

Agomet[®] F 307 A/B

Two component liquid methacrylate adhesive for Ferrite Core assembly

Properties

Agomet F 307 A/B is a cold curing reaction adhesive that has proved particularly well suited for series production bonding of ferrite cores with a definite air gap.

Besides a very high curing rate, Agomet F 307 A/B features good peel strength and tensile shear strength values. Curing takes about 5 minutes, depending on ambient temperature. The final strength is reached after approximately 2 hours at room temperature.

Agomet F 307 A/B bonds have a low shrinkage. They resist moisture.

In many bonding operations, a particular surface preparation of the joints is not necessary or can be reduced to a minimum. Agomet F 307 A/B fills joint gaps.

The A/B system allows you to choose the bonding procedure best suited for the individual application - e.g. to apply the adhesive manually or with automated dosing/dispensing equipment.

Bondable Materials

Metals such as steel, aluminium, copper, zinc and their alloys as well as ferrites. Rigid PVC, ABS, polystyrene, polycarbonate, polyester mouldings and other rigid plastics.

	<i>Agomet F 307 A</i>	<i>Agomet F 307 B</i>
Viscosity (23 °C)	appr. 400 Pa.s	appr. 400 Pa.s
Density	appr. 1.4 g / cm ³	appr. 1.4 g / cm ³

Bonding Procedure

Surface Preparation

Even without a particular surface pre-treatment, Agomet F 307 A/B bonds develop good strength values. To optimise bonding strength, however, all joint surfaces must be free of loose impurities such as dust, oxides, grease, mould release agents, or plasticizers. A simple wipe with a solvent such as acetic ether 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.

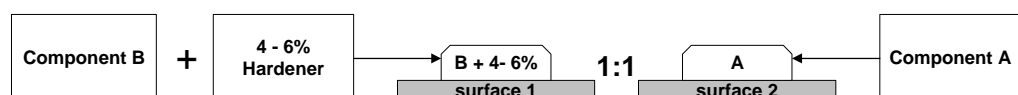
Mixing Ratio

Add 4 - 6 % hardener paste to component B and mix homogeneously. Then apply 1:1 together with the ready-to-use component A.

Bonding

Apply component A to one surface and place an equally thick layer of component B (hardener already mixed in) on the other surface. Then join the two parts immediately and keep under contact pressure. Curing starts only after both surfaces to be bonded have been joined.

This separate processing allows bonding operations practically independent of the adhesive's potlife.



Caution: Never mix hardener into component A!

Bonding
contin. You may also apply the adhesive with dosing/dispensing equipment, even by placing components A and B (incl. hardener) on top of each other on one of the surfaces to be joined. In this case, however, the parts must be mated immediately.

Bonding performance

Tensile-Shear Strength Aluminium/Bondur F44 (AlCuMg2pl): 18 N/mm²
*according to DIN 53 283
test specimen 100 x 25 x 1.6 mm
bonded area 300 mm²
surface preparation: degreased, roughened*

Advice

Storage Stability Please see labels: a minimum of 6 months in the original unopened container.
Storage conditions: cool and dry.
Once the hardener has been mixed in, component B can only be stored for about one week.

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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