

Structural Adhesives

Araldite® 2011 (AW 106/HV 953U) Two component epoxy paste adhesive

Key properties

- High shear and peel strength
- Tough and resilient
- Good resistance to dynamic loading
- Bonds a wide variety of materials in common use

Description

Araldite 2011 is a multipurpose, two component, room temperature curing, paste adhesive of high strength and toughness.

It is suitable for bonding a wide variety of metals, ceramics, glass, rubber, rigid plastics and most other materials in common use. It is a versatile adhesive for the craftsman as well as most industrial applications.

Product data

	2011/A	2011/B	2011 (mixed)
Colour (visual)	neutral	pale yellow	pale yellow
Specific gravity	ca. 1.15	ca. 0.95	ca. 1.05
Viscosity (Pas)	30-50	20-35	30-45
Pot Life (100 gm at 25°C)	-	-	100 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, iso-propanol (for plastics) 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 2011/A	100	100
Araldite 2011/B	80	100

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	24	12	7	2	-	-
LSS > 1N/mm ²	minutes	-	-	-	-	30	6
Cure time to reach	hours	36	18	10	3	-	-
LSS > 10N/mm ²	minutes	-	-	-	-	45	7

LSS = Lap shear strength.

Typical cured properties

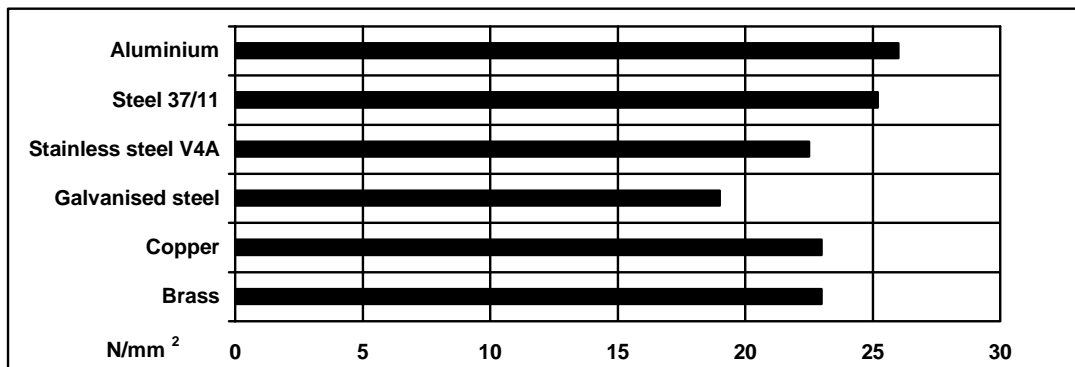
Unless otherwise stated, the figures given below were all determined by testing standard specimens made by lap-jointing 170 x 25 x 1.5 mm strips of aluminium alloy. The joint area was 12.5 x 25 mm in each case.

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

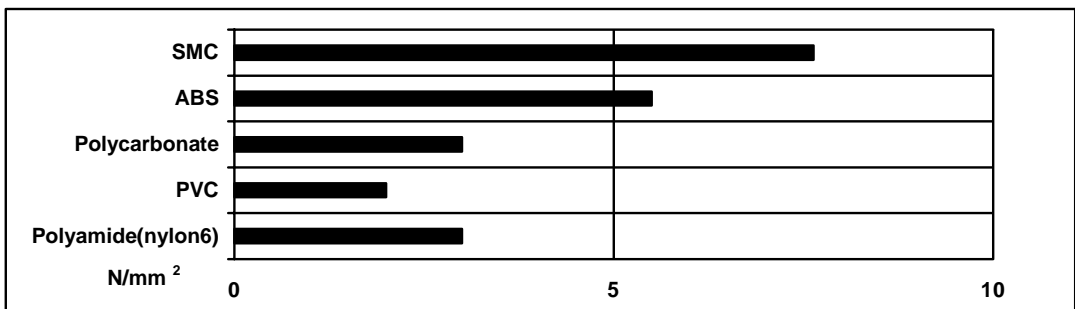
Pretreatment - Sand blasting



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

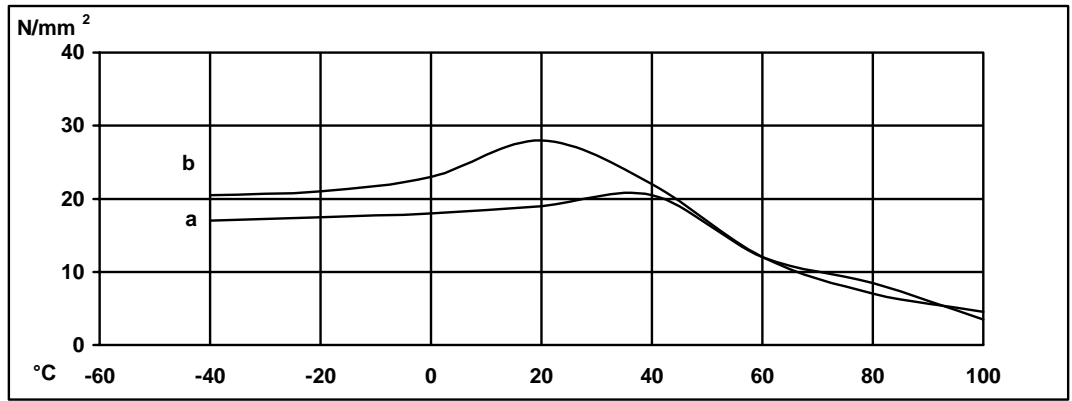
Cured for 16 hours at 23°C and tested at 23°C

Pretreatment - Lightly abrade and alcohol degrease.



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 5 N/mm

Glass transition temperature Cure: 16 hours at 40°C ca. 45°C

Electrolytic corrosion (DIN 53489) (cure 16hrs at 40°C or 20 mins at 100°C)

Test: 4 days in a conditioning chamber in 40/92 climate as specified by DIN 50015

Rating according to specified standard A -A/B 1,2

Minimum dielectric strength at 50 Hz, 24°C (VSM 77170)

Mix ratio	Instantaneous value	1-minute value
100:80 pbw	25-27 kV/mm	22-24 kV/mm

Water vapour permeability (NF 41001) (38°C, 90% rh) Cure: 5 days/23°C

Test on a 1mm thick film 16g/m²/24 hours

Water absorption (ISO 62-80)

24 hours at 23°C	0.8%
30 mins at 100°C	1.3%

Thermal conductivity (ISO 8894/90) Cure: 20 minutes/100°C

Test: At 23°C 0.22W/mK

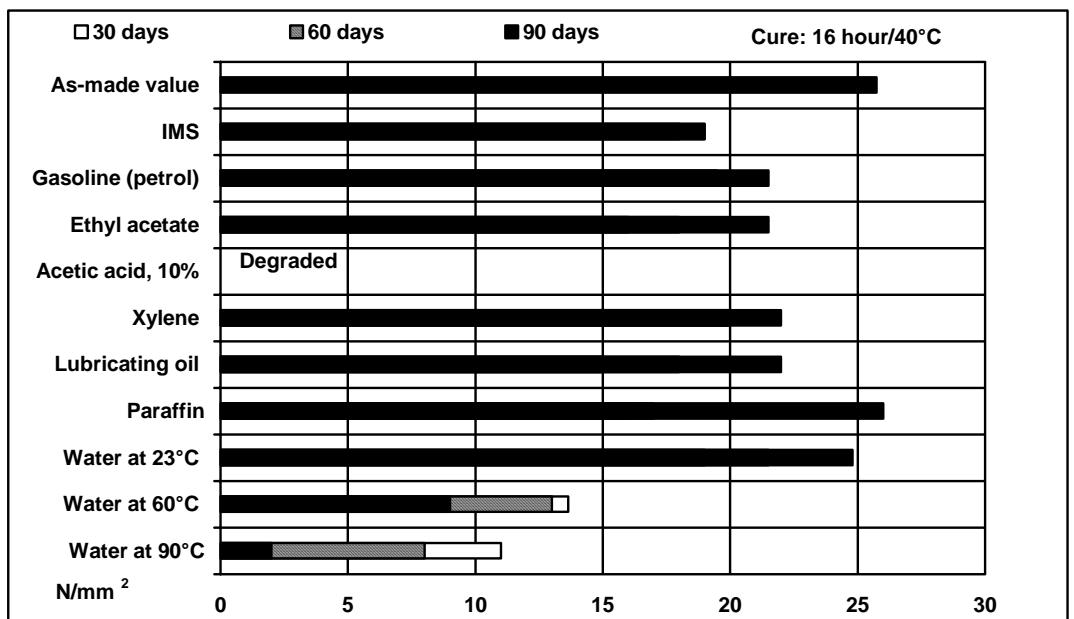
Shear modulus (DIN 53445) Cure: 16 hours/40°C

-50°C	-	1.5GPa
0°C	-	1.2GPa
50°C	-	0.2GPa
100°C	-	7MPa

Flexural Properties (ISO 178) Cure 16 hours/ 40°C tested at 23°C

Flexural Strength 60.4MPa

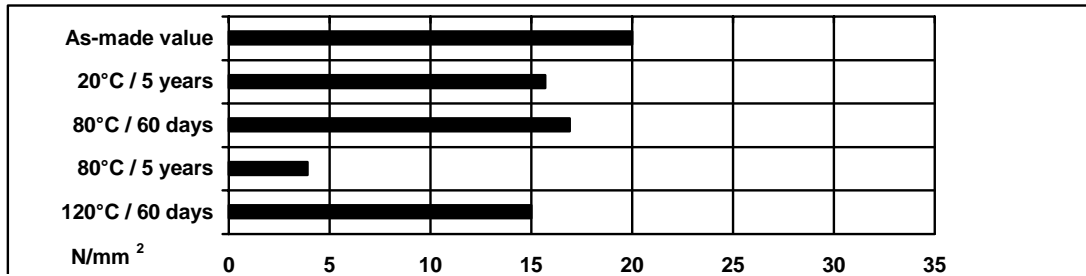
Flexural Modulus 1904.1 MPa



Lap shear strength versus heat ageing

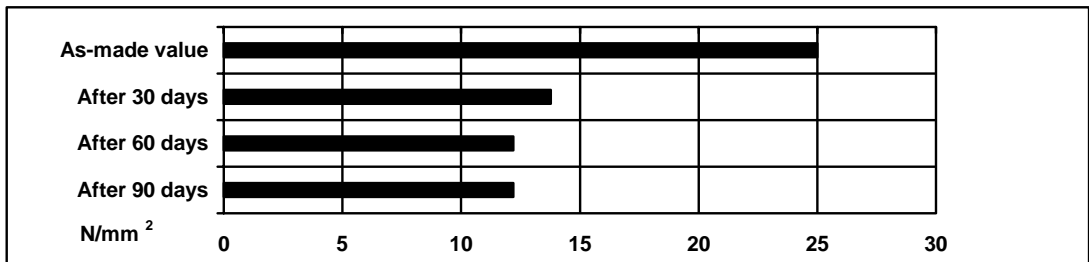
Cure: 16 hours/40°C

Test: at 23°C, 50% rh



Lap shear strength versus tropical weathering (40/92, DIN 50015; typical average values)

Cure:16 hours/40°C: Test at 23°C.



Fatigue test on simple lap joints (DIN 53285)

Cure: 20 minutes/100°C Mean static lap shear strength: 16.3N/mm²

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

Fluctuating load as % of static shear strength

No. of load cycles to joint failure

30
20
15

10⁵ - 10⁶
10⁶ - 10⁷
> 10⁷

Storage

Araldite 2011/A and Araldite 2011/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.

Duxford, Cambridge
England CB2 4QA

Tel:+44(0)1223 832121
Fax:+44(0) 1223 493322
www.araldite.com

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