

L-324

Two-component Paste Adhesive, High Toughness



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Product Data Sheet

Revised: 12/20/06

Description

L-324 is a two-component paste adhesive which will cure at room temperature. Using a modified epoxy resin formulation, L-324 is ideal for bonding metallic and non-metallic detail parts into finished assemblies. L-324 is especially modified for high toughness and excellent peel strength.

Advantages of L-324

- ❖ L-324 will find quick acceptance in the shop environment due to easy handling characteristics.
- ❖ The smooth consistency of L-324 allows for smooth mixing, cartridge filling, uniform extrusion into faying surfaces, and quick clean-up.
- ❖ L-324 has high toughness and excellent peel strength.

Properties

- *Form:* Extrudable Paste
- *Color Part A:* Gray
- *Color Part B:* Amber
- *Color Mixed A + B:* Light Gray
- *Mix Ratio:* 2A : 1B by weight

Pot Life

- 100 gram mass
- 60 minutes at Room Temperature (75°F or 24°C)

Availability

- 12 Pound (5.4 kg) Kit: 8 lbs Part A, 4 lbs Part B (3.6 kg Part A, 1.8 kg Part B)
- 60 Pound (27 kg) Kit: 40 lbs Part A, 20 lbs Part B (18 kg Part A, 9 kg Part B)

Shelf Life

- 12 months at Room Temperature (75°F or 24°C)

Cure Cycles

- Full Cure: 7 days at Room Temperature (75°F or 24°C)
- Handling Strength: 24 hours at Room Temperature (75°F or 24°C)
- Accelerated Cure: 2 hours at 150°F (65°C)

Mixing Procedure

- ❖ Combine 2 Parts A with 1 Part B (by weight) and mix thoroughly. If necessary, Part A may be pre-heated (up to 120°F or 49°C) to reduce the viscosity and allow for easier mixing. Apply immediately to bondline.

Mechanical Properties

Tensile Shear Strength (ASTM D 1002)

- -67°F (-55°C) 3300 PSI (22.7 MPa)
- RT 3400 PSI (23.4 MPa)
- 160°F (71°C) 1000 PSI (6.9 MPa)

T-Peel Using 0.020" (0.51 mm) Thickness Aluminum

- RT 45 in lb/in (200 N/25 mm)

Flatwise Tensile Strength with 1/8", 8 lbs/ft³ (3.175 mm, 128 kg/m³) Aluminum Core

- RT 1320 PSI (9.1 MPa)

CAUTION: Care should be taken with batches over 500 grams total weight. Large batches or those which are mixed in excess of recommended ratios may become exothermic (i.e., VERY HOT). The user is encouraged to develop standard batch mix sizes.

NOTICE:

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