

## Structural Adhesives

### Araldite® 2014 (AW 139/XB 5323) Two component epoxy paste adhesive

#### Key properties

- Low out gassing / volatile loss
- Temperature resistant to 120°C
- Very resistant to water and a variety of chemicals
- Gap filling, non sagging up to 5mm thickness wide
- Good bonds to a wide variety of substrates

#### Description

Araldite 2014 is a two component, room temperature curing, thixotropic paste adhesive of high strength with good environmental and excellent chemical resistance.

Used for bonding of metals, electronic components, GRP structures and many other items where a higher than normal temperature or more aggressive environment is to be encountered in service. The low out gassing makes this product suitable for specialist electronic telecommunication and aerospace applications.

#### Product data

	2014/A	2014/B	2014 (mixed)
Colour (visual)	beige paste	grey paste	grey paste
Specific gravity	ca. 1.6	ca. 1.6	ca. 1.6
Viscosity (Pa s)	150 - 350	thixotropic	thixotropic
Pot Life (100 gm at 25°C)	-	-	40 minutes
Shelf life (2 - 40°C)	3 years	3 years	-

#### Processing

##### Pretreatment

The strength and durability of a bonded joint are dependant 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 or other proprietary degreasing agents in order to remove all traces of oil, grease and dirt.

Low grade alcohol, gasoline (petrol) 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

Mix ratio	Parts by weight	Parts by volume
Araldite 2014/A	100	100
Araldite 2014/B	50	50

Resin and hardener should be blended until they form a homogeneous mix.

Resin and hardener are also 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 is applied with a spatula to the pretreated and dry joint surfaces. A layer of adhesive 0.05 to 0.10 mm thick will normally impart the greatest lap shear strength to the joint. The joint components should be assembled and clamped as soon as the adhesive has been applied. An even contact pressure throughout the joint area will ensure optimum cure.

**Mechanical processing**

Specialist firms have developed metering, mixing and spreading equipment that enables the bulk processing of adhesive.

We will be pleased to advise customers on the choice of equipment for their particular needs.

**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.

**Times to minimum shear strength**

Temperature	°C	10	15	23	40	60	100
Cure time to reach	hours	16	9	3.5	-	-	-
LSS > 1N/mm <sup>2</sup>	minutes	-	-	-	75	26	6
Cure time to reach	hours	24	11.5	6	-	-	-
LSS > 10N/mm <sup>2</sup>	minutes	-	-	-	105	30	6

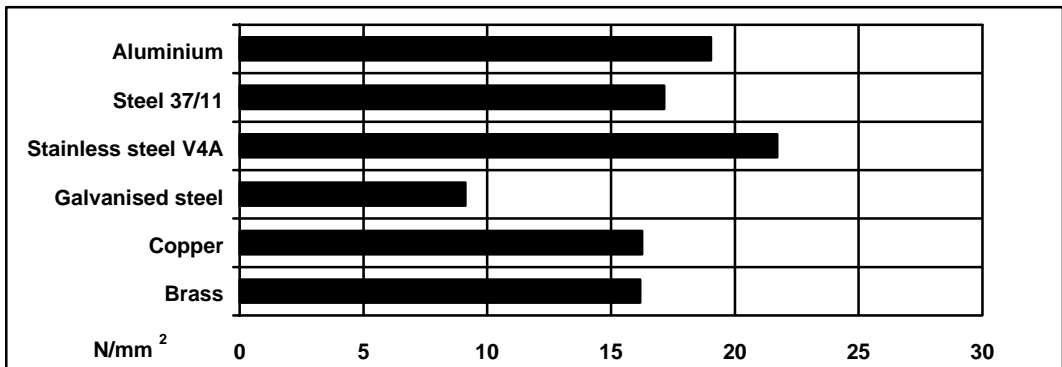
LSS = Lap shear strength.

**Typical cured properties**

Unless otherwise stated, the figures given below were all determined by testing standard specimens made by lap-jointing 170 x 25 x 1.5 mm strips of aluminium alloy. The joint area was 12.5 x 25 mm in each case. The figures were determined with typical production batches using standard testing methods. They are provided solely as technical information and do not constitute a product specification.

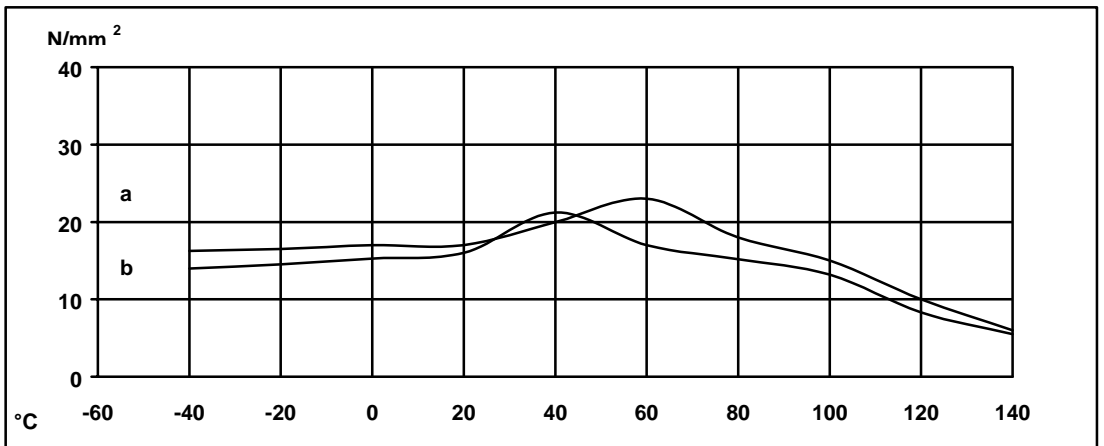
**Average lap shear strengths of typical metal-to-metal joints (ISO 4587)**

Cured for 16 hours at 40°C and tested at 23°C  
 Pretreatment - Sand blasting



**Lap shear strength versus temperature (ISO 4587) (typical average values)**

Cure: (a) = 7 days /23°C; (b) = 24 hours/23°C + 30 minutes/80°C



**Roller peel test (ISO 4578)** (Cured 16 hours/40°C) 3.0 N/mm

**Glass transition temperature (DSC)**

Cure: 24 hours at 23°C plus 1 hour at 80°C: ca. 85°C

**Shear modulus (DIN53445)** Cure 16 hours/40°C

50°C - 1.2 GPa	100°C - 180 MPa
75°C - 400 MPa	125°C - 20 MPa

**E - modulus (ISO R527) at 23°C** 4 GPa

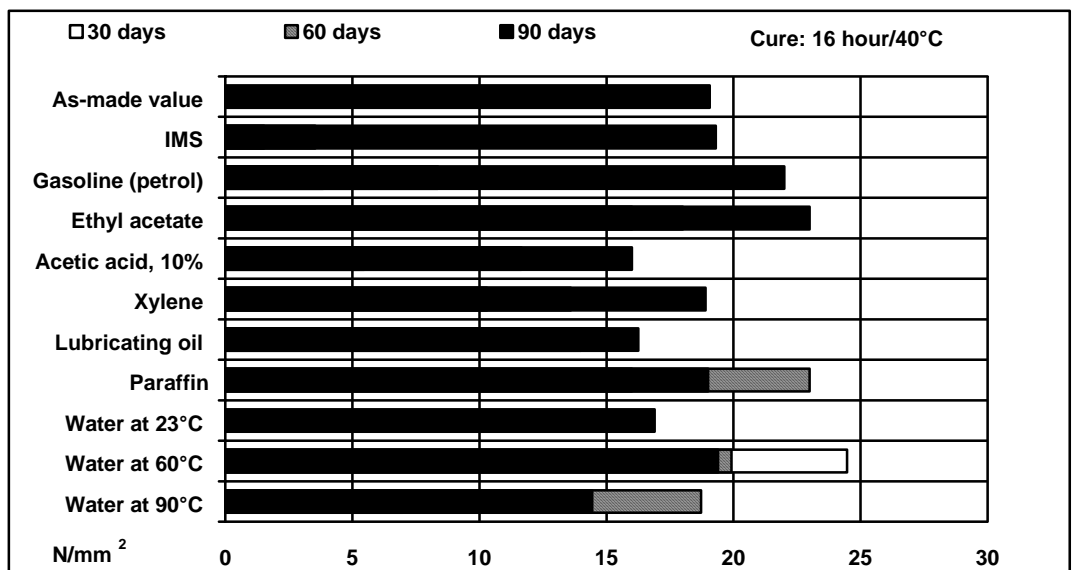
**Flexural Properties (ISO 178)** Cure 1 day/ 23°C +30mins/ 80°C tested at 23°C

Flexural Strength	61.0 MPa
Flexural Modulus	4354.9 Mpa

**Tensile strength (ISO R527) at 23°C** 26 MPa 0.7% elongation at break

**Lap shear strength versus immersion in various media (typical average values)**

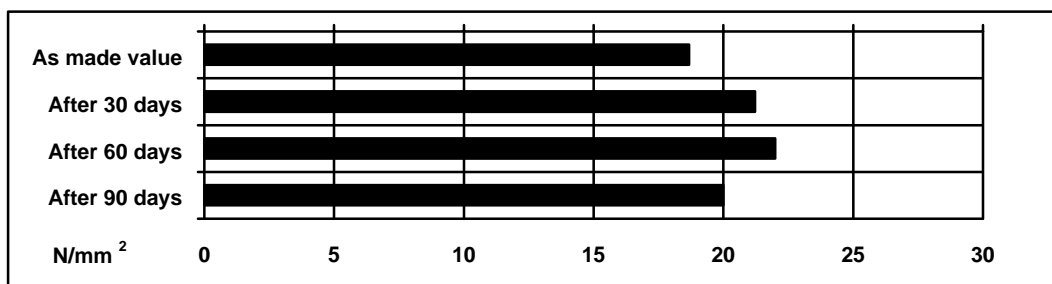
Unless otherwise stated, L.S.S. was determined after immersion for 90 days at 23°C



### Lap shear strength versus tropical weathering

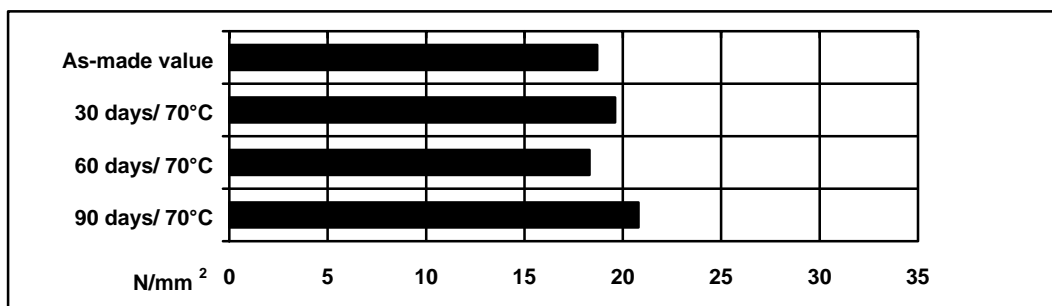
(40/92, DIN 50015; typical average values)

Cure: 16 hours/40°C Test: at 23°C



### Lap shear strength versus heat ageing

Cure: 16 hours/40°C



## Storage

Araldite 2014/A and Araldite 2014/B may be stored for up to 3 years at room temperature provided the components are stored in sealed containers. The expiry date is indicated on the label.

## Handling precautions

### Caution

Our products are generally quite harmless to handle provided that certain precautions normally taken when handling chemicals are observed. The uncured materials must not, for instance, be allowed to come into contact with foodstuffs or food utensils, and measures should be taken to prevent the uncured materials from coming in contact with the skin, since people with particularly sensitive skin may be affected. The wearing of impervious rubber or plastic gloves will normally be necessary; likewise the use of eye protection. The skin should be thoroughly cleansed at the end of each working period by washing with soap and warm water. The use of solvents is to be avoided. Disposable paper - not cloth towels - should be used to dry the skin. Adequate ventilation of the working area is recommended. These precautions are described in greater detail in the Material Safety Data sheets for the individual products and should be referred to for fuller information.

## Huntsman Advanced Materials

All recommendations for the use of our products, whether given by us in writing, verbally, or to be implied from the results of tests carried out by us, are based on the current state of our knowledge. Notwithstanding any such recommendations the Buyer shall remain responsible for satisfying himself that the products as supplied by us are suitable for his intended process or purpose. Since we cannot control the application, use or processing of the products, we cannot accept responsibility therefor. The Buyer shall ensure that the intended use of the products will not infringe any third party's intellectual property rights. We warrant that our products are free from defects in accordance with and subject to our general conditions of supply.

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