

## Structural Adhesives

### Araldite® AV 119 One component epoxy adhesive

#### Key properties

- Cures at 120-180°C
- Heat resistant to 120°C
- Very good peel strength
- Good chemical resistance
- Thixotropic - no flow during cure
- Gap filling to 3mm

#### Description

Araldite AV 119 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, ceramics, glass, rubber, temperature resistant plastics and many other materials.

#### Typical product data

	Araldite AV 119
Colour (visual)	Beige
Specific gravity	1.15 - 1.20
Viscosity (Pas)	thixotropic paste

#### 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 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.

### Curing times

Temperature	°C	120	140	150	160	180
Cure time	minutes	60	45	30	20	10
Lap shear strength at 23°C	N/mm <sup>2</sup>	20-23	25-28	27-30	29-32	30-33

Note: Temperatures below 120°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.

### Typical cured properties

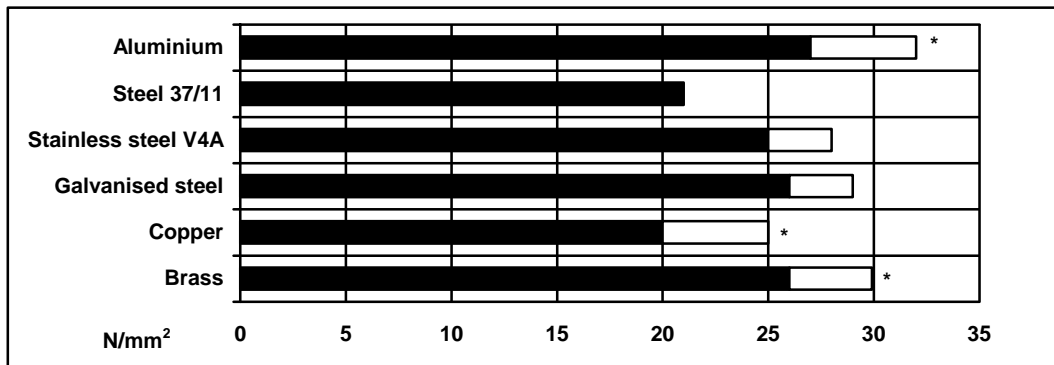
Unless otherwise stated, the figures given below were all determined by testing standard specimens made by lap-jointing 170 x 25 x 1.5 mm strips of aluminium alloy. The joint area was 12.5 x 25 mm in each case.

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)

Cured for 30 mins at 150°C and tested at 23°C

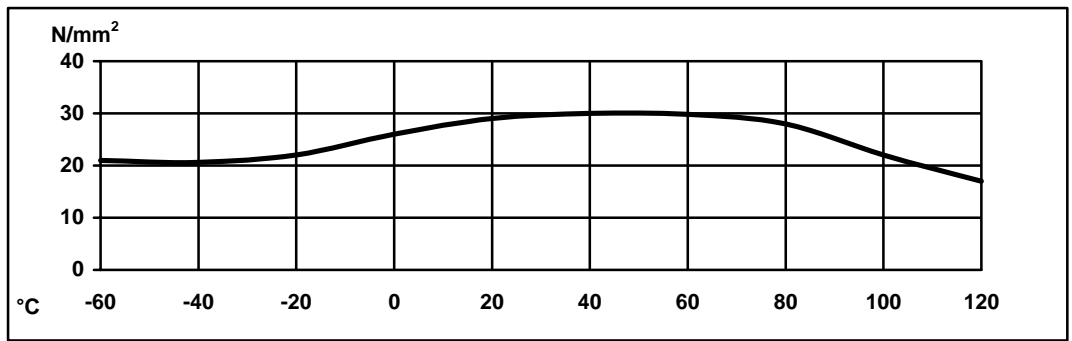
Pretreatment - Sand blasting



\* Failure stress close to elastic limit yield stress of the metal

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

Cure: 30 mins at 150°C



**Roller peel test (ISO 4578)**

8-10 N/mm

Cured 30 mins at 150°C

**Coefficient of thermal expansion (VDE 304)**

20 - 60°C

$57 \times 10^{-6}$

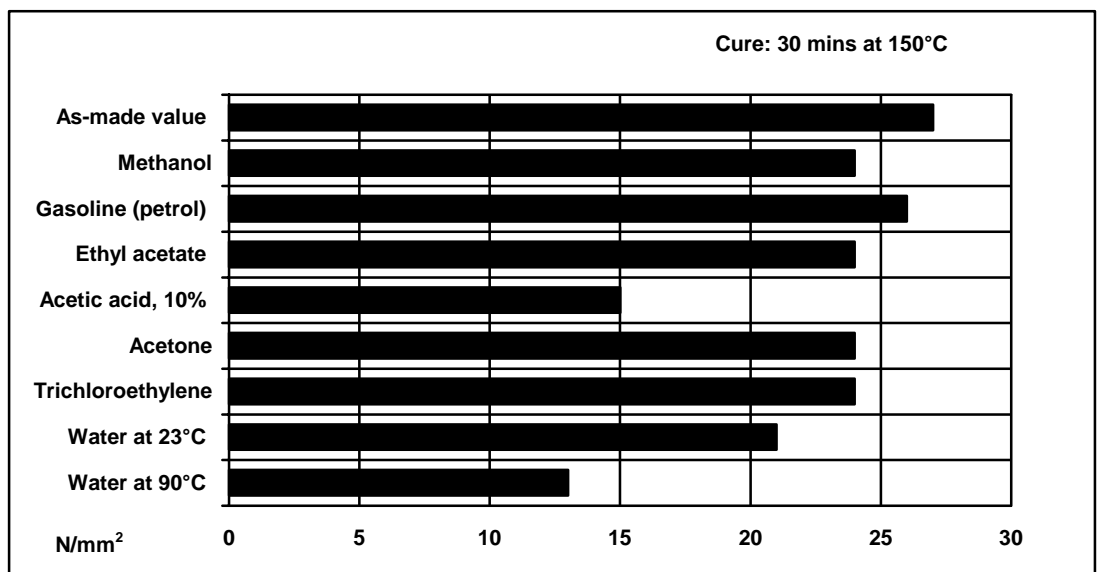
20 - 100°C

$68 \times 10^{-6}$

**Electrolytic corrosion (DIN 53489)**

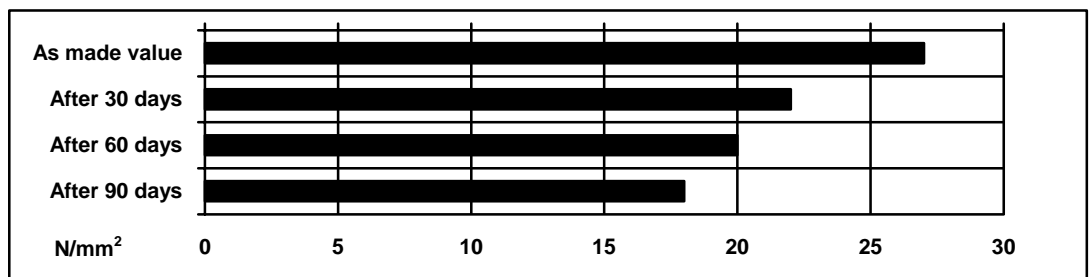
Grade A1

**Lap shear strength after 90 days immersion in various media at 23°C (typical average values)**



**Lap shear strength versus tropical weathering (40/92, DIN 50015; typical average values)**

Cure: 30 min at 150°C



**Shear modulus (DIN 53445)**

Cure:30min/150°C

25°C	-	1.4GPa
50°C	-	1.3GPa
75°C	-	1.1GPa
100°C	-	0.7GPa
125°C	-	0.3GPa
150°C	-	15MPa

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**Storage**

Araldite AV 119 may 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.

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**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.

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