

July, 2015

APM Epicol 237399

Description	
System:	2-component or 1-component freezer adhesive
Colour:	dark grey / black
Viscosity:	viscous
Solid bodies:	100% / solvent-free
Pot life:	45 minutes
Curing:	at room temperature or in oven
Temp. range:	-55°C to +100 °C, dense up to +180°C

Specifications	
APM number:	237399
NASA/ESA outgassing:	< 2 % TML
	< 0.06 % CVCM
Fungal resistance:	Class I accepted
Directive 2011/65/EC:	RoHS compatible
EC No. 1907/2006:	compliant with REACH

APM Epicol 237399 is a high-strength epoxy adhesive which cures at room temperature. The adhesive is available as a 2-component adhesive or as a deep-frozen 1-component adhesive. APM Epicol 237399 is used as a construction adhesive and has excellent adhesion on metals. A thin glue line of 0.10 mm is typical. but this can be increased depending on the dimensions of the parts to be bonded, the temperature range of the application and the difference in thermal expansion. Due to its good tensile shear strength it is well suited for the ageing resistant bonding of ceramics or metals. Depending on the air humidity during the curing process the adhesive surface remains somewhat sticky. A dry surface can be achieved by curing at low air humidity or at high temperature in an oven.

Properties of fluid adhesive		
Colour of resin component A:	black	
Colour of resin component B:	yellowish brown	
Resin component:	epoxy resin	
Hardener component:	polyamide hardener	
Viscosity	Resin (25°C):	30 Pa.s
	Hardener (25°C):	1.0 Pa.s
	Mixture (25°C):	7.0 Pa.s
Mixture ratio A/B:	100 : 30 parts by wght.	
Mixture ratio A/B:	100 : 40 part by vol.	
Pot life at 25°C:	45 minutes	

Surface pretreatment / cleaning
The surfaces to be bonded must be dry and free from dust, oil, separating agents and other impurities. The type of surface pretreatment depends on the requirements profile. Above all, mechanical pretreatment, e.g. grinding or sand-blasting, achieves an improvement in adhesion for metals and in many cases for non-metallic surfaces as well. Glass surfaces and metallic surfaces can be cleaned with aqueous cleaners or clean solvents.

Mixing the adhesive components

The two adhesive components are weighed in the clean mixing beakers in the specified mixing ratio. The components must be machine mixed (Speedmixer) or manually without admixing air bubbles. To obtain a perfect mixture, produce between 10 g and 50 g of the mixture and then colour it homogeneously black after mixing.

Adhesion with deep-frozen mixtures

Remove the deep-frozen adhesive from the deep freeze and allow it to reach room temperature in the air. This requires 5 to 10 minutes depending on the cartridge size. As soon as the cartridge is no longer covered with condensation and the adhesive is fluid, work can start with dosing.

Applying the adhesive

The ideal processing temperature is between 20°C and 28°C. Viscosity falls at higher temperature and pot life shortens. The adhesive is applied from the cartridge using a dosing device. It can also be applied with a spatula. Optimum strength can be achieved with adhesive thicknesses of 0.05 to 0.15 mm. Optimum resistance is dependent on the temperature range and the expansion coefficients of single parts. A uniform adhesive thickness can be ensured by using a specific bond geometry or by inserting spacers, e.g. glass fibres or plastic beads. The parts are joined together and prevented from slipping during curing by attaching clamps or fixing devices.

Curing the adhesive

Room temperature	25°C	18 hours
Heating cabinet	40°C	6 hours
Heating cabinet	60°C	1 hours
Heating cabinet	120°C	5 minutes

After the adhesive is cured, the parts can be further processed. However, the bond only achieves optimum strength and resistance after a few days.

Properties of cured adhesive

Colour:	dark grey / black
Shore D (25°C):	80
Tensile strength (25°C):	30 N/mm ²
Modulus of elasticity (25°C):	2400 N/mm ²
Glass transition temperature:	58°C
Density (25°C):	1.2 g/cm ³
Decomposition temperature:	400 °C
Outgassing values:	< 2% TML
	< 0.06% CVCM

Cleaning the adhesive

Residue from non-cured adhesive on the substrates and processing equipment can be removed or cleaned using a solvent such as isopropanol or acetone. Organic solvents may lead to component destruction or stress cracking in plastics. For this reason, avoid use of aggressive solvents such as acetone, ketones and esthers. Comply with the official safety regulations when handling combustible solvents. Cured adhesive can only be removed mechanically. The adhesive becomes softer at temperatures over 100 °C.

Temperature stability

The typical application temperature range is from -55°C to +100°C. Depending on the application, the adhesive can also be used below -55°C. The adhesive becomes very hard at these temperatures and may result in cracks in the substrate or signs of the adhesive detaching from the substrate.

At temperatures above +100°C the adhesive becomes softer, which may be an advantage depending on the load since the adhesive can compensate for a variety of thermal expansion stresses without destroying the bond. After cooling down to room temperature, the adhesive assumes its usual properties. Thermal destruction of the adhesive only occurs at temperatures over 200 °C.

Tensile shear strength / test temperature

Aluminium, etched / at -40 °C	15 N/mm ²
Aluminium, etched / at +20 °C	18 N/mm ²
Aluminium, etched / at +60 °C	21 N/mm ²
Aluminium, etched / at +100 °C	3.5 N/mm ²

Deep-frozen cartridges

Processing 2-component adhesives poses risks to adhesive bond quality which is not tolerated in certain applications, e.g. space, aviation, electronics or medical technology. The individual components may become crystallised during storage or might separate from the filler; the mixing ratio may be incorrect, the mixture inhomogeneous or air bubbles may become admixed with the adhesive mixture. All these risks can be avoided if the mixing process if small quantities of adhesive (up to 55 cm³ cartridges) are used and the pot life is not too short (> 30 minutes).

Ageing resistance of adhesive bonds

The typical application temperature range of Epicol 237399 is from -55°C to +100°C. Adhesive bonds are very resistant to ageing within this temperature range. The cured adhesive demonstrates excellent temperature stability, humidity ageing resistance and solvent resistance.

Compliance

Epicol 237399 and all its constituents comply with the requirements of RoHS and REACH guidelines. Always comply with the safety data sheet when handling the adhesive.

Safety instructions

Avoid contact with skin and eyes. When applying the adhesive, always wear gloves and safety goggles. If adhesive comes into contact with the skin, do not use solvents to remove. Instead wash the affected area (hands) with warm water and soap and then dry. Liquid adhesive irritates on contact with the eyes and may lead to permanent eye damage. Before use, please observe the instructions in the safety data sheet.

Disposal

The liquid components of the adhesive must be disposed of as hazardous waste in the same way as synthetic resin or paint components. Under no circumstances mix large quantities (> 100 g) of the components for curing since the curing process is strongly exothermic and could result in the mixture heating up to a dangerous extent. Cured adhesive is disposed of as hazardous waste in the same way as thermosetting plastics depending on local legal requirements or as domestic waste.

Storage

The adhesive has maximum shelf life at temperatures between 15°C and 25°C. The shelf life of the two components is at least 24 months under these conditions. Higher temperatures shorten the standard shelf life. Lower temperatures cause a temporary higher viscosity. Deep-frozen 1-component adhesive (in cartridges) must always be stored at a temperature of below -40°C. At this temperature the mixture has a shelf life of at least 2 months. Never defrost the cartridges, otherwise the pot life is shorter or the adhesive is already cured. As a result the product is always delivered with dry ice at -78°C.

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Procurement

The unmixed adhesive is available as a 2-component set of 600 g or as a bipack. The deep-frozen adhesive is available in cartridges of 3 / 5 / 10 / 30 or 55 cc .

The specifications in this data sheet are based on meticulous tests and our previous experience in everyday practice. They are non-binding instructions, in the same way as our application advisories are also non-binding, whether verbal, in writing or by trials since we cannot accept any liability due to the wide variety of possible influences during processing and application. APM Technica AG disclaims all other explicit or implicit warranties, conditions and terms, be they of real or legal nature, including those which refer to usual market quality, their suitability for a particular use, satisfactory quality or observance of third-party trademarks. APM Technica excludes all liability to the extent permitted by law – whether arising from contract, quasi contract or tort (including negligence) – for direct, indirect and consequential damages, punitive damages awarded by court, loss of business of all kinds, loss of information or data or any other financial losses which may result from the sale, installation, maintenance, use, performance, failure or interruption of operation of the product or in connection therewith, even if we were informed of the possibility of occurrence of such damages. Data and other specifications concerning the nature and suitability of our products are non-binding general conditions and specifically represent no guarantee of certain characteristics. We advise you to perform your own adequate tests to determine the suitability of our products for your specific application. The user is himself responsible for defining the suitability of production methods mentioned in the technical data sheet for his purposes and for taking precautionary measures which are suitable to protect assets and persons from any danger which may occur during the handling and usage of these products. In all other cases our General Terms and Conditions of Business shall apply.