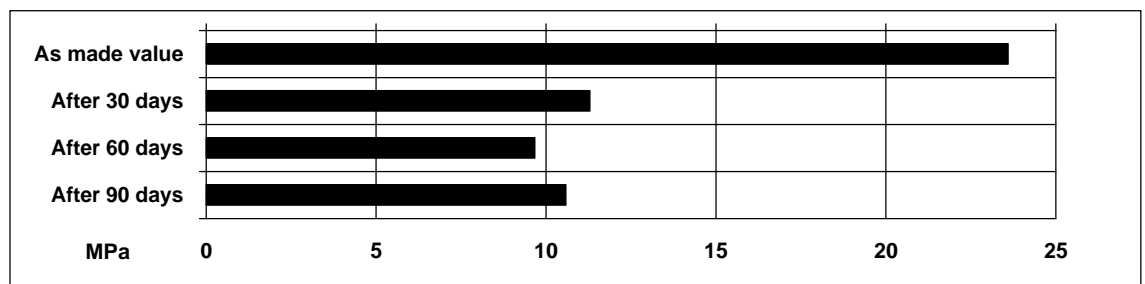


Lap shear strength versus tropical weathering

(40/92, DIN 50015; typical average values)

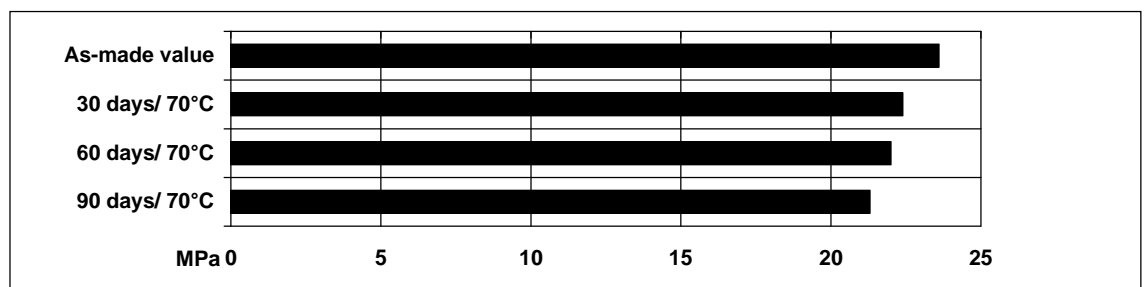
Cure: 16 hours/40°C

Test: at 23°C



Lap shear strength versus heat ageing

Cure: 16 hours/40°C



Storage

Araldite® F348 and Hardener F348 may be stored for up to 2 years at 2 – 8 °C or 6 months at room temperature provided the components are stored in sealed containers. The expiry date is indicated on the label.

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.

Huntsman Advanced Materials

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Huntsman Advanced Materials

(Switzerland) GmbH
Klybeckstrasse 200
4057 Basel
Switzerland

Tel: +41 (0)61 299 11 11

Fax: +41 (0)61 299 11 12

www.huntsman.com/advanced_materials