

Araldite® 2005 Adhesive

Product Description

Araldite® 2005 is a two- component, room temperature curing, methyl methacrylate adhesive for fast assembly operations on a wide range of substrates, including those which can be “difficult to bond”. No special handling or application techniques are required.

Key Features

- Good sanding properties.
- Ideal for bonding thermoplastics.
- Tolerant to “less than ideal” pre-treatment.

Typical Properties

Property	Test Method	RDA 2014-020 Resin (A)	RDA 2014-022 Activator (B)	A/B Mixed
Color	Visual	Off white	Light yellow	Beige
Specific Gravity	ASTM D792	0.99	0.97	0.97
Viscosity at 77F, cPs	ASTM D2393	130,000	50,000	--
Gel Time at RT, 3 grams total mass, minutes	ASTM D2471	--	--	4.00
Mix Ratio by volume	--	100	100	--
Mix Ratio by weight	--	100	98	--

Typical Cured Properties

Average handling shear strengths of typical treated steel to treated steel joints. Tested at 25°C (77°F) per ASTM D1002.

Property	Lap Shear Strength
10 minutes	210 psi
15 minutes	480 psi
20 minutes	1,180 psi

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Average lap shear strengths of typical metal to metal joints. Cure 24 hours at 25°C (77°F) and test at 25°C (77°F) per ASTM D1002.

Substrate	Lap Shear Strength
Treated steel	4,490 psi
Primed aluminum	4,290 psi

Average lap shear strengths of typical plastic to plastic joints. Cure 24 hours at 25°C (77°F) and test at 25°C (77°F) per ASTM D1002.

Substrate	Lap Shear Strength
ABS	Substrate Failure
PVC	Substrate Failure
PC	Substrate Failure

Processing

Application of Adhesive

The resin/hardener mix is applied with a spatula to the pre-treated and dry joint surfaces.

For the best results, the two surfaces being bonded should be free of oil, dirt, moisture and other such contaminants and should be slightly roughed or sanded to remove the gloss.

A layer of adhesive 0.002 to 0.004-inches (0.05 to 0.10-mm) thick will normally impart the greatest lap shear strength to a joint.

The joint components should be assembled and clamped as soon as the adhesive has been applied. Even contact throughout suffices to ensure proper cure.

Standard Test Specimens

Unless otherwise stated, the figures given below were all determined by testing standard specimens made up by lap-jointing 4-inch x 1-inch x 0.06-inch (10-cm x 2.5-cm x 1.5-mm) strips of steel, RC#14. The joint area was 0.5 x 1 inch (12.5 mm x 2.5 cm) in each case.

Storage

Araldite® 2005 should be stored during 12 months at 2°C – 8°C in a dry place, in its sealed original container. The product may be placed at room temperature before use. The total time at 15°C – 25°C (59°F – 77°F) should not exceed 6 months from date of shipping from Huntsman. The product should not be exposed to direct sunlight.

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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

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