

## Araldite® 2015 Adhesive

### Product Description

Araldite® 2015 structural adhesive is a two component, room temperature curing paste adhesive giving a resilient bond. It is thixotropic and non-sagging up to 0.394 (10 mm) thickness. It is particularly suitable for SMC and GRP bonding.

### Features

- Toughened paste
- Ideal for bonding GRP, SMC and dissimilar substrates
- Low shrinkage
- Gap filling, non-sagging up to 0.394 in (10 mm) thickness
- High shear and peel strength

### Typical Properties\*

Property	Araldite® 2015 A	Araldite® 2015 B	Mixed System
Appearance	Neutral paste	Neutral paste	Neutral paste
Density, g/cm <sup>3</sup>	~1.4	~1.4	~1.4
Viscosity at 25°C, cP	Thixotropic	Thixotropic	Thixotropic
Pot life at 25°C, 100 g, min	--	--	~30 - 40

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

### Processing

#### Mix Ratio

Product	Parts by weight	Parts by volume
Araldite® 2015 A	100	100
Araldite® 2015 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® 2015 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](http://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	12	7.5	4	1	-	-
minutes	-	-	-	-	17	6
Cure time to reach LSS > 1450 psi (10 MPa), hours	21	13	6	2	-	-
minutes	-	-	-	-	35	7

\*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, metal-metal joints, sand blasting pre-treatment, psi				ISO 4587
Aluminum	2,408			
Steel 37/11	2,886			
Stainless steel V4A	2,640			
Galvanized steel	1,566			
Copper	2,872			
Brass	3,075			
Average lap shear strength, plastic-plastic joints, lightly abrade and alcohol degrease pre, psi				ISO 4587
GRP	1,334			
CFRP	2,074			
SMC	1,015			
ABS	580			
PVC	580			
PMMA	334			
Polycarbonate	435			
Polyamides	276			
Lap shear strength, after immersion in 23°C media, psi	30 days	60 days	90 days	ISO 4587
As-made value	--	--	2,408	
IMS	--	--	2,002	
Gasoline	--	--	2,509	
Ethyl acetate	--	--	1,784	
Acetic acid, 10%	--	827	--	
Xylene	--	--	2,045	
Lubricating oil	--	--	3,002	
Paraffin	--	--	2,683	
Water at 73°F	--	--	1,450	
Water at 140°F	--	--	1,900	
Water at 194°F	1624	--	1,523	
Lap shear strength, exposure to tropical weather,* psi				ISO 4587 / DIN 50015
As-made value	2,408			
30 days	1,871			
60 days	1,871			
90 days	2,263			

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## Technical Datasheet

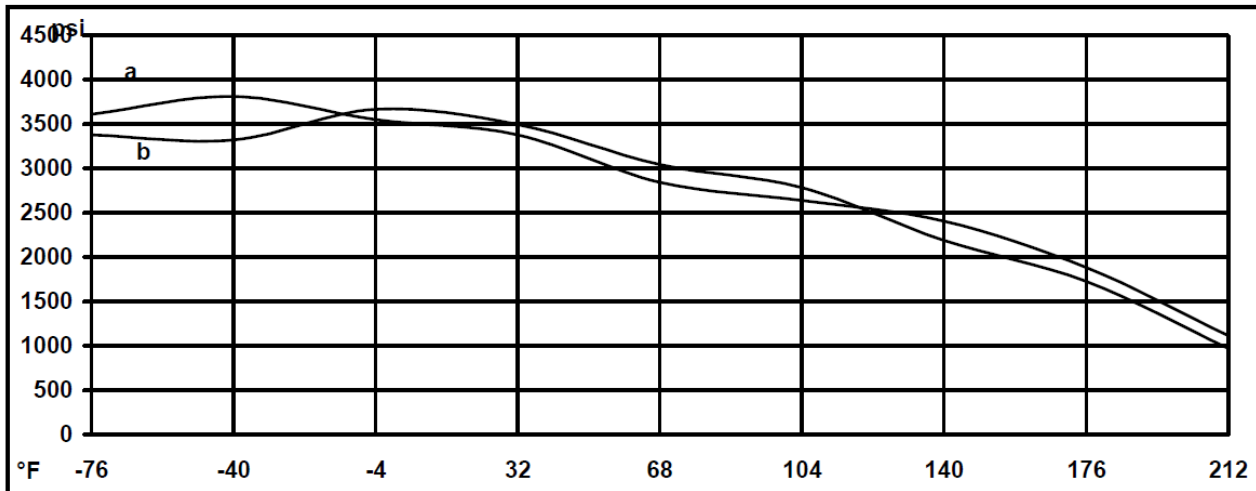
Lap shear strength, heat aging at 158°F, psi		ISO 4587
As-made value	2,408	
30 days	2,814	
60 days	3,321	
90 days	3,292	
Thermal cycling <sup>†</sup>	3,002	
Roller peel test, pli (N/mm)	23 (4.0)	ISO 4578
Glass transition temperature, T <sub>g</sub> , °F (°C)		
Cure: 16 h at 104°F (40°C)	153 (67) by DSC	Huntsman
1 h at 176°F (80°C)	189 (87) by shear modulus	DIN 53445
Dielectric constant (500v at 25°C), at 1 kHz	5.6	
Flexural strength, psi (MPa)	6,193 (42.7)	ISO 178
Flexural modulus, psi (MPa)	263,040 (1813.6)	ISO 178
Tensile strength, psi (MPa)	4351 (30)	ISO 527
Tensile modulus, psi (MPa)	290,075 (2)	ISO 527
Elongation at tensile break, %	4.4	ISO 527
Shear modulus, cure 1 h at 176°F, psi (GPa)		DIN 53445
32°F		
G'	145,038 (1.0)	
Λ	0.25	
77°F		
G'	130,534 (0.9)	
Λ	0.25	
122°F		
G'	116,030 (0.8)	
Λ	0.35	
167°F		
G'	29,008 (0.2)	
Λ	1.9	
212°F		
G'	290 (0.002)	
Λ	0.5	
Resistance to fatigue, 40 Hz at 23°C	Cycles to failure	Static failing load: 2321 psi (16 MPa)
Maximum applied load:		
20% of static failing load		
Sandblasted aluminum	>10 <sup>7</sup>	
Chromate pickled aluminum	>10 <sup>7</sup>	
25% of static failing load		
Sandblasted aluminum	>10 <sup>7</sup>	
Chromate pickled aluminum	>10 <sup>7</sup>	
30% of static failing load		
Sandblasted aluminum	3 x 10 <sup>6</sup>	
Chromate pickled aluminum	8 x 10 <sup>5</sup>	

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

<sup>†</sup>25 cycles -22°F to 158°F (-30°C to + 70°C).

**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® 2015 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**

**FOR PROFESSIONAL AND INDUSTRIAL USE ONLY**

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#### Main Offices:

**Huntsman Corporation**  
10003 Woodloch Forest Dr  
The Woodlands, TX 77380  
888-564-9318

**Huntsman Advanced Technology Center**  
8600 Gosling Rd.  
The Woodlands, TX 77381  
281-719-7400