

## Structural Adhesives

### Araldite® 2018 (XD 4445/XD 4446) Two component PU adhesive system

#### Key properties

- Bonds well to most thermoplastics
- Flexible
- Room temperature curing

#### Description

Araldite 2018 is a two component, room temperature curing, pale coloured, lightly thixotropic liquid polyurethane adhesive for thermoplastic bonding.

#### Product data

	2018/A	2018/B	2018 (mixed)
Colour (visual)	Pale opaque	Pale opaque	Pale opaque
Specific gravity	ca 1.16	ca 1.10	ca 1.13
Viscosity (Pas)	12 - 18	3 - 6	ca 8
Pot Life (100 gm at 25°C)	-	-	40 minutes
Shelf life (2 - 40°C)	2 years	2 years	-
Flash point (°C)	>100	>100	-

#### Processing

##### Pretreatment

The strength and durability of a bonded joint are dependant on proper pretreatment 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 2018/A	100	100
Araldite 2018/B	95	100

Resin and hardener are 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 directly or 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	16.5	12	4	-	-	-
LSS > 1N/mm <sup>2</sup>	minutes	-	-	-	45	25	4
Cure time to reach	hours	48	20	16	3	-	-
LSS > 10N/mm <sup>2</sup>	minutes	-	-	-	-	30	12

LSS = Lap shear strength.

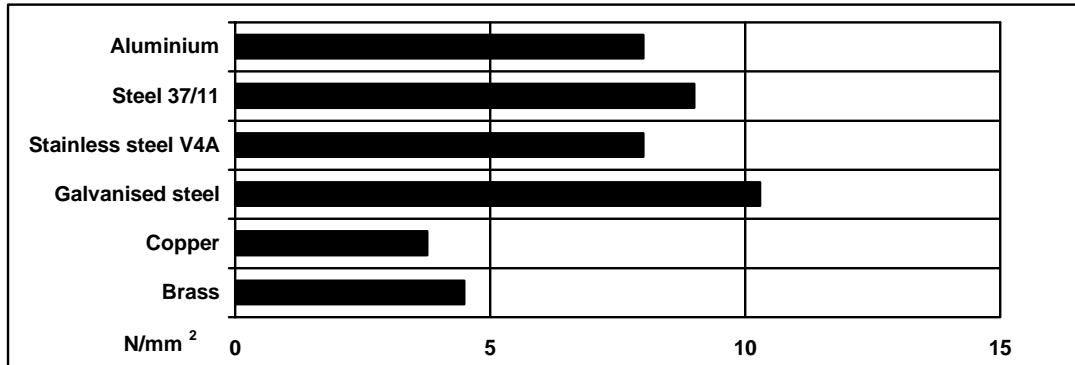
**Typical cured properties**

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

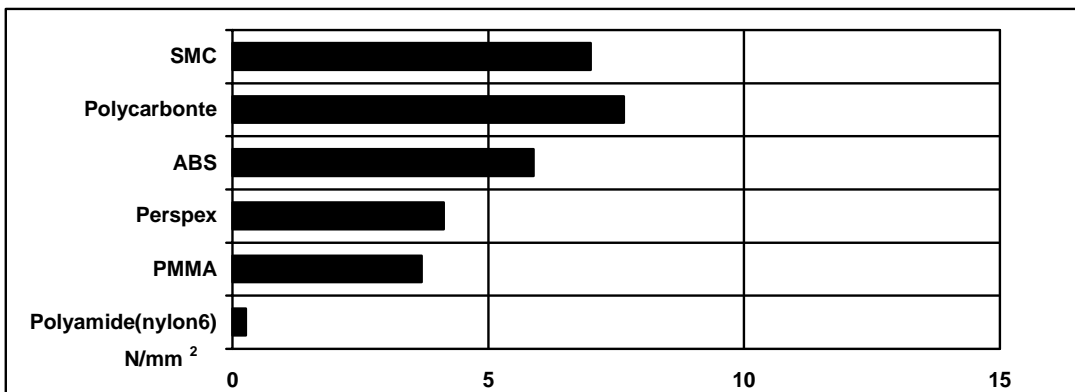
Pretreatment - Sand blasting



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

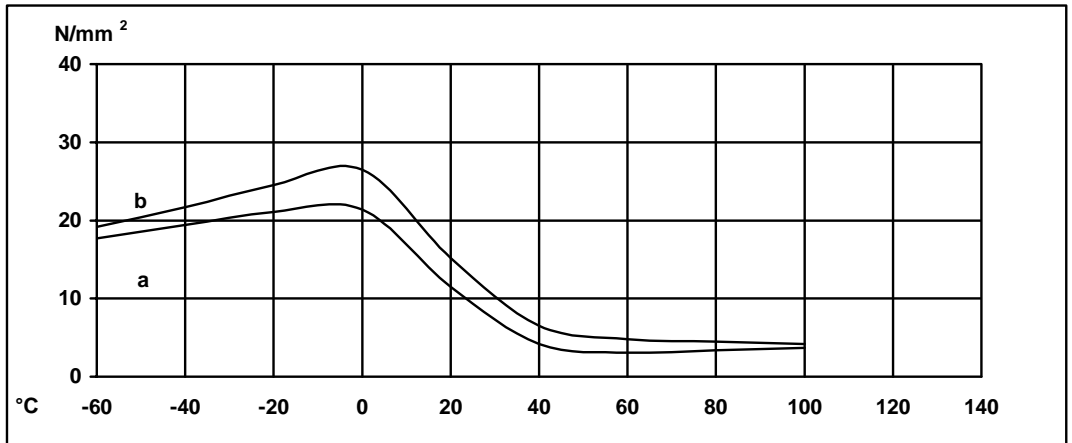
Cured for 16 hours at 40°C and tested at 23°C

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 4.0 N/mm

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

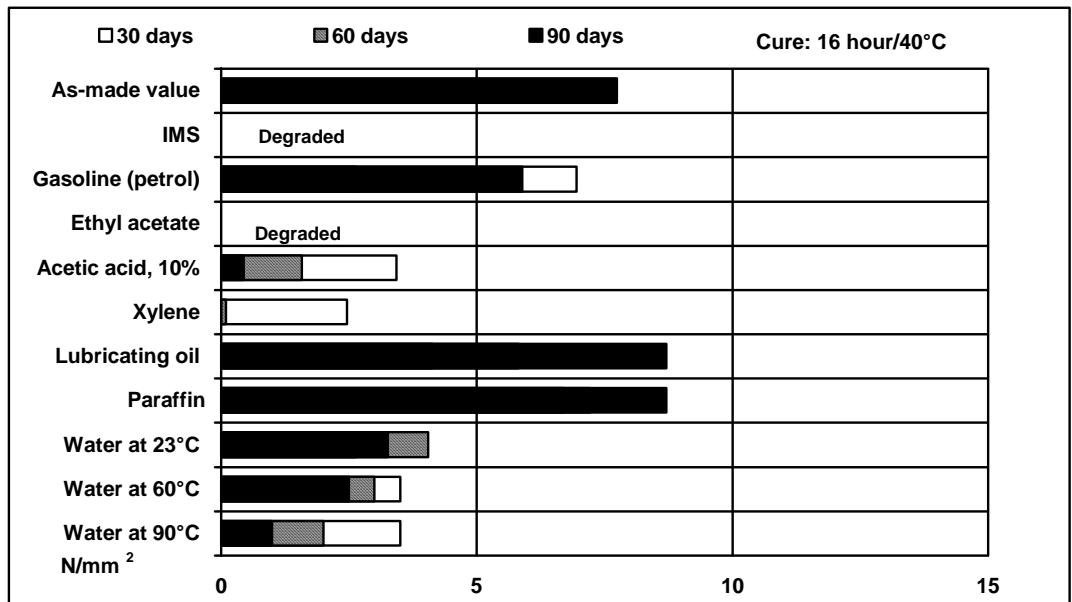
Flexural Strength 1.48 MPa

Flexural Modulus 23.5 MPa

Elongation at break 35 %

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

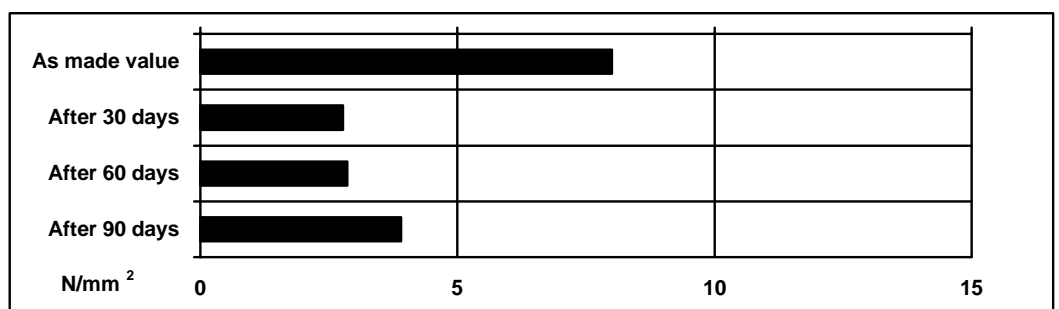
Unless otherwise stated, L.S.S. was determined after immersion for 90 days at 23°C



**Lap shear strength versus tropical weathering**

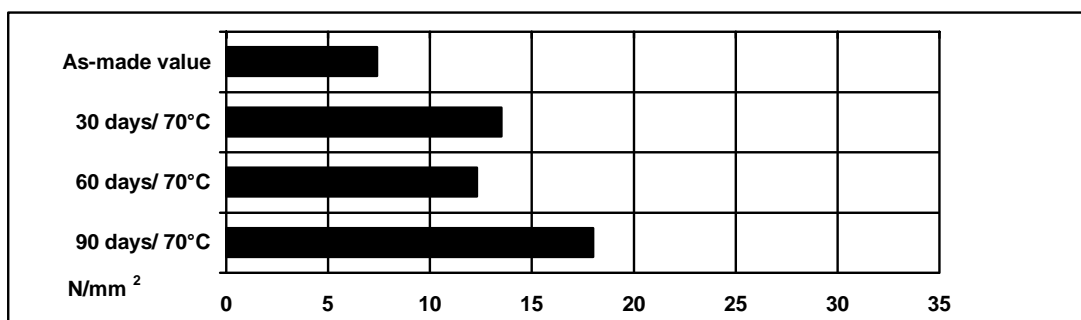
(40/92, DIN 50015; typical average values)

Cure: 16 hours/40°C; Test: at 23°C



### Lap shear strength versus heat ageing

Cure: 16 hours/40°C



### Thermal cycling

100 cycles of 6 hour duration from -30°C to 70°C: 8.8 N/mm<sup>2</sup>

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### Storage

Araldite 2018/A and Araldite 2018/B may be stored for up to 2 years at room temperature provided the components are stored in sealed containers. The expiry date is indicated on the label. Cartridges should not be stored for long periods after removal from the foil overpack.

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### 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.

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### 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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