

Advanced Materials

Araldite[®] 2028-1

Structural Adhesives

Araldite[®] 2028-1 Two component transparent polyurethane adhesive

Key properties	transparent
	fast curing
	UV stable
	Suitable for bonding a variety of metal and plastic substrates
Description	Araldite 2028-1 is a cold curing polyurethan adhesive, consisting of a transparent resin component and a transparent hardener component. The adhesive's flashpoint is above 100 °C.

Product data

Property	Component A (resin)	Component B (hardener)	Mixed Adhesive
Colour (visual)	Water white	Water white	Water white
Specific gravity	1.12	1.12	1.12
Viscosity at 25°C (Pas)	10.4	1.2	-
Pot Life (100 gm at 25°C)			6 mins

Processing

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, 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
Component A (resin)	100	100
Component B (hardener)	100	100

Araldite 2028-1 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.

Wellmid Electronics (Shenzhen) Co., Ltd. February 2009

Enriching lives through innovation

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 an suitable application method as well as suggest a variety of reputable companies that manufacture and service adhesive dispensing equipment.

A layer of adhesive 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.

Times to minimum shear strength

Temperature	°C	10	15	23	40	60	100
Cure time to reach	hours	-	-	-	-	-	-
LSS > 1MPa	minutes	90	30	15	5	< 2	< 2
Cure time to reach	hours	24	16	5	1	-	-
LSS > 10MPa	minutes	-	-	-	-	30	15

LSS = Lap shear strength.

Typical cured properties

Unless otherwise stated, the figures given below were all determined by testing standard specimens made by lap-

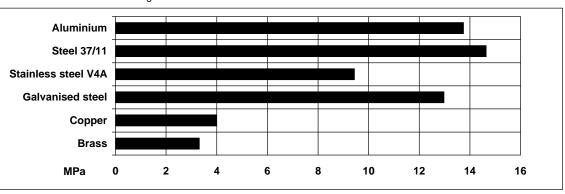
jointing 114 x 25 x 1.6 mm strips of aluminium alloy. The joint area was 12.5 x 25 mm in each case. The figures were determined with typical production batches using standard testing methods. They are provided solely

as technical information and do not constitute a product specification.

Note: The data in this edition is based on recent retesting of the product.

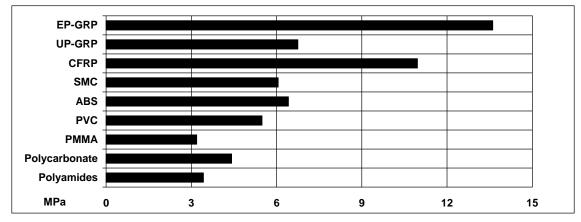
Average lap shear strengths of typical metal-to-metal joints (ISO 4587)

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

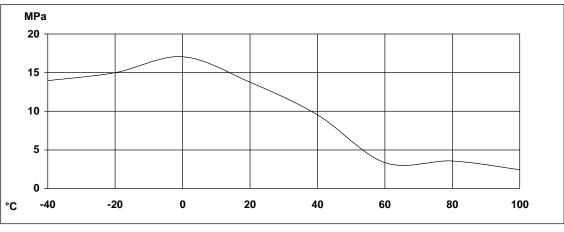


Average lap shear strengths of typical plastic-to-plastic joints (ISO 4587)

Cured for 16 hour 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: 16 hours at 40°C



Roller peel test (ISO 4578)

Cured: 16 hours at 40°C

Glass transition temperature

Cure: 16 hours at 40°C

Lap shear strength on other substrates

Cure: 16 hours at 40°C

Wood : 7.17 MPa Glass :4.51 MPa

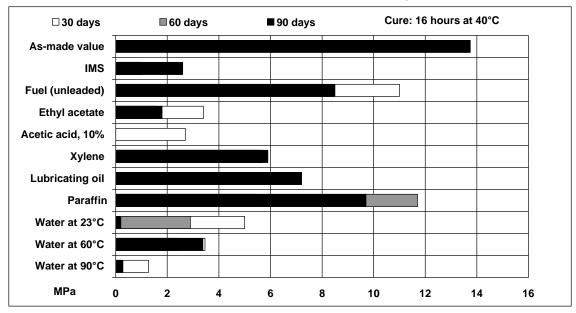
Wellmid Electronics (Shenzhen) Co., Ltd. February 2009 1.2 N/mm

7°C by DSC



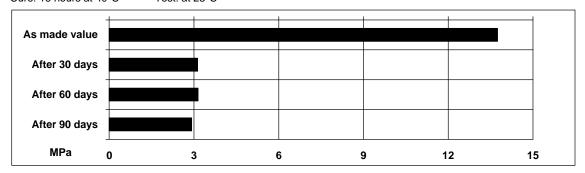
Lap shear strength versus immersion in various media (typical average values)

Unless otherwise stated, L.S.S. was determined after immersion for 30,60 and 90 days at 23°C



Lap shear strength versus tropical weathering

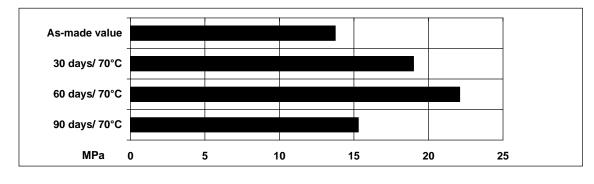
(40/92, DIN 50017; typical average values) Cure: 16 hours at 40°C Test: at 23°C



HUNTSMAN

Lap shear strength versus heat ageing

Cure: 16 hours at 40°C



Thermal cycling

	5 MD
100 cycles of 6 hours duration from -30°C to 70°C:	7.75 MPa

Tensile strength at 23°C (ISO 527)	5 MPa
Tensile modulus	10 MPa
Elongation at break	34 %



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 Core processing generally appreciately sensitive skin uses not necessing products, 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 foodstuffs or food utensils, and measures should be taken to prevent the uncured. The wearing of impervious rubber or plastic gloves will normally be necessary, likewise the use of eye protection. The skin should be thoroughly cleans at the end of each working period by washing with scap 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 individ, products and should be referred to for fuller information. 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 laterials 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 laterials All recommendations the Buyer shall main responsibility therefor. The Buyer shall ensure that the intended use of the products winch infininge any third party is infelectual property rights. We warrant that our products are free from defects in accordance with and subject to our general conditions of supply. Hunterian Advanced Materials are to accordance with and subject to our general conditions of supply. Hunterian Advanced Materials are to exceeded are interesting of whether the supercluation out are uncertained processing of the supplication. The tween shall ensure that the intended processing the supplication of	Handling	Caution	
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