

Adhesives and Tooling

Structural Adhesives

Araldite® AW2104/HW2934

Two component epoxy paste adhesive

Key properties

- High shear and peel strength
- Tough and resilient
- Rapid curing
- Bonds a wide variety of materials

Description

Araldite AW2104/HW2934 is a rapid cure, multipurpose, two component, room temperature curing, high viscosity liquid adhesive of high strength and toughness.

It is suitable for bonding wide variety of metals, ceramics, glass, rubbers, 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

	AW2104	HW2934	mixed
Colour (visual)	opaque	pale yellow	pale yellow
Specific gravity	1.16-1.18	1.15-1.18	ca 1.18
Viscosity (Pas)	25-45	20-40	typically 25-35
Pot Life (100 gm at 25°C)	-	-	4 minutes
Shelf life (2 - 40°C)	3 years	3 years	-

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, trichloroethylene or proprietary degreasing agent in order to remove all traces of oil, grease and dirt. 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 AW2104	100	100
Araldite HW2934	100	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 Vantico.

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.

Vantico 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 LSS > 1N/mm ²	hours	-	-	-	-	-	-
	minutes	35	20	20	5	2	<1
Cure time to reach LSS > 10N/mm ²	hours	-	-	-	-	-	-
	minutes	120	70	61	25	10	2

LSS = Lap shear strength.

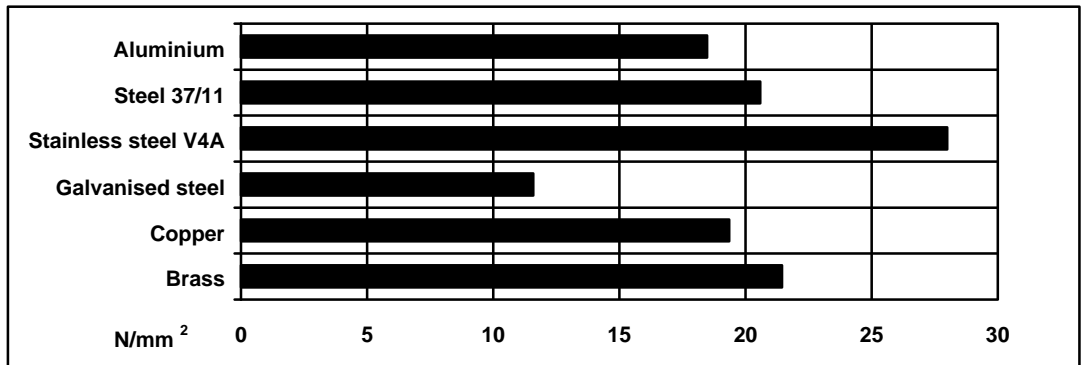
Typical cured properties

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)

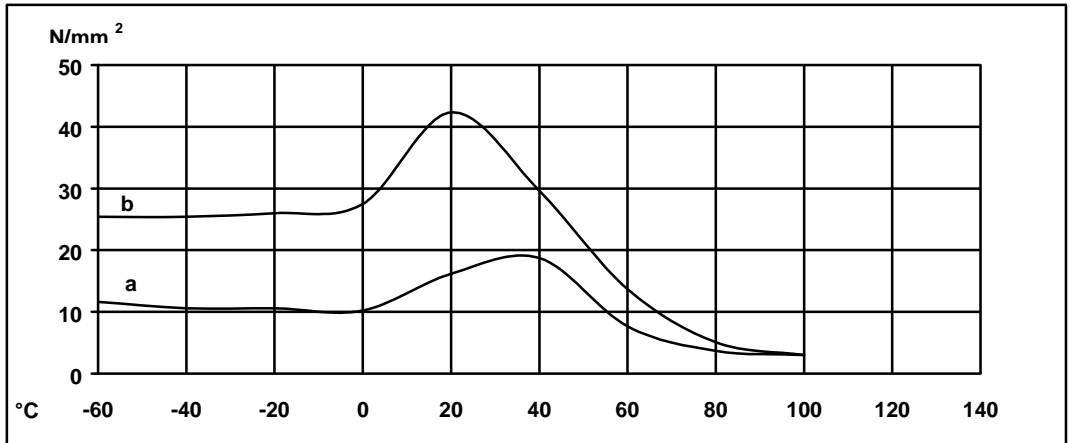
Cured for 16 hours at 40°C and tested at 23°C

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

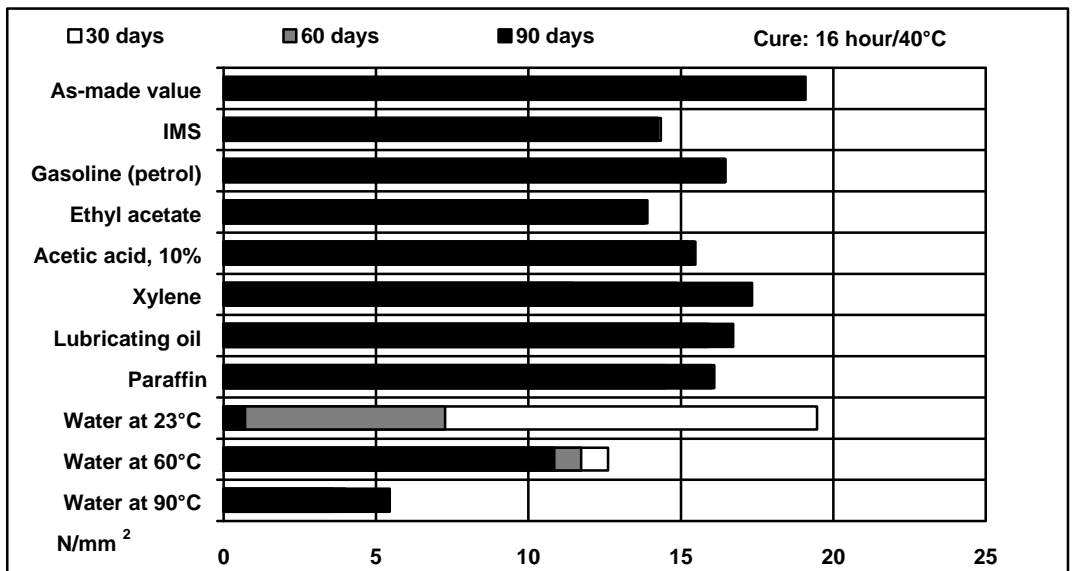


Roller peel test (ISO 4578)

Cure: 48 hours /20°C 16 hours /40°C 2 hours /80°C
 3.5 N/mm 5.5 N/mm 5.5 N/mm

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

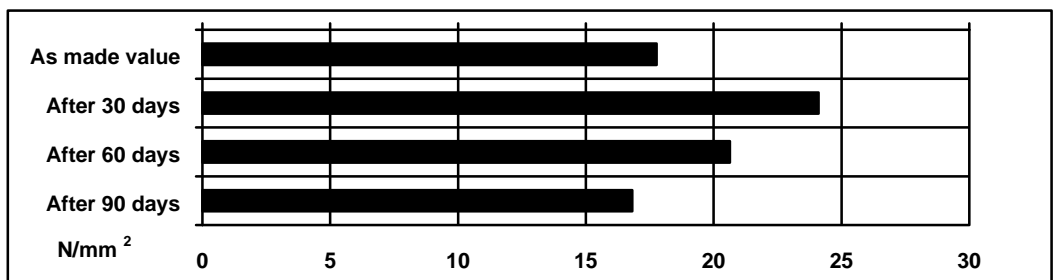
Unless otherwise stated, L.S.S. was determined after immersion for 90 days at 23°C



Lap shear strength versus tropical weathering

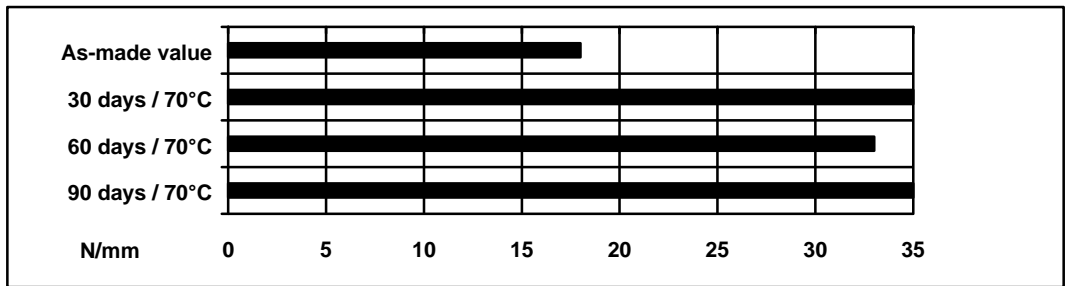
(40/92, DIN 50015; typical average values)

Cure: 16 hours/40°C; Test: at 23°C



Lap shear strength versus heat ageing

Cure: 16 hours/40°C



Storage

Araldite AW2104 and Araldite HW2934 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

Vantico' 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 Vantico publication No. 24264/3/e Hygienic precautions for handling plastics products of Vantico and in the Vantico Material Safety Data sheets for the individual products. These publications are available on request and should be referred to for fuller information.

Huntsman limited
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