

Advanced Materials**Araldite® AV 170****Structural Adhesives****Araldite® AV 170****One component epoxy adhesive****Key properties**

- Cures at 140-180°C
- Heat resistant to 120°C
- Very good peel strength
- Good chemical resistance
- Gap filling to 3mm
- Contains spacers to ensure a minimum bond line thickness of 0.05 mm

Description

Araldite® AV 170 is a multipurpose, one component heat curing thixotropic paste adhesive of high strength and toughness.

It is suitable for bonding a wide variety of metals, temperature resistant plastics and many other materials.

Product data

Property	Araldite® AV 170
Colour - visual (A112)*	Off-white
Specific gravity	1.15 - 1.20
Viscosity (Pas)	thixotropic paste
Lap shear strength at 80 °C (A501)*	> 20 MPa
Flash Point (°C)	> 100

** Specified data are on a regular basis analysed. Data which is described in this document as 'typical' is not analysed on a regular basis and is given for information purposes only. Data values are not guaranteed or warranted unless if specifically mentioned.*

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

Application of adhesive

The resin/hardener mix is applied with a spatula to the pretreated and dry joint surfaces.

A layer of adhesive 0.05 to 0.10 mm thick will normally impart the greatest lap shear strength to the joint. The adhesive contains spacers to ensure a minimum bond line thickness of 0.05 mm.

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 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.

Typical cure times

Minimum recommended cure schedule to reach LSS near to full cure (95%)					
Temperature	°C	140	160	180	220
Cure time	minutes	50	20	10	5

Typical LSS values on aluminium					
Temperature	°C	140	160	180	220
Cure time	minutes	60	60	60	60
Lap shear strength at 23°C	N/mm ²	23-26	26-30	28-30	30-32

Note: Temperatures below 140°C will not give adequate cure even when cure time is prolonged.

Cure temperature above 150°C should be avoided when joining materials of different coefficients of linear thermal expansion; otherwise stresses will be set up in the bond line on cooling. This effect is particularly marked where the bond surfaces are large.

At 220°C, cure time should not exceed 60 minutes

Typical cured properties

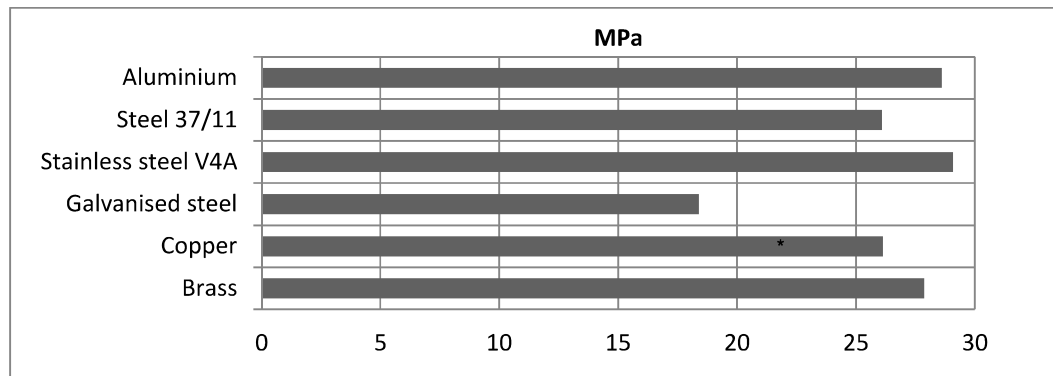
Unless otherwise stated, the figures given below were all determined by testing standard specimens made by lap-jointing 114 x 25 x 1.5 mm strips of aluminium alloy. The joint area was 12.5 x 25 mm in each case.

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) (typical average values)

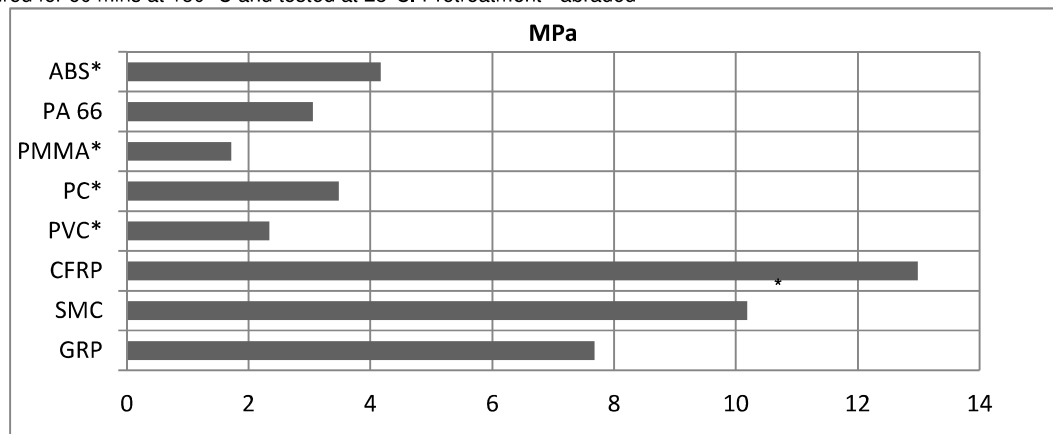
Cured for 60 mins at 150°C and tested at 23°C

Pretreatment - Sand blasting



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

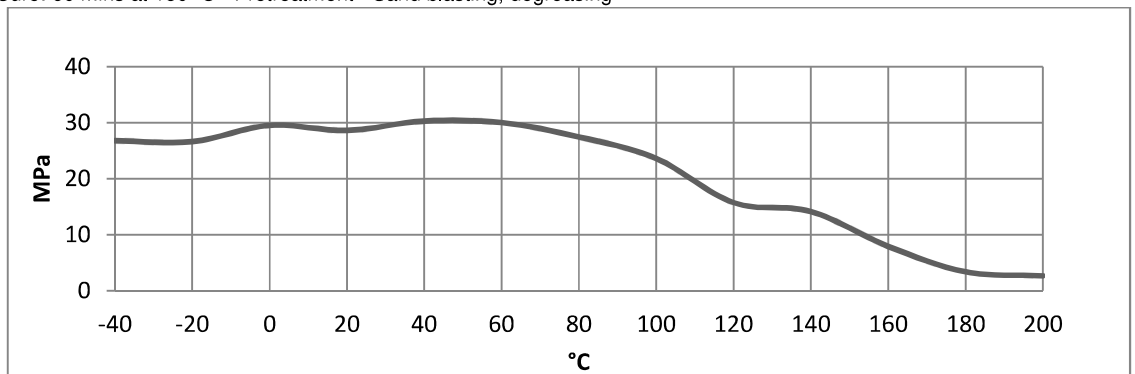
Cured for 60 mins at 150°C and tested at 23°C. Pretreatment - abraded



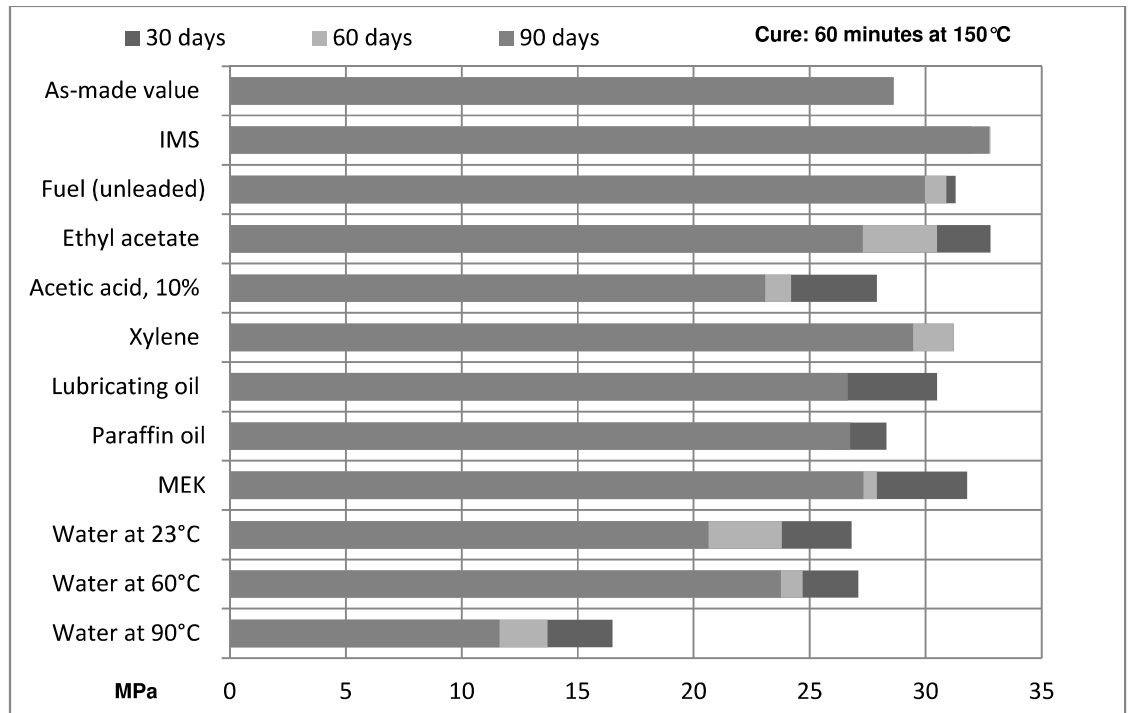
* : degradation of plastic substrates due to curing temperature conditions

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

Cure: 60 mins at 150°C - Pretreatment - Sand blasting, degreasing

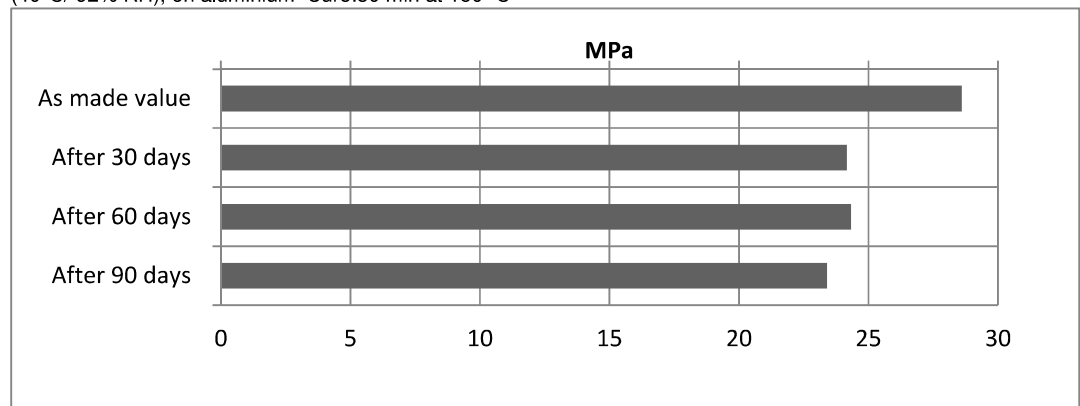


**Lap shear strength after 30,60 and 90 days immersion in various media at 23°C otherwise stated
(typical average values)**



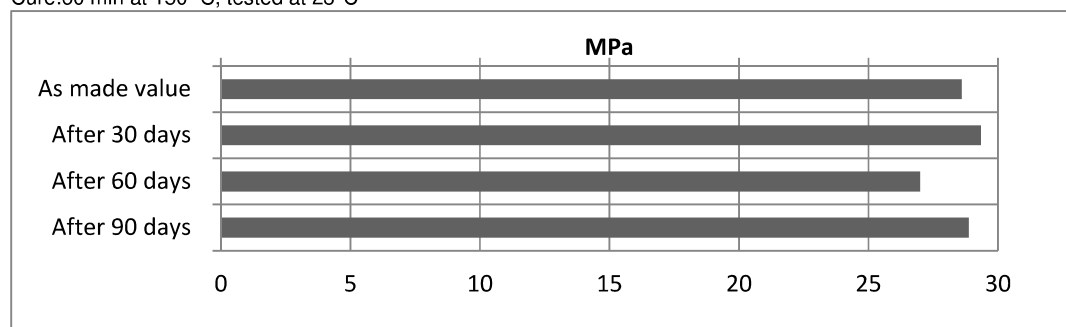
Lap shear strength versus tropical weathering (ISO 4587) (typical average values)

(40°C/ 92% RH), on aluminium Cure:30 min at 150°C



Lap shear strength versus heat ageing 70 °C for 30, 60 and 90 days. Typical average value on aluminium

Cure: 60 min at 150 °C, tested at 23 °C



Roller peel test (ISO 4578) (typical average values)

Cured 30 min/ 150 °C

5.8 N/mm

Cured 30 min/ 180 °C

6.6 N/mm

Glass Transition temperature (Tg)

129 °C (by DMA)

Thermal cycling cured 60 min at 150 °C

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

26.6 MPa

Tensile strength at 23 °C (ISO 527)

25 MPa

E-modulus

1639 MPa

Elongation at break

1.4 %

Shear modulus G' (ISO 6721)

Cure: 2 hours/150 °C

-20 °C - 1.27 GPa

0 °C - 1.18 GPa

23 °C - 1.10 GPa

60 °C - 0.88 GPa

100 °C - 0.63 GPa

150 °C - 13.3 MPa

180 °C - 13.3 MPa

Flexural Properties (ISO 178) Cure 2 hours/ 150 °C , tested at 23 °C

Flexural Strength

46 MPa

Flexural Modulus

2013 MPa

Shore Hardness (D scale) (ISO 868/03) Cure 2 hours/ 150 °C , tested at 23 °C, 50%RH

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Storage

Araldite AV 170 must be stored for up to 2 years at 2 - 8°C. At 15-25°C the life of the product is 6 months after removal from storage at 2 - 8°C. 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 warrants only that its products meet the specifications agreed with the user. Specified data are analysed on a regular basis. Data which is described in this document as 'typical' or 'guideline' is not analysed on a regular basis and is given for information purposes only. Data values are not guaranteed or warranted unless if specifically mentioned.

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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.aralditeadhesives.com