

L-324LV

Two-component Paste Adhesive,
High Toughness, Low Viscosity



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Product Data Sheet

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Description

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

Advantages of L-324LV

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

Properties

- *Form:* Extrudable Paste
- *Color Part A:* Red
- *Color Part B:* Blue
- *Color Mixed A + B:* Purple
- *Mix Ratio:* 100A : 40B by weight
- *Shore D Hardness:* 75
- *Viscosity*
 - *Part A:* 4000 - 5000 Poise
 - *Part B:* 0.5 - 2.0 Poise

Pot Life

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

Availability

- 1 Gallon (3.8 L) Kit: 8 lbs Part A, 3.2 lbs Part B (3.6 kg Part A, 1.5 kg Part B)
- 5 Gallon (18.9 L) Kit: 40 lbs Part A, 16 lbs Part B (18.1 kg Part A, 7.3 kg Part B)

Shelf Life

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

Cure Cycles

- Full Cure: 5 days at Room Temperature (75°F or 24°C)
- Handling Strength: 16 hours at Room Temperature (75°F or 24°C)
- Accelerated Cure: 2 hours at 150°F (65°C)

Mixing Procedure

❖ Combine 100 Parts A with 40 Part B (by weight) and mix thoroughly. Apply immediately to bondline.

Mechanical Properties

Tensile Shear Strength (ASTM D 1002)

- -67°F (-55°C) 4050 PSI (27.9 MPa)
- RT 4230 PSI (29.2 MPa)
- 180°F (82°C) 980 PSI (6.8 MPa)

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

- RT 35 in lb/in (156 N/25 mm)

Compressive Strength (ASTM D695)

- RT 7300 PSI (50.3 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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