

Araldite® 1258 A/B Adhesive

Product Description

Araldite® 1258 A/B epoxy adhesive is a two-component, aluminum-filled paste. The system forms a bond that is often stronger than the materials being bonded. Araldite® 1258 A/B epoxy adhesive conforms to surfaces without heat or pressure, and hardens in 2-4 hours at room temperature. Formulated to give a strong, durable bond when used with a variety of substrates, this adhesive is well suited for many industrial maintenance applications. It has been approved by the Armed Forces for making emergency repairs in the field.

Applications

- Rebuilding machinery
- Lining wood or metal tanks
- General maintenance such as resetting screws or bolts, or plugging cracks in metal
- Patching cement and concrete
- Fastening loose bricks and stones in place.
- Repair plastic and conventional tools,
- Building nesting fixtures and fill holes in castings
- Repairing vacuum forms, air ducts and steam lines, radiators, cylinder drying tools, boiler jackets and other industrial equipment/parts

Features

- Easy to thoroughly mix by hand for small batches
- Bonds to steel, glass, porcelain, concrete and wood
- Can be sanded, filed or machined, drilled or threaded with conventional tools

Typical Properties*

Property	Test Method	Araldite® 1258 A Resin	Hardener 1258 B	Mixed System
Appearance	Visual	Light gray paste	Dark gray paste	--
Density, g/cm ³	ASTM D792	1.53	1.56	--
Viscosity at 25°C, CP	ASTM D2393	> 1,000,000	> 1,000,000	--
Pot life, 4 fl oz, at 25°C, min	--	--	--	23

*Properties are based on Huntsman test methods. Copies are available upon request

Processing

Mix Ratio

Product	Parts by weight	Parts by volume
Araldite® 1258 A Resin	100	100
Hardener 1258 B	82	100

Typical Cure Cycles

Temperature	Cure time
77°F (25°C)	6 hours
140°F (60°C)	30 min
212°F (100°C)	10 min

Pretreatment

The strength and durability of a bonded joint are dependent on proper pretreatment of the surfaces to be bonded. At the very least, joint surfaces should be cleaned with a good degreasing agent such as acetone or trichloroethylene, in order to remove all traces of oil, grease and dirt. Never use alcohol, gasoline or paint thinners. 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.

Typical Physical Properties

Unless otherwise stated, the data were determined with typical production batches using standard test methods. They are typical values only, and do not constitute a product specification.

Unless a different specification is given, the figures below were all determined by testing standard specimens made up by lap-jointing 4-in x 1-in x 0.06-in (10-cm x 2.5-cm x 1.5-mm) strips of aluminum. The joint area was 0.5 inch x 1 inch (12.5 mm x 2.5 cm) in each case. Samples were cured 7 d at 77°F (25°C) and values measured at 25°C.

Property	Value
Lap shear strength, psi (MPa) Cure:	
6 hours at 77°F (25°C)	2,560 (18)
24 hours at 77°F (25°C)	2,700 (19)
7 days at 77°F (25°C)	2,840 (20)
Lap shear strength*, psi (MPa) Test temperature:	
-76°F (-60°C)	2,280 (16)
77°F (25°C)	2,840 (20)
140°F (60°C)	1,140 (6)
176°F (80°C)	330 (2)

Advanced Materials

Technical Datasheet

Lap shear strength, after exposure to 120°F (49°C)/95 % R.H., psi (MPa)	
0 days	2,840 (20)
30 days	3,410 (24)
90 days	3,560 (25)
120 days	3,130 (22)

*Load applied 10 minutes after specimens reach test temperature.

Storage

Araldite® 1258 A/B Adhesive should be stored in a dry place, in the original sealed containers, at temperatures between 2°C and 40°C (36°F and 104°F). Under these storage conditions, the products have a shelf life of **3 years** (from date of manufacture). The products should not be exposed to direct sunlight.

If stored below 60°F, the adhesive should be brought to 60°F - 77°F and conditioned at this temperature for some time prior to use.

Precautionary Statement

Huntsman Advanced Materials Americas LLC maintains up-to-date Safety Data Sheets (SDS) on all of its products. These sheets contain pertinent information that you may need to protect your employees and customers against any known health or safety hazards associated with our products. Users should review the latest MSDS to determine possible health hazards and appropriate precautions to implement prior to using this material.

First Aid!

Refer to SDS as mentioned above.

KEEP OUT OF REACH OF CHILDREN

FOR PROFESSIONAL AND INDUSTRIAL USE ONLY

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