

Agomet[®] Hardener Lacquer 2

Quick drying hardener lacquer for use with Agomet[®] adhesives “NO MIX SYSTEM”

Properties

NO-MIX-SYSTEM	Agomet [®] Hardener Lacquer 2 was especially developed for the NO-MIX-SYSTEM. With this system, the two components of the reaction adhesive are applied separately, which allows a bonding similar to one-component adhesives and avoids any potlife limitations. In addition to simple processing, the NO-MIX-SYSTEM also permits processing independent from place and time: you may prepare the parts to be joined in one place and bond later in a different place.								
Hardener System	Agomet [®] Hardener Lacquer 2 is a very rapidly drying hardener composition. Within 4 minutes after exposure to air, it forms a film which contains the hardener in very fine distribution. Parts coated with Hardener Lacquer 2 can be stored at room temperature for up to 30 days without noticeably changing the curing performance of the adhesive.								
Adhesives	With the use of Hardener Lacquer 2, a large number of Agomet [®] methacrylate adhesives can be processed similar to one-component adhesives. Particularly well suited are the following highly reactive AGOMET [®] adhesives: <table border="0" style="margin-left: 20px;"> <tr> <td>AGOMET[®] F 347</td> <td>AGOMET[®] F 310</td> </tr> <tr> <td>AGOMET[®] F 330</td> <td>AGOMET[®] F 311</td> </tr> <tr> <td>AGOMET[®] F 300</td> <td>AGOMET[®] F 315</td> </tr> <tr> <td>AGOMET[®] F 305</td> <td></td> </tr> </table> The NO-MIX-SYSTEM may also be applied to cure other than the above Agomet [®] methacrylate adhesives; in this case, however, we recommend preliminary tests. Agomet [®] Hardener Lacquer 2 is by no means suitable for curing epoxy or polyurethane adhesives such as our Agomet [®] P and Agomet [®] PU types.	AGOMET [®] F 347	AGOMET [®] F 310	AGOMET [®] F 330	AGOMET [®] F 311	AGOMET [®] F 300	AGOMET [®] F 315	AGOMET [®] F 305	
AGOMET [®] F 347	AGOMET [®] F 310								
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AGOMET [®] F 300	AGOMET [®] F 315								
AGOMET [®] F 305									

Bonding Procedure

Surface Pretreatment	All surfaces to be bonded must be free of any contamination and, most important, free of grease and dust. We advise mechanical roughening of the surfaces.
Application	Agomet [®] Hardener Lacquer 2 is applied to the surfaces to be bonded: <ul style="list-style-type: none"> - for joint gaps up to 0.4 mm, coating of just one surface will normally be sufficient - if the joint gap exceeds 0.4 mm, both surfaces must be coated with hardener lacquer. - avoid joint gaps of more than 0.8 mm. <p>You may apply the lacquer with a soft brush or a roller, but also by dipping or by spraying. In case of poor wetting, we recommend two brush-applied coats to ensure a perfect setting of the adhesive.</p> <p>The necessary amount of Hardener Lacquer 2 depends on the nature of the surfaces to be joined: smooth plastics and metals require about 30 g Hardener Lacquer 2 per square metre while rough, porous concrete surfaces need up to 150 g/sq.m.</p>
Further Processing	Surfaces coated with Hardener Lacquer 2 can be handled and processed as soon as the lacquer has dried (= after about 4 minutes). Even though the hardener component may lose some of its reactivity during an extended storage period, strength values are only slightly reduced after 30 days.

Bonding Since the adhesive can cure properly only together with Hardener Lacquer 2, it is important avoid thick beads of adhesive at the edges of surfaces to be joined: without Hardener Lacquer 2, the squeezed-out adhesive will not cure.

Bonding performance

Strengths The bond strengths obtained with Hardener Lacquer 2 are equivalent to those reached when mixing 3 % hardener paste into the adhesive. For more details, please see the product sheet of the individual adhesive.

Advice

Industrial Hygiene Agomet® Hardener Lacquer 2 contains also low-boiling solvents. For processing larger amounts of Hardener Lacquer 2, we recommend good ventilation of the workplace.

Storage Stability Please see label: a minimum of 6 months in the original, unopened container, without any reduction of reactivity. Storage temperature: 5 - 25°C.

Handling Precautions

Caution

Huntsman 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 into 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 Huntsman publication No. 24264/3/e Hygienic precautions for handling plastics products of Huntsman and in the Vantico Material Safety Data sheets for the individual products. These publications are available on request 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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