

**Advanced Materials****ARALDITE® 2015-2 (ARALDITE® AV 5308-1 / Hardener HV 5309-2)****Structural Adhesives****PROVISIONAL TECHNICAL DATA SHEET****Two-component epoxy paste adhesive****Key properties**

- Toughened paste adhesive
- Ideal for bonding GRP, SMC and dissimilar substrates
- Gap filling, non-sagging up to 10mm thickness
- Good resistance to environmental conditions
- Temperature resistance to 100°C

**Description**

ARALDITE® 2015-2 (bulk-pack reference: ARALDITE® AV 5308-1 / Hardener HV 5309-2) is a high toughness, two-component, room temperature curing epoxy paste adhesive providing durable, resilient bonds. It is thixotropic and non-sagging up to 10mm thickness, and is particularly suited for bonding SMC and GRP, as well as bonding dissimilar materials.

**Product data**

Property	RESIN ARALDITE® 2015-2 A (AV 5308-1)	HARDENER ARALDITE® 2015-2 B (HV 5309-2)	MIXED ADHESIVE
Appearance (visual)	<i>Smooth beige paste</i>	<i>Beige soft paste</i>	Beige paste
Specific gravity	ca. 1.4	ca. 1.4	ca. 1.4
Viscosity at 25°C	Thixotropic	Thixotropic	Thixotropic
Working time (10g) 23°C	-	-	30 - 35 minutes

*Data in this document shows 'typical' values and is given for information purposes only. Data values are not guaranteed or warranted unless if specifically mentioned.*

**Processing****Pretreatment**

The strength and durability of a bonded joint are dependent 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 methoxy propanol, acetone or other proprietary degreasing agents 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 prior to bonding.

Mix ratio	Parts by weight	Parts by volume
ARALDITE® 2015-2 A (AV 5308-1)	100	100
ARALDITE® 2015-2 B (HV 5309-2)	100	100

**Application of adhesive**

The resin/hardener mix may be applied manually or using automated application to pretreated surfaces ready for bonding. Huntsman's technical support group can advise further on surface pre-treatments as well as suitable application methods and dispensing equipment.

An adhesive bond thickness of 0.1 to 0.30 mm will typically impart the greatest lap shear strength to a joint. Proper adhesive joint design and surface preparation is critical to produce a durable bond. The bonded components should be assembled and held in a fixed position as soon as the adhesive has been applied, at least until the handling strength is reached (handling strength considered as 1MPa lap shear strength – see table below).

For more information regarding surface preparation and pretreatment, adhesive joint design, dispensing systems and adhesive properties, visit [www.aralditeadhesives.com](http://www.aralditeadhesives.com) and download the Technical Guide for ARALDITE® Adhesives.

**Equipment maintenance**

Tools should be cleaned using a suitable solvent, such as methoxy propanol or acetone, before adhesive residues have had time to cure. Removal of cured residues with solvents is not possible, and mechanical abrasion must be used.

If solvents are used for cleaning, operatives should take the appropriate precautions and, in addition, avoid skin and eye contact.

**Typical times to minimum shear strength**

Temperature	°C	10	15	23	40	60	100
Cure time to reach	hours	9	6	4	-	-	-
LSS > 1MPa	minutes	-	-	-	65	20	5
Cure time to reach	hours	28	12	7	-	-	-
LSS > 10MPa	minutes	-	-	-	120	50	10

LSS = Lap shear strength.

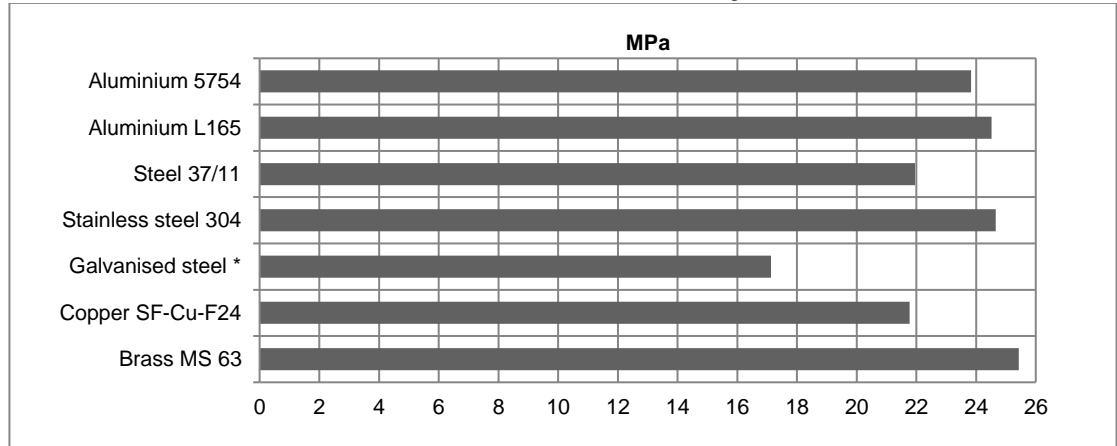
**Typical cured properties**

The data shown below is provided solely as technical information and does not constitute a product specification.

Unless otherwise stated, the figures given below were determined by testing standard specimens made by lap-jointing 100 x 25 x 1.6 mm strips of sandblasted aluminium alloy. The bond area was 12.5 x 25 mm, with bonded specimens cured under light clamping pressure. Lap shear testing was carried out at 23°C at 10mm/min unless otherwise stated.

### Average lap shear strengths of typical metal-to-metal joints (ISO 4587; typical average values)

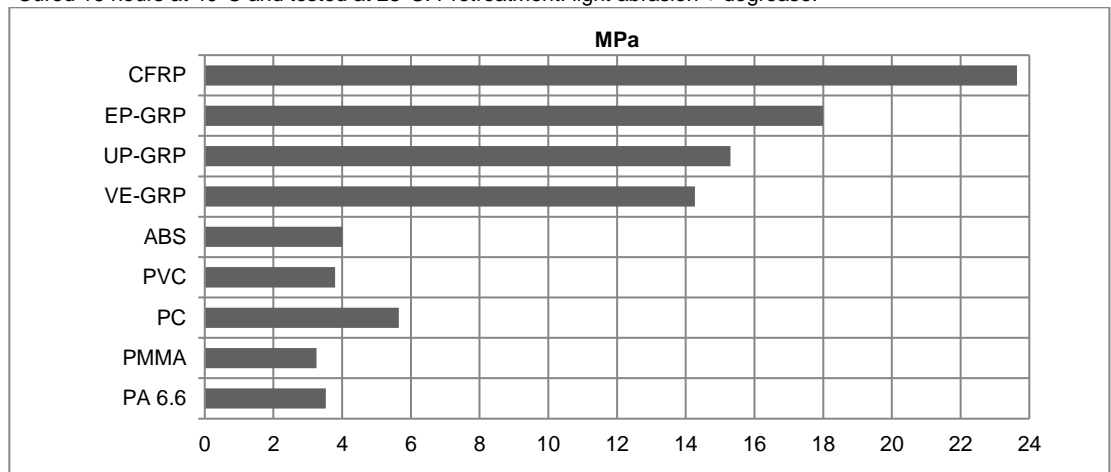
Cured 16 hours at 40 °C and tested at 23°C. Pretreatment: sandblast + degrease



\* galvanised steel: degrease only

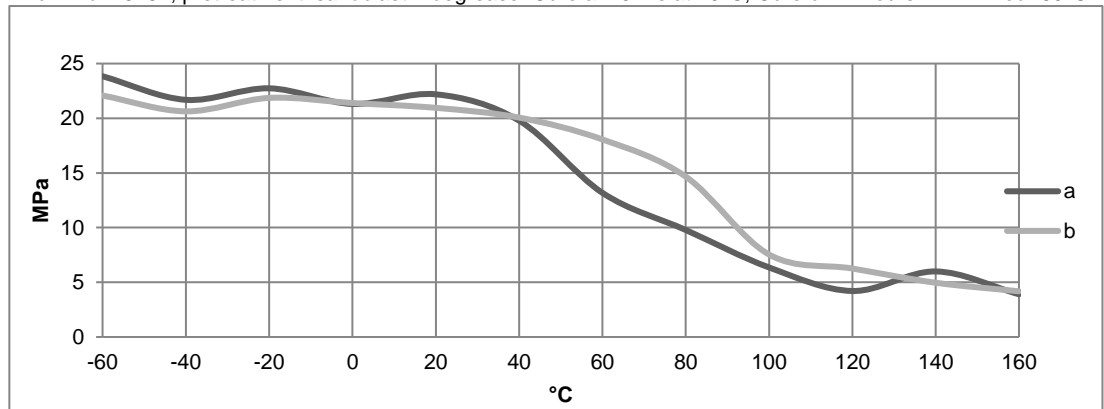
### Average lap shear strengths of typical plastic-to-plastic joints (ISO 4587; typical average values)

Cured 16 hours at 40°C and tested at 23°C. Pretreatment: light abrasion + degrease.



### Lap shear strength versus temperature (ISO 4587; typical average values)

Aluminium 5754, pretreatment: sandblast + degrease. Cure a: 16 hrs at 40°C, Cure b: 24 hours RT + 1 hour 80°C



**DMA (Dynamic Mechanical Analysis ISO 6721; typical average values)**

**Cure a: 16 hours 40°C**

Tg midpoint	75°C
Shear modulus -40°C	1385 MPa
Shear Modulus 23°C	861 MPa
Shear Modulus 50°C	577 MPa
Shear Modulus 75°C	29 MPa
Shear Modulus 100°C	10 MPa
Shear Modulus 125°C	10 MPa

**Cure b: 24 hours RT + 1 hour 80°C**

Tg midpoint	82°C
Shear modulus -40°C	1385 MPa
Shear Modulus 23°C	836 MPa
Shear Modulus 50°C	567 MPa
Shear Modulus 75°C	91 MPa
Shear Modulus 100°C	11 MPa
Shear Modulus 125°C	10 MPa

**Tensile Properties (ISO 527; typical average values) Cure 16 hours at 40°C, tested at 23°C**

Tensile modulus	1720 MPa
Tensile strength	29 MPa
Elongation at break	8.5 %

**Compressive Properties (ISO 604; typical average values) Cure 16 hours at 40°C, tested at 23°C**

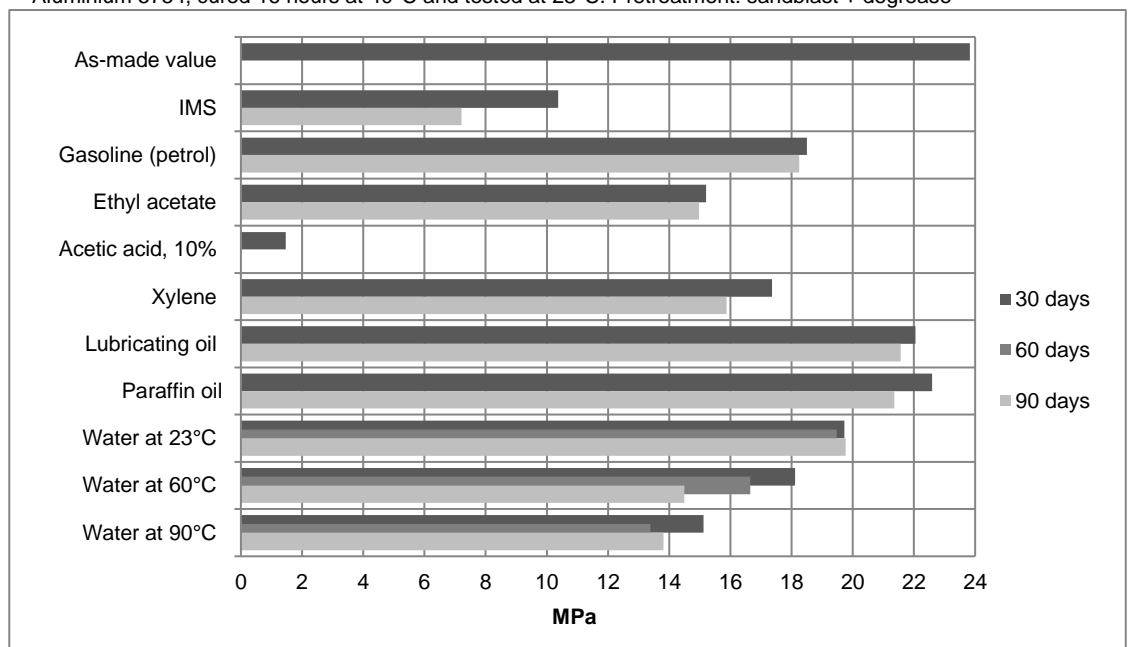
Compressive modulus	1920 MPa
Maximum compressive strength	105 MPa
Strength at break	100 MPa

**Hardness (ISO 868; typical average values) Cure 16 hours at 40°C, tested at 23°C**

Shore D hardness	76
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**Lap shear strength versus immersion in various media (ISO 4587; typical average values)**

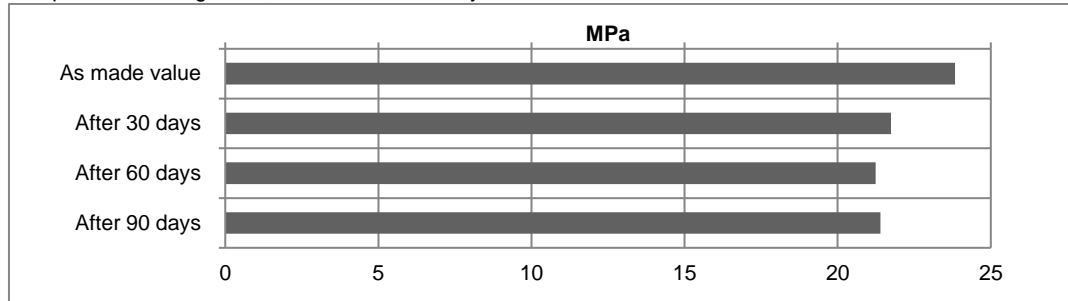
Aluminium 5754, cured 16 hours at 40°C and tested at 23°C. Pretreatment: sandblast + degrease



### Lap shear strength versus tropical weathering (DIN 50015; typical average values)

Aluminium 5754, cured 16 hours at 40°C and tested at 23°C. Pretreatment: sandblast + degrease

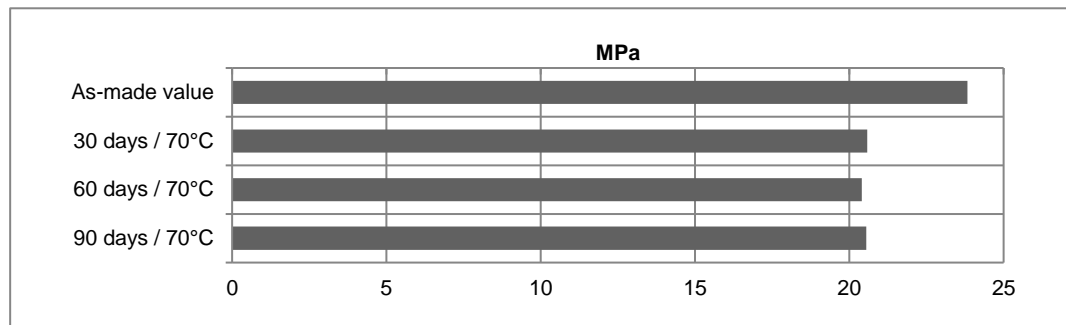
Tropical weathering: 40°C, 92% relative humidity



### Lap shear strength versus heat ageing at 70°C (ISO 4587; typical average values)

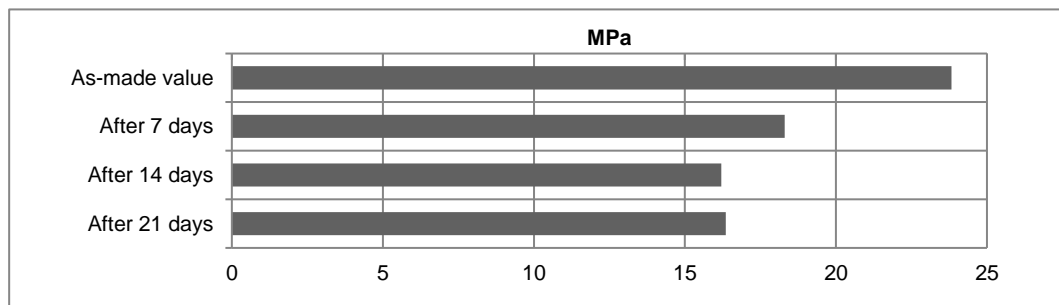
Aluminium 5754, cured 16 hours at 40°C and tested at 23°C. Pretreatment: sandblast + degrease

Heat aging at 70°C



### Lap shear strength versus cataplasma ageing (ISO 9142 E2; typical average values)

Aluminium 5754, cured 16 hours at 40°C and tested at 23°C. Pretreatment: sandblast + degrease



**Storage**

ARALDITE® 2015-2 (AV 5308-1 / HV 5309-2) should be stored at room temperature in the original sealed containers, kept in a dry place protected from extremes of temperature and strong sunlight. The expiry date is indicated on the individual container labels.

**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 warrants only that its products meet the specifications agreed with the user. Specified data are analysed on a regular basis. Data which is described in this document as 'typical' or 'guideline' is not analysed on a regular basis and is given for information purposes only. Data values are not guaranteed or warranted unless if specifically mentioned.

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