

Advanced Materials**Araldite® AW 139-1 / Hardener HW 5323**

Structural Adhesives

TECHNICAL DATA SHEET**Araldite® AW 139-1 / Hardener HW 5323****Two component epoxy paste adhesive****Key properties**

- Grey paste
- High temperature and chemical resistance
- Low shrinkage
- Very resistant to water and a variety of chemicals
- Gap filling, non sagging up to 5mm thickness

Description

Araldite® AW 139-1 / Hardener HW 5323 is a two component, room temperature curing, thixotropic paste adhesive of high strength with good environmental and excellent chemical resistance.

Used for bonding of metals, electronic components, GRP structures and many other items where a higher than normal temperature or more aggressive environment is to be encountered in service. The low out gassing makes this product suitable for specialist electronic telecommunication and aerospace applications.

Product data

Property	Araldite® AW 139-1	Hardener HW 5323	Mix
Colour (visual)	beige paste	grey paste	grey paste
Specific gravity	ca. 1.6	ca. 1.6	ca. 1.6
Viscosity at 25°C (Pas)	ca. 100	thixotropic	thixotropic
Pot Life (100 gm at 25°C)	-	-	60 minutes
Shelf life (2-40°C)	3 years	3 years	-

Processing**Pretreatment**

The strength and durability of a bonded joint are dependant 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, alcohol or other proprietary degreasing agents in order to remove all traces of oil, grease and dirt.

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® AW 139-1	100	100
Hardener HW 5323	50	50

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 0.05 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	14	8	3	-	-	-
LSS > 1MPa	minutes	-	-	-	60	15	3
Cure time to reach	hours	20	11	5	-	-	-
LSS > 10MPa	minutes	-	-	-	80	20	4

LSS = Lap shear strength.

Typical cured properties

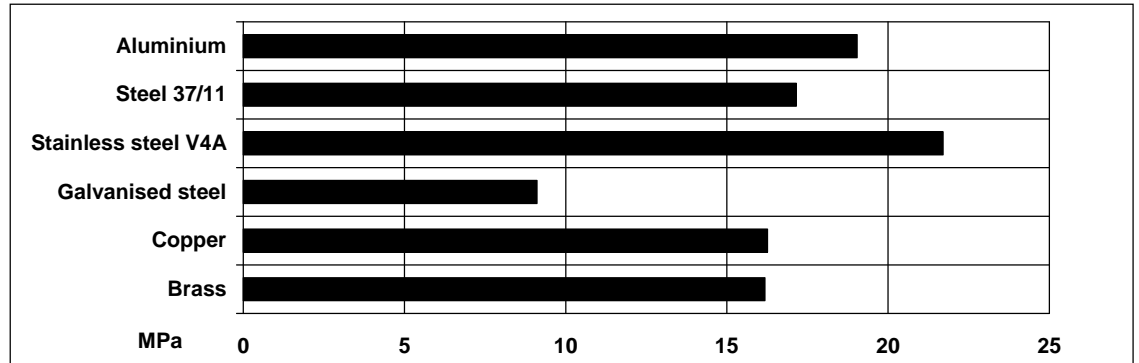
Unless otherwise stated, the figures given below were all determined by testing standard specimens made by lap-jointing 114 x 25 x 1.6 mm strips of aluminium alloy. The joint area was 12.5 x 25 mm in each case.

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.

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

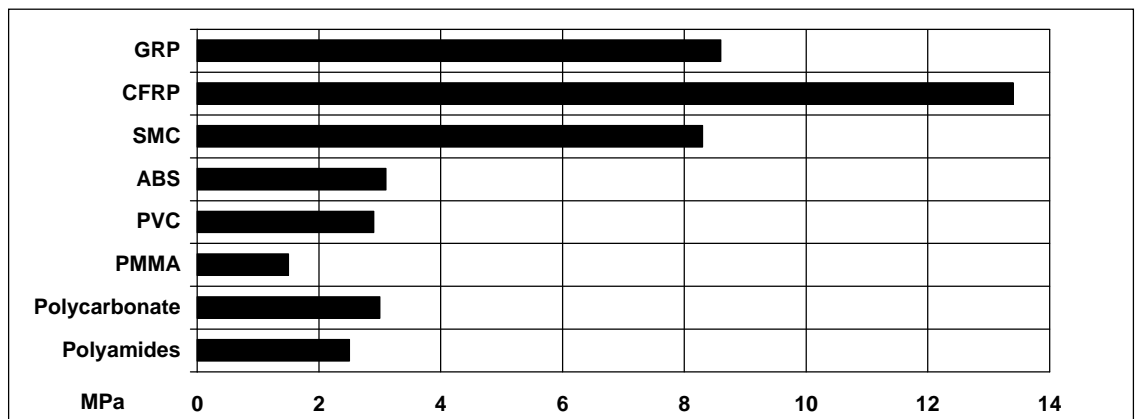
Cured for 16 hours at 40°C and tested at 23°C

Pretreatment - Sand blasting



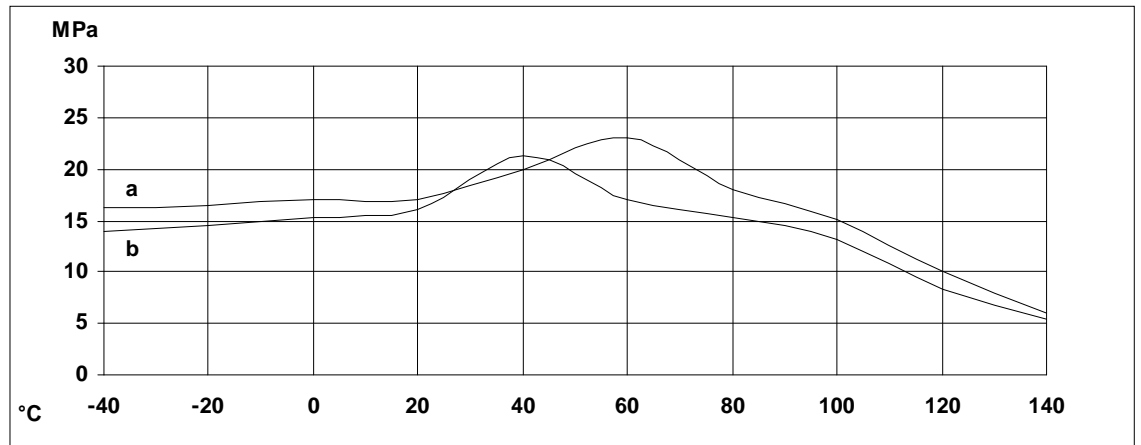
Average lap shear strengths of typical plastic-to-plastic joints (ISO 4587)

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

3.0 N/mm

Glass transition temperature (DSC)

Cure: 24 hours at 23°C plus 1 hour at 80°C:

ca. 85°C

Shear modulus (DIN 53445)

Cure: 16 hours/40°C

50°C - 1.2 GPa
 75°C - 400 MPa
 100°C - 180 Mpa
 125°C - 20 Mpa

E - modulus (ISO R527) at 23°C

4 GPa

Flexural Properties (ISO 178) Cure 16 hours/ 40°C Cure 1 day/ 23°C +30mins/ 80°C tested at 23°C

Flexural Strength 61 MPa

Flexural Modulus 4355 MPa

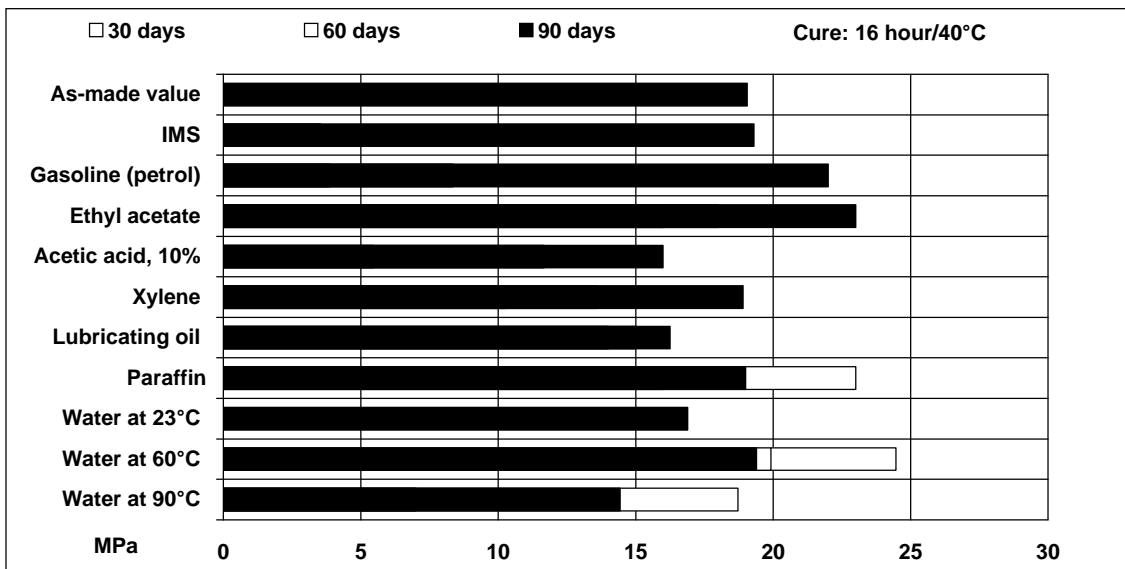
Tensile strength (ISO R527) at 23°C 26 MPa

Elongation at break 0,7%

Additional electrical properties	Test values	Test methods
Dielectric strength (Volt/mil)	440	ASTM D-149
Surface resistivity (Ohm)	7.0 E+15	IEC 60093
Volume resistivity (Ohm-cm)	6.1 E+15	IEC 60093
Dielectric constant at 60Hz	4.0	IEC 60250
Loss tangent, % at 60Hz	1.0	IEC 60250

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

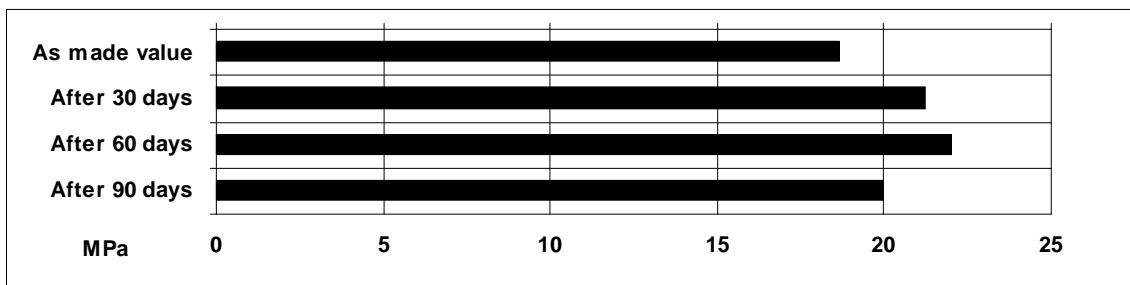
Unless otherwise stated, L.S.S. was determined after immersion for 90 days at 23°C



Lap shear strength versus tropical weathering

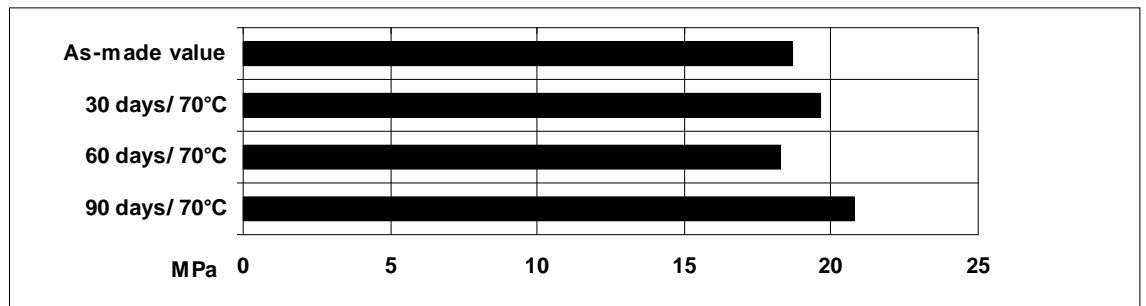
(40/92, DIN 50015; typical average values)

Cure: 16 hours/40°C Test: at 23°C



Lap shear strength versus heat ageing

Cure: 16 hours/40°C



Storage

Araldite® AW 139-1 and Hardener HW 5323 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**

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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