

Araldite® 2010-1 Adhesive

Product Description

Araldite® 2010-1 structural adhesive is a fast cure, multipurpose, two component, room temperature curing, thixotropic paste adhesive of high strength and toughness. It is suitable for bonding a wide variety of metals, ceramics, glass, rubbers, rigid plastics, and most other materials in common use.

Features

- Fast curing
- Toughened
- Low shrinkage
- High shear and peel strength
- Bonds a wide variety of materials
- One-to-one mix ratio

Typical Properties*

Property	Araldite® 2010-1 A	Araldite® 2010-1 B	Mixed System
Appearance	Neutral	Grey paste	Grey paste
Density, g/cm ³	~1.16	~1.15	~1.16
Viscosity at 25°C, cP	~140,000	~65,000	~80,000
Flash point (°F)	>392	257	--
Pot life at 25°C, 100 g, min	--	--	~10

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

Processing

Mix Ratio

Product	Parts by weight	Parts by volume
Araldite® 2010-1 A	100	100
Araldite® 2010-1 B	100	100

Pretreatment

The strength and durability of a bonded joint are dependent on proper treatment of the surfaces to be bonded. At the very least, joint surfaces should be cleaned with a good degreasing agent such as acetone, isopropanol (for plastics) or other proprietary degreasing agents in order to remove all traces of oil, grease and dirt. Low-grade alcohol, gasoline, or paint thinners should never be used. 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.

Araldite 2010-1 structural adhesive is available in cartridges incorporating mixers and can be applied as ready to use adhesive with the aid of the tool recommended by Huntsman Advanced Materials.

Application of adhesive

The resin/hardener mix may be applied manually or robotically to the pretreated and dry joint surfaces. Huntsman's technical support group can assist the user in the selection of a suitable application method as well as suggest a variety of reputable companies that manufacture and service adhesive dispensing equipment. A layer of adhesive 0.002 to 0.004 in (0.05 to 0.10 mm) thick will normally impart the greatest lap shear strength to the joint. Huntsman stresses that proper adhesive joint design is also critical for a durable bond. The joint components should be assembled and secured in a fixed position as soon as the adhesive has been applied. For more detailed explanations regarding surface preparation and pretreatment, adhesive joint design, and the dual syringe dispensing system, visit www.araldite2000plus.com.

Equipment Maintenance

All tools should be cleaned with hot water and soap before adhesives residues have had time to cure. The removal of cured residues is a difficult and time-consuming operation. If solvents such as acetone are used for cleaning, operatives should take the appropriate precautions and, in addition, avoid skin and eye contact.

Cure times to reach minimum shear strength

Temperature, °F	50	59	73	104	140	212
Cure time to reach LSS* > 145 psi (1 MPa), hours	4	2	-	-	-	-
minutes	-	-	30	15	5	<5
Cure time to reach LSS > 1450 psi (10 MPa), hours	24	9	3	1	-	-
minutes	-	-	-	-	20	5

*LSS = Lap shear strength

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 by lap-jointing 4.5 x 1 x 0.063 in (114 x 25 x 1.6 mm) strips of aluminum alloy. The joint area was 0.5 x 1 in (12.5 x 25 mm) in each case.

Samples were cured at 104°F (40°C) for 16 hours and tested at 23°C, unless otherwise noted.

Property	Value			Test Method
Average lap shear strength of metal-metal joints, sand blasting pre-treatment, psi				ISO 4587
Aluminum	2,727			
Steel 37/11	1,958			
Stainless steel V4A	3,321			
Galvanized steel	2,611			
Copper	2,857			
Brass	2,538			
Average lap shear strength of typical plastic-plastic joints, lightly abrade and alcohol degrease pre-treatment, psi				ISO 4587
GRP	725			
CFRP	1,871			
SMC	856			
ABS	479			
PVC	363			
PMMA	189			
Polycarbonate	363			
Polyamides	348			
Lap shear strength, after immersion in 23°C media, psi	30 days	60 days	90 days	ISO 4587
As-made value	--	--	3,336	
IMS	3,046	2,611	2,466	
Gasoline	3,989	3,916	3,191	
Ethyl acetate	2,321	2,611	3,046	
Acetic acid, 10%	3,046	2,466	2,176	
Xylene	3,771	3,336	3,191	
Lubricating oil	2,176	2,611	3,916	
Paraffin	2,321	2,466	3,336	
Water at 73°F	4,061	2,756	3,336	
Water at 140°F	1,233	1,015	1,160	
Water at 194°F	1,015	1,015	1,160	

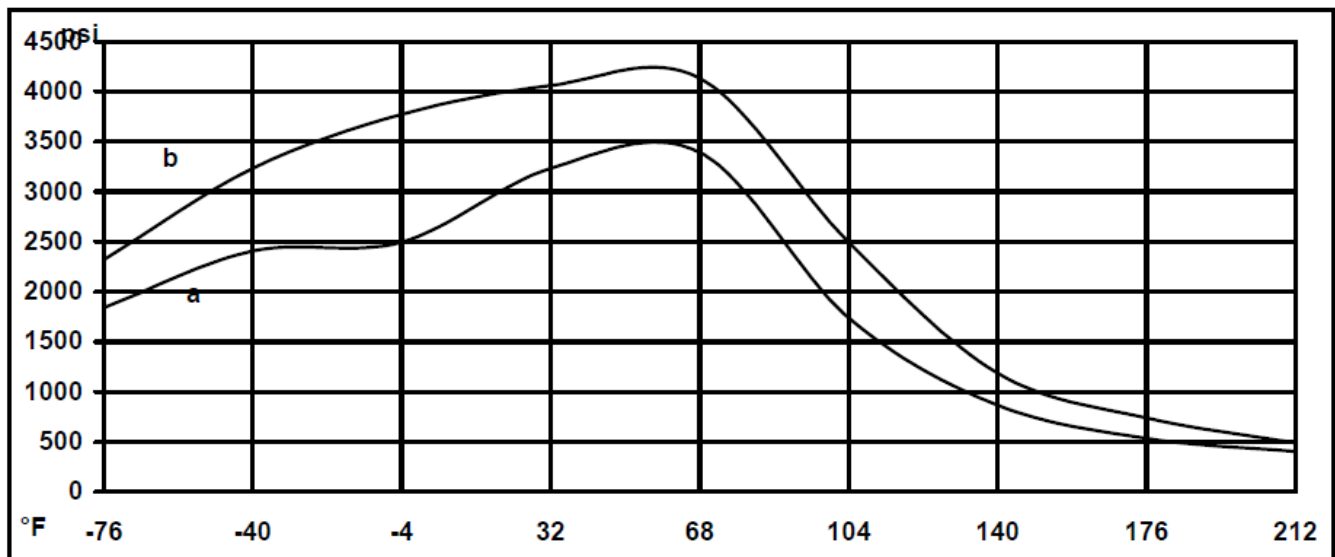
Lap shear strength, exposure to tropical weather,* psi (MPa)		DIN 50015
Standard - As Prepared	3,336	
30 days	2,611	
60 days	1,740	
90 days	1,595	
Lap shear strength, heat aging at 158°F, psi		--
Standard - As prepared	3,336	
30 days	3,350	
60 days	3,495	
90 days	3,481	
Roller peel test, pli (N/mm)	34 (6.0)	ISO 4578
Glass transition temperature, T _g , DSC Cure: 24 hours at 73°F + 1 hour at 176°F	~104°F (40°C)	Huntsman
Flexural strength, psi (MPa)	6,527 (45)	ISO 178
Flexural modulus, psi (MPa)	274,847 (1895)	ISO 178
Thermal cycling [†] , 100 cycles of 6 hour duration from -22°F to 158°F, psi (MPa)	4,293 (29.6)	--

*40/92, DIN 50015; typical average values; test at 23°C.

[†]Test carried out using a load cycle frequency of 90 Hz.

Figure 1. Lap shear strength versus temperature (ISO 4587) (typical average values)

Cure: (a) = 7 days at 73°F (23°C); (b) = 24 hours at 73°F (23°C) + 30 min / 176°F (80°C)



Storage

Araldite® 2010-1 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 product has a shelf life of **3 years** (from date of manufacture). The product 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

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