



TECHNICAL PRODUCT BULLETIN

GENERAL DESCRIPTION

AL419FDA is a two-part, heat-resistant and low exothermic epoxy adhesive formulation. It is a 100% solid epoxy adhesive, with superior chemical resistance and shear strength. AL419FDA contains a thixotropic agent, which impedes thinning out of the material during heat cure when properly mixed and cured.

ADVANTAGES

- Develops a strong bond
• Durable to numerous construction materials such as metals, glass, rubber, ceramics, concrete and phenolic plastics
• Provides premium resistance to water, salt solutions, galvanic action, acids, alkalies and most chemicals

FDA INFORMATION

Title 21 of the Code of Federal Regulations (CFR) permits and regulates the use of epoxy resins such as AL419FDA - Part A as an indirect food additive in food contact applications. Some of the sections of 21 CFR that support the above are 175.105, 175.300, 175.320, and 176.170.

AL419FDA - Part B complies with FDA regulations listed in the Title 21 of the CFR, Sections:

- 175.105 (c)(5) Adhesives
• 175.300 (b)(3)(viii)(c) Coatings - adjunct for epoxy resins
• 176.170 (b)(1) Components of paper and paper-board in contact with aqueous and fatty foods.
• 175.300 (b)(xxxii) Side seam cements

AL419FDA - Part B will comply with the above regulations as long as it is used only with other approved materials, and as long as the finished product conforms with extractives limitations for the use-situation as specified in those regulations.

SPECIFICATIONS

Table with 2 columns: Property and Value. Properties include Base (Epoxy), Solvent (None), Flammability (Non-Flammable), Color (Available in a variety of Colors), Solids Contents (100%), Coverage (250-350 ft²/gal), Shelf life (2 years, closed packaging, unopened), Service Temperature (-40°C to 165°C), Hardness SD (78), and Tensile Shear Strength Al to Al (2700 psi). Includes curing times for various temperatures.

WORKING TIME

AL419FDA's pot life and exotherm are dependent upon several factors: mass of resin, amount of catalyst used, ambient temperature and type of equipment used, among others. A 200 grams mix of 40% catalyst and 60% resin will have a pot life of approximately 120 minutes at room temperature. A 2:1 mix ratio of catalyst and resin will have 40 minutes pot life at room temperature.

The information given and the recommendations made herein are based on our research and are believed to be accurate but no guarantee of their accuracy is made. In every case we urge and recommend that purchasers before using any product in full scale production make their own tests to determine to their own satisfaction whether the product is of acceptable quality and is suitable for their particular purposes under their own operation conditions.



ALFA INTERNATIONAL CORPORATION

www.alfaadhesives.com

AL419FDA

Two-Part Epoxy Resin

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APPLICATION

1. Clean and thoroughly dry all surfaces to be bonded
2. Follow mixing-dispensing instructions as shown on package
3. Apply a thin coat of the mix (not more than 0.010 inches) by brush, spray, or roller to the surfaces to be bonded
4. Gently press surfaces firmly together

PACKAGING INFORMATION

AL419FDA is available in 50 grams divided plastic bags and in large unit (two-container) pint, quart, and gallon kits. Each kit consists of the correct amount of the specified epoxy material and curing agent hardener formulations, each supplied in separate containers with complete proportioning, use and cure instructions.

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