

**Advanced Materials****Araldite® 2023-60****Structural Adhesives****TECHNICAL DATASHEET****Araldite® 2023-60****Two component toughened methacrylate adhesive system****Key properties**

- 60 minutes open time at RT
- Gap filling up to 30 mm
- Bright grey color, UV stable
- Tough flexible bonds for use in dynamic environments
- Elongation at break of 100%

**Description**

Araldite® 2023-60 is a two component, room temperature curing, flexible, methacrylate adhesive with an open time of 60 minutes. It is a thixotropic paste which can fill gaps up to 30 mm. This adhesive is ideal for bonding composites for the manufacturing of large structures.

**Product data**

Properties	Araldite® F 323-60 MIN	Hardener F 323	Mixed adhesive
Colour (visual)	White	Black	Bright grey
Specific gravity	ca. 1.08	ca. 1.17	ca. 1.09
Viscosity at 25°C (Pa.s)	160 – 200	80 - 120	non-sagging
Pot life (20 gr. at 25°C)	-	-	75 - 95 minutes
Open time	-	-	> 60 minutes
Lap shear strength at 25°C (A501)*	-	-	> 12 MPa
Time to peak exotherm (20gr) (A159)*	-	-	90 - 120 minutes

\* Specified data are on a regular basis analysed. Data which is described in this document as 'typical' 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.

**Processing****Pretreatment**

The strength and durability of a bonded joint are dependent on proper pretreatment of the surfaces to be bonded, however the methacrylate adhesives can be used effectively with little surface preparation. Ideally 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.

Mix ratio	Parts by weight	Parts by volume
Araldite® F 323-60 MIN	100	100
Hardener F 323	10 - 11	10

**Application of adhesive**

This system 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. Because of the high viscosity of the product, it is recommended to use a pneumatic dispensing gun. To ease the use with a manual dispensing gun, the cartridges can be preheated at 40°C during minimum 1 hour, if possible 2 hours before use.

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 0.25 mm thick will normally impart the greatest lap shear strength to the joint. The joint components should be assembled and secured in a fixed position as soon as the adhesive has been applied.

**Warning:** the cure reaction can generate a high amount of heat, it is not recommended to mix large amounts of material at room temperature.

For more detailed explanations regarding surface preparation and pretreatment, adhesive joint design, and the dual cartridge dispensing system, visit [www.aralditeadhesives.com](http://www.aralditeadhesives.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 MEK are used for cleaning, operatives should take the appropriate precautions and, in addition, avoid skin and eye contact.

**Typical times to minimum shear strength on sandblasted aluminium / contact pressure**

Temperature	°C	10°C	23°C	40°C
Cure time to reach	hours	5		
LSS > 1MPa	minutes		100	45
Cure time to reach	hours	7	2	
LSS > 10MPa	minutes			60

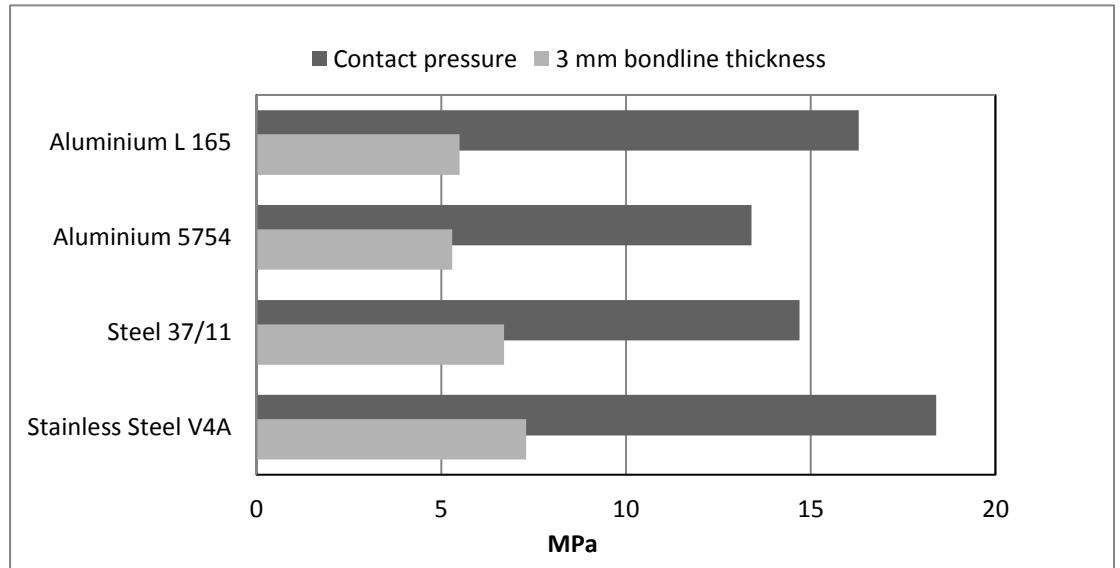
## Typical cured properties

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. 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) (typical average values)

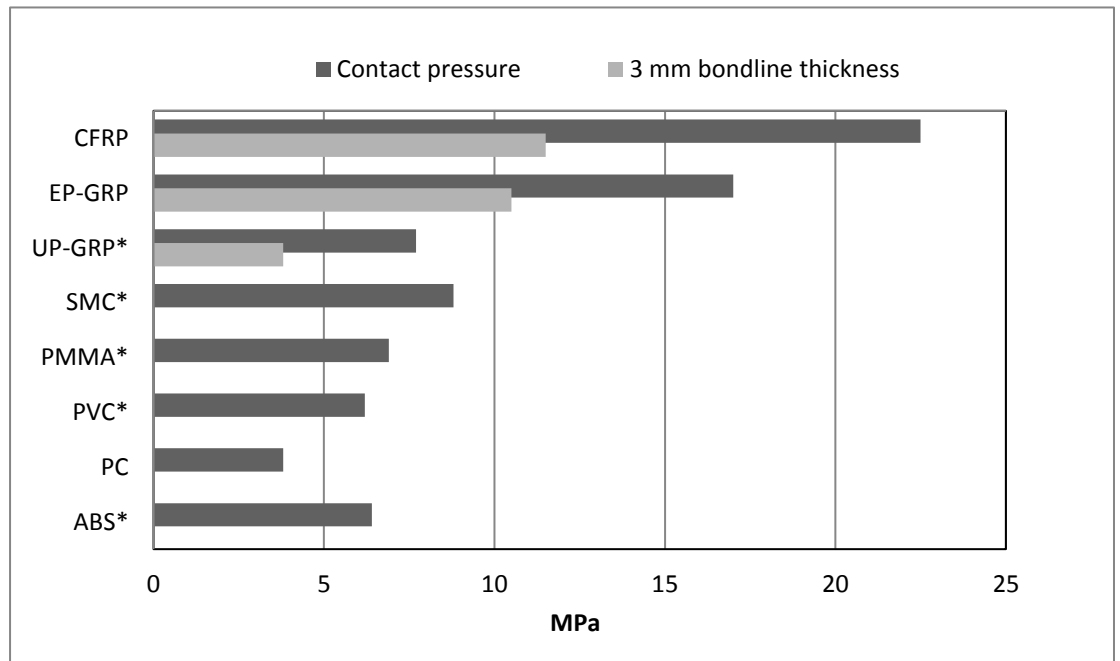
Cured for 24 hours at RT and tested at 23°C, substrates sandblasted and degreased with acetone.



Note: Araldite® 2023-60 is not suitable to bond galvanized steel, copper and copper alloys.

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

Cured for 24 hours at RT and tested at 23°C. Substrates abraded and degreased with isopropanol.



(\*): UP-GRP, SMC; PMMA, PVC, substrate failure observed.

**Yellowing under UV light (Typical average values)**

Cure 7 days at RT

No yellowing after 1000 hours Atlas Suntest XLS+ / 500 W/m<sup>2</sup>

**Glass Transition Temperature (DMA) (Typical average values)**

Cure 7 days at RT

Onset 49°C

Midpoint 81°C

**Tensile Properties (ISO 527) (Typical average values)**

Cure 7 days at RT and test at 23°C

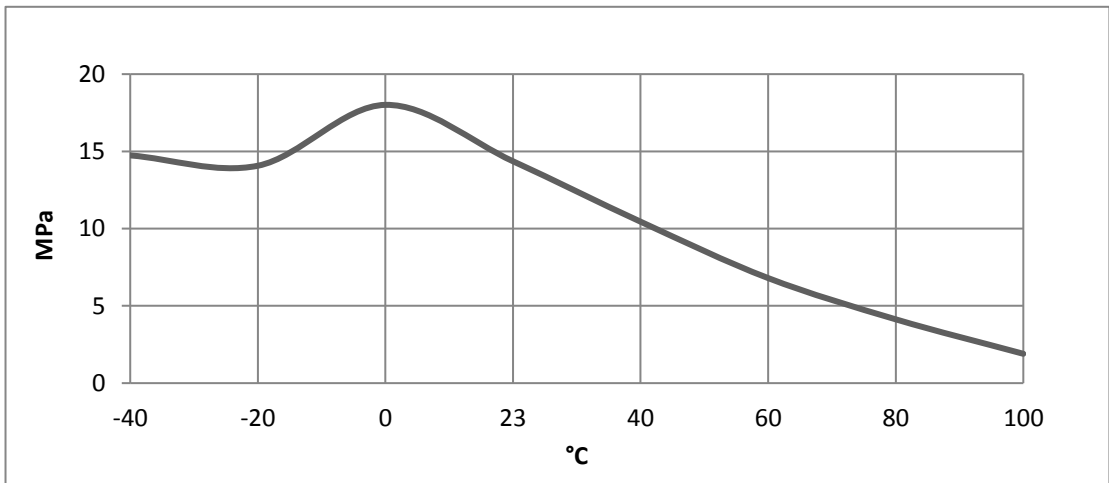
Tensile Strength 21 MPa

Tensile Modulus 700 - 800 MPa

Elongation at break ca. 100%

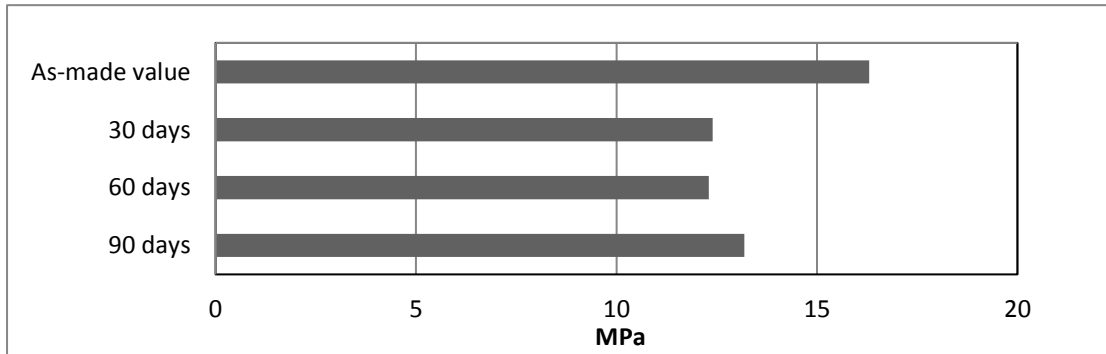
**Lap shear strength versus temperature (ISO 4587) (typical average values)**

On aluminium, pretreatment: sand blasting. Cure: 24 hours at RT.



**Lap shear strength versus tropical weathering (ISO 4587) (typical average values)**

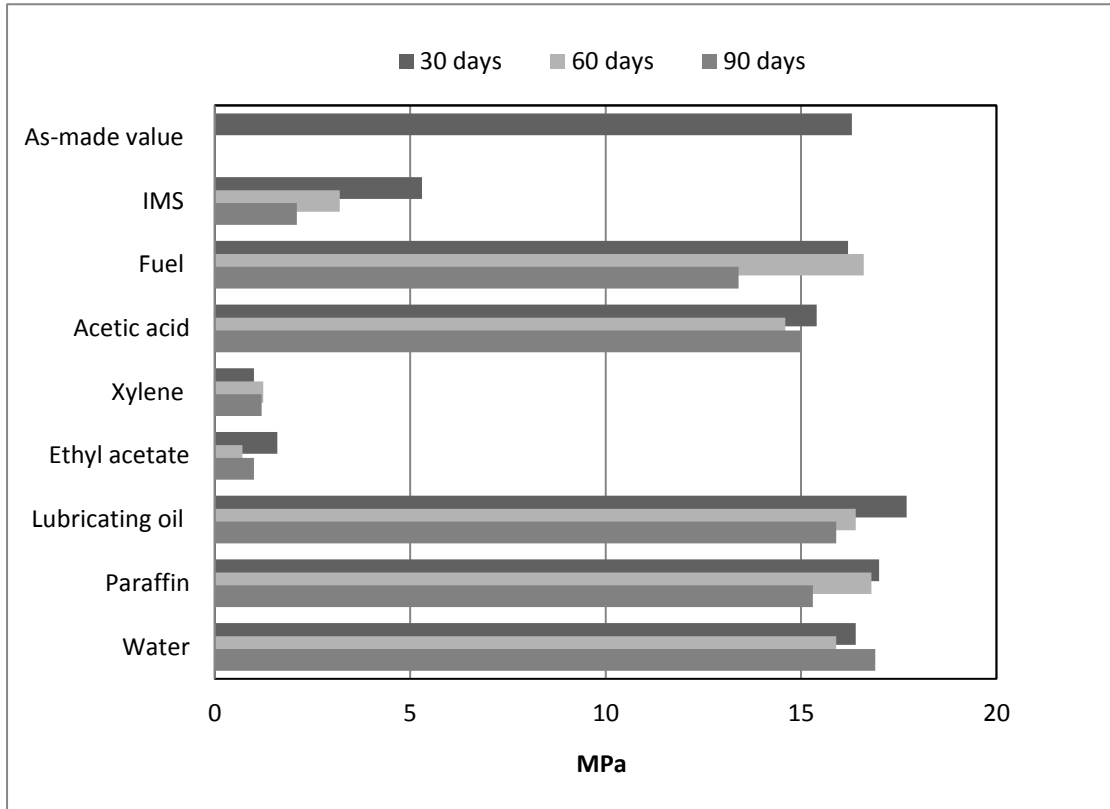
Aging at 40°C / 92% RH. Cure: 7 days at RT. Test at 23°C



**Lap shear strength versus immersion in various media (ISO4587) (typical average values)**

Cure: 7 days at RT Tested at 23°C.

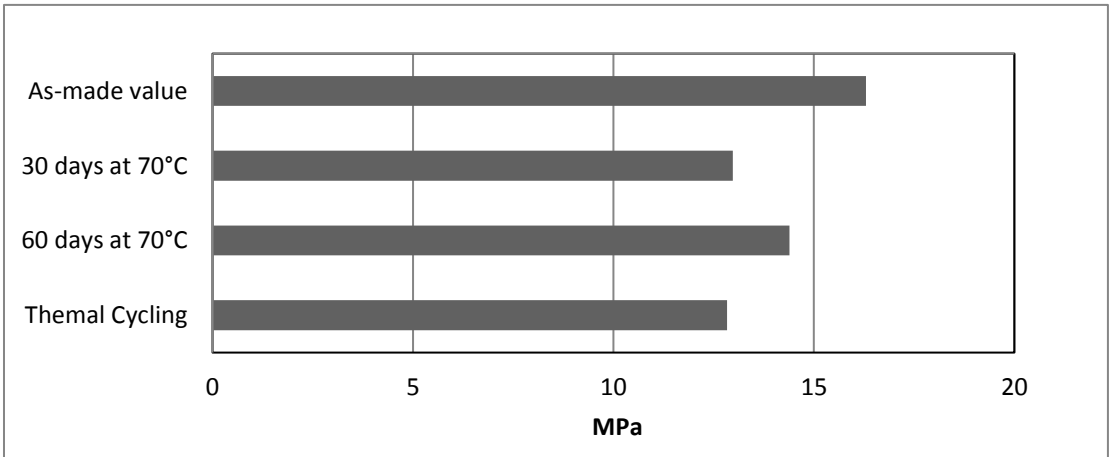
Lap Shear Strength was determined after immersion for 30, 60 and 90 days at 23°C.



**Lap shear strength versus heat ageing and thermal cycling (typical average values)**

Cure: 7 days at RT. Test at 23°C

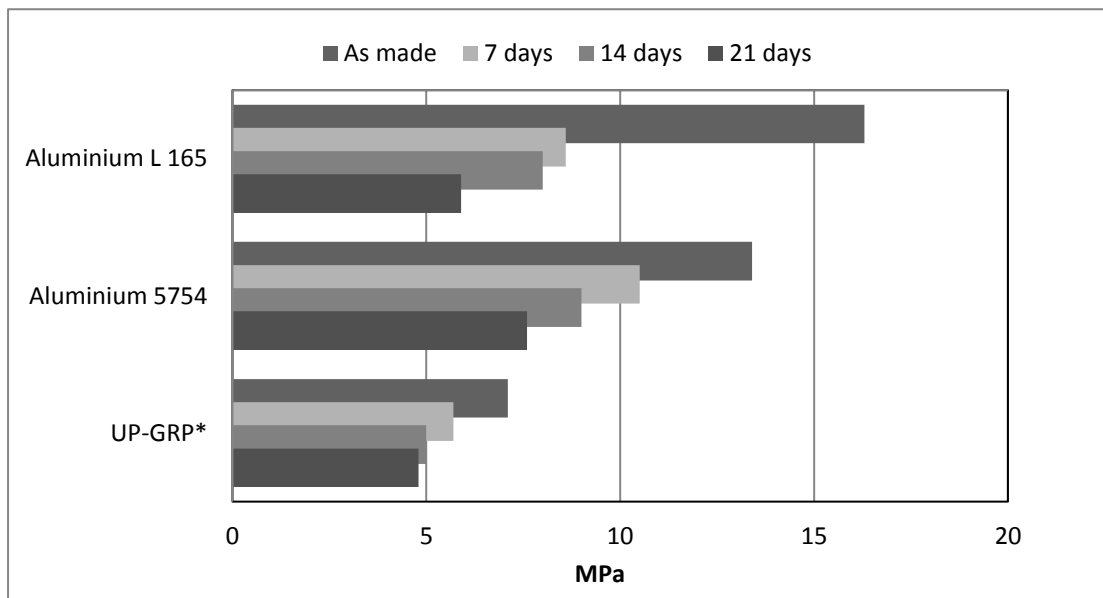
Thermal cycling 100 cycles ( 2h -30°C / 1 h up to 70°C / 2h 70°C / 1h down to -30°C)



### Lap shear strength versus Cataplasma ageing (typical average values)

Cure 7 days at RT – Cataplasma according to ISO 9142/E2 - Test: at 23°C

Metals sandblasted and degreased / plastics abraded and degreased



(\*): UP-GRP: substrate failure observed

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**Storage**

The resin Araldite® F323-60 may be stored during 24 months at 2 – 8°C or 12 months at 8 – 25°C provided the component is stored in the original sealed container. The expiry date is indicated on the label assuming a storage at 2 – 8°C (24 months).

The Hardener F 323 may be stored during 18 months at 2 – 8°C or 6 months at 8 – 25°C provided the component is stored in the original sealed container. The expiry date is indicated on the label assuming a storage at 8 - 25°C (6 months).

The cartridges of Araldite® 2023-60 may be stored during 18 months at 2 – 8°C or 6 months at 8 – 25°C provided the components are stored in the original sealed containers. The expiry date is indicated on the label assuming a storage at 2 - 8°C (18 months).

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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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