

A total solution to high performance adhesive bonding

One stop shop technology for structural bonding of plastics

• Fully comprehensive range of structural adhesives

The Araldite® 2000 PLUS range adhesives can be used under a broad spectrum of processing and curing conditions while meeting the most demanding performance requirements. The range includes leading-edge epoxy, polyurethane and toughened acrylic technologies providing a complete solution to structural bonding.

• Broad range of easy to use packing sizes

Araldite® 2000 PLUS adhesives are available in a wide range of cartridge systems and small packs for convenient handling. These options allow the user to accurately deliver a measured quantity of adhesive with minimum waste.

• Local availability

No matter where you are in the world, Huntsman's strong global network means Araldite® 2000 PLUS adhesives can be supplied locally. Our operations span 30 countries and are supported by an established worldwide distribution framework.

Setting the industry standard for technical support

• Comprehensive telephone technical support

Huntsman sets the standard for technical support. Its industry experts can provide advice at a local level and can rapidly respond to customer challenges.

• On site technical assistance

Our network of technical support staff can give on site demonstrations and provide expert advice to find the best solution for a range of technical challenges.

• Access to significant case history database

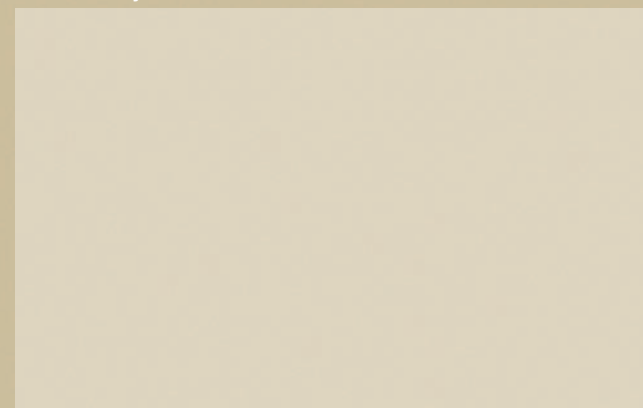
The Araldite® 2000 PLUS range can be used across a vast range of structural engineering applications. Sample case studies from our extensive library available on our website www.araldite2000plus.com.

• Additional reference guides available

Araldite® brand product has been a leading adhesive brand for 60 years. Our experience is reflected in our comprehensive technical support packages which can be accessed through our website. Araldite® 2000 PLUS provides a complete solution to all adhesive processing and performance needs.



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EUROPE / AFRICA

Huntsman Advanced Materials (Switzerland) GmbH
Klybeckstrasse 200
P.O. Box
4002 Basel
Switzerland
Tel +41 61 966 41 20
Fax +41 61 966 35 19

INDIA / MIDDLE EAST

Huntsman Advanced Materials (India) Pvt. Ltd
5th Floor, Bldg. No. 10
Solitaire Corporate Park
167, Guru Hargovindji Marg, Chakal Andheri (East)
Mumbai - 400 093
India
Tel +91 22 4095 1556 - 60
Fax +91 22 4095 1300/1400/1500

ASIA / PACIFIC

Huntsman Advanced Materials (Hong Kong) Ltd
Suites 3 - 12, Level 41
Langham Place
8 Argyle Street
Kowloon
Hong Kong
Tel +852 2148 8800
Fax +852 2424 1741

AMERICAS

Huntsman Advanced Materials Americas Inc.
10003 Woodloch Forest Drive
The Woodlands,
Texas 77380
USA
Tel +1 888 564 9318
Fax +1 281 719 4047

More detailed information about these products can be found on our website: www.araldite2000plus.com

For any other information, please send an e-mail to: araldite2000plus@huntsman.com

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Design : www.zygmund.fr

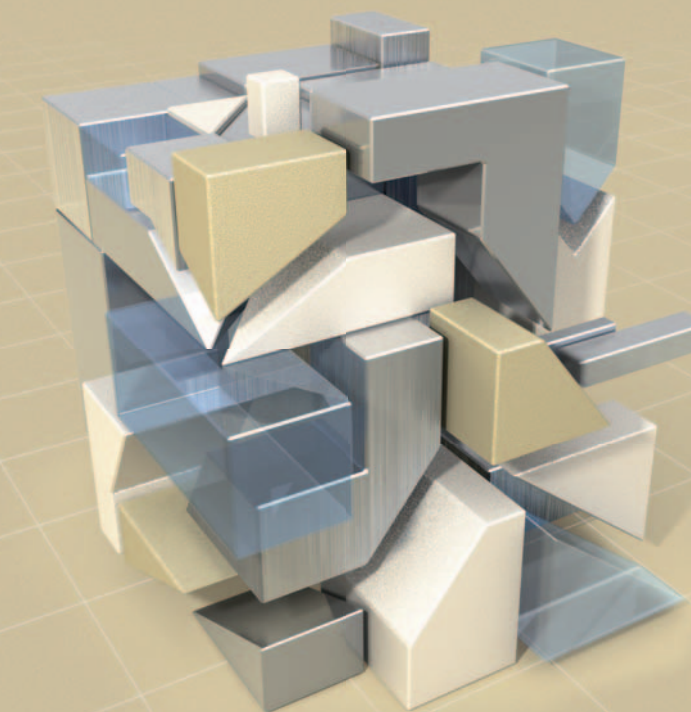
Araldite® 2000+

Strength in bonding

HUNTSMAN

Enriching lives through innovation

bonding **plastics**
to metals and dissimilar substrates



The appropriate solution for

Bonding plastics to any substrates

Huntsman's recognized expertise in research and development allows us to offer a uniquely wide range of innovative solutions all of which are backed by strong technical support and excellent levels of customer service. Araldite® 2000 PLUS adhesives are designed to satisfy all your plastic bonding requirements.

	2011	2010-1	2012	2013	2014	2015	2021	2022	2018	2040	2041-1	2055
	Multi purpose	Rapid cure		Chemical / temperature resistance		Toughened			Flexible			Rigid
Chemical type	EP	EP	EP	EP	EP	EP	MMA	MMA	PUR	PUR	PUR	PUR
Fast curing		■	■				■	■				
Gap filling				■	■	■	■	■	■	■	■	■

BONDING PLASTICS TO PLASTICS

	2011	2010-1	2012	2013	2014	2015	2021	2022	2018	2040	2041-1	2055
GRP	●	○	●	●	●	●	●	●	●	●	●	●
CFP	●	●	●	●	●	●	●	●	○	○	●	○
SMC	●	○	○	●	●	●	○	○	●	○	●	●
ABS	●	○	○	○	○	○	○	●	●	○	●	●
PVC	○	○	○	○	○	○	●	●	○	○	○	●
PMMA	○	○	○	○	○	●	●	●	○	○	●	○
Polycarbonate	○	○	○	○	○	○	●	●	●	●	●	○
Polyamides	●	○	○	○	○	○	●	○	○	○	●	○

BONDING PLASTICS TO METALS

	2011	2010-1	2012	2013	2014	2015	2021	2022	2018	2040	2041-1	2055
Ferrous metals	●	○	●	●	●	●	●	●	○	○	○	○
Stainless steel	●	●	●	●	●	●	●	●	○	○	○	●
Aluminium	●	●	●	●	●	●	●	●	○	○	○	●
Copper	●	●	●	●	●	●	●	○	○	○	○	●
Brass	●	●	●	●	●	●	●	●	○	○	○	○
Zinc / Galvanized metal	●	●	○	●	●	○	○	●	○	○	○	●

BONDING PLASTICS TO NON METALS

	2011	2010-1	2012	2013	2014	2015	2021	2022	2018	2040	2041-1	2055
Rubbers	○	○	○	○	○	○	○	○	○	○	○	○
Glass	○	○	○	○	○	○	○	○	○	○	○	○
Ceramics	●	○	●	●	○	○	●	●	○	○	○	○
Wood	●	●	●	●	●	●	○	○	●	○	●	●

EP Epoxy / MMA Methyl Methacrylate / PUR Polyurethane • ● Excellent / ○ Good / ○ Moderate



Processing, performance and packaging data

Araldite® 2000 PLUS product is a trusted brand – with more than 60 years experience in developing engineering adhesives.



Bonding plastics	Multi purpose	Rapid cure		Chemical / temperature resistance		Toughened			Flexible			Rigid
	2011	2010-1	2012	2013	2014	2015	2021	2022	2018	2040	2041-1	2055
Chemical type	EP	EP	EP	EP	EP	EP	MMA	MMA	PUR	PUR	PUR	PUR
Product description	<ul style="list-style-type: none"> Multi purpose Long working life Low shrinkage 	<ul style="list-style-type: none"> Fast curing Toughened Low shrinkage 	<ul style="list-style-type: none"> Fast curing General purpose Low shrinkage 	<ul style="list-style-type: none"> Metal colored paste Suitable for vertical applications Low shrinkage 	<ul style="list-style-type: none"> Gray paste High temperature and chemical resistance Low shrinkage 	<ul style="list-style-type: none"> Toughened paste Ideal for GRP, SMC and dissimilar substrates Low shrinkage 	<ul style="list-style-type: none"> Rapid curing High peel strength Multi purpose 	<ul style="list-style-type: none"> Good sanding properties Ideal for bonding thermoplastics 	<ul style="list-style-type: none"> Good UV stability Ideal for bonding thermoplastics Low shrinkage 	<ul style="list-style-type: none"> Ideal for bonding plastics Low shrinkage Ideal for thick bond lines 	<ul style="list-style-type: none"> Rapid cure Black color Ideal for bonding plastics especially SMC & polyamides Low shrinkage 	<ul style="list-style-type: none"> Gap filling Long open time Resists weathering and humidity Low shrinkage

PROCESSING DATA

	2011	2010-1	2012	2013	2014	2015	2021	2022	2018	2040	2041-1	2055
Viscosity (at 73°F)	30k-45k cps	Appr. 80k cps	25k-35k cps	Thixotropic	Thixotropic	Thixotropic	Appr. 45k cps	Appr. 60k cps	Appr. 8k cps	Appr. 50k cps	Appr. 55k cps	Thixotropic
Useable life of adhesive (at 73°F)												
<i>In mixer nozzle</i>	1.8 hr	10 min	8 min	1.3 hr	1 hr	40 min	3 min	10 min	40 min	15 min	15 min	45 min
<i>100 g (0.22 lb) of mix</i>	1.5 hr	6 min	5 min	60 min	1 hr	40 min	-	-	40 min	15 min	15 min	60 min
Time required to reach (at 73°F)												
<i>Light handling strength (145 psi)</i>	7 hr	30 min	20 min	4 hr	3 hr	4 hr	8 min	18 min	4 hr	6 hr	3 hr	6 hr
<i>50% of final shear strength</i>	10 hr	3 hr	1 hr	10 hr	5 hr	6 hr	20 min	30 min	16 hr	20 hr	16 hr	20 hr
Time required to reach (at 140°F)												
<i>50% of final shear strength</i>	45 min	20 min	10 min	40 min	20 min	40 min	-	-	30 min	1.5 hr	60 min	60 min

PERFORMANCE DATA

	2011	2010-1	2012	2013	2014	2015	2021	2022	2018	2040	2041-1	2055
Lap shear strength on GRP substrate	1640 psi	725 psi	1335 psi	1200 psi	1250 psi	1335 psi	1130 psi	1130 psi	1160 psi	1090 psi	1150 psi	1305 psi
Peel strength on Al substrate	28 pli	34 pli	31 pli	22 pli	17 pli	23 pli	62 pli	22 pli	22 pli	22 pli	34 pli	6 pli
Typical Tg / max temp giving LSS of 725 psi	113°F / 194°F	104°F / 176°F	104°F / 176°F	113°F / 158°F	185°F / 266°F	149°F / 230°F	149°F / 230°F	113°F / 212°F	Flex / 104°F	86°F / 122°F	86°F / 122°F	140°F / 194°F
Resistance properties												
<i>Chemical</i>	○	○	○	●	●	○	○	●	○	○	○	○
<i>Heat</i>	○	○	○	○	●	○	●	○	○	○	○	○
<i>Water</i>	○	○	○	○	○	○	○	○	○	○	○	○
<i>Impact</i>	●	●	○	○	○	○	●	●	●	●	●	○

PACKAGING

	2011	2010-1	2012	2013	2014	2015	2021	2022	2018	2040	2041-1	2055
Cartridges												
<i>50 ml</i>	■	■	■	■	■	■	■	■	■	■	■	■
<i>200 ml</i>	■	■	■	■	■	■	■	■	■	■	■	■
<i>400 ml</i>												
<i>500 ml</i>												
Working packs (1.8 kg (4 lb) kits)	■	■	■	■	■	■	■	■	■	■	■	■

A total solution to high performance adhesive bonding

One stop shop technology for structural bonding of metals

- **Fully comprehensive range of structural adhesives**

Araldite® 2000 PLUS adhesives for metals can be used under a broad spectrum of processing and curing conditions while meeting the most demanding performance requirements. The range includes leading-edge epoxy, polyurethane and toughened acrylic technologies providing a complete solution to structural bonding.

- **Broad range of easy to use packing sizes**

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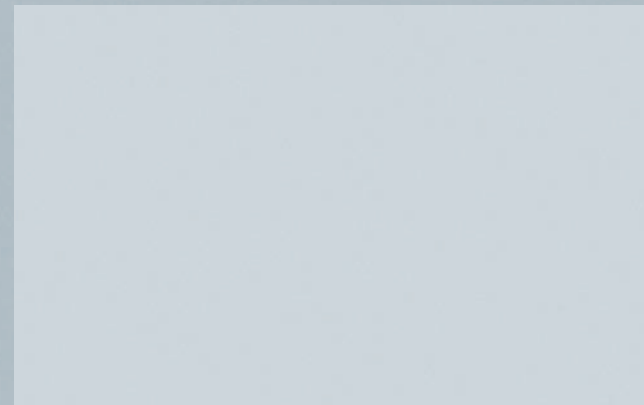
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EUROPE / AFRICA

Huntsman Advanced Materials
(Switzerland) GmbH
Klybeckstrasse 200
P.O. Box
4002 Basel
Switzerland
Tel +41 61 966 41 20
Fax +41 61 966 35 19

INDIA / MIDDLE EAST

Huntsman Advanced Materials
(India) Pvt. Ltd
5th Floor, Bldg. No. 10
Solitaire Corporate Park
167, Guru Hargovindji Marg, Chakal
Andheri (East)
Mumbai - 400 093
India
Tel +91 22 4095 1556 - 60
Fax +91 22 4095 1300/1400/1500

ASIA / PACIFIC

Huntsman Advanced Materials
(Hong Kong) Ltd
Suites 3 - 12, Level 41
Langham Place
8 Argyle Street
Kowloon
Hong Kong
Tel +852 2148 8800
Fax +852 2424 1741

AMERICAS

Huntsman Advanced Materials
Americas Inc.
10003 Woodloch Forest Drive
The Woodlands,
Texas 77380
USA
Tel +1 888 564 9318
Fax +1 281 719 4047

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Design : www.zygmund.fr

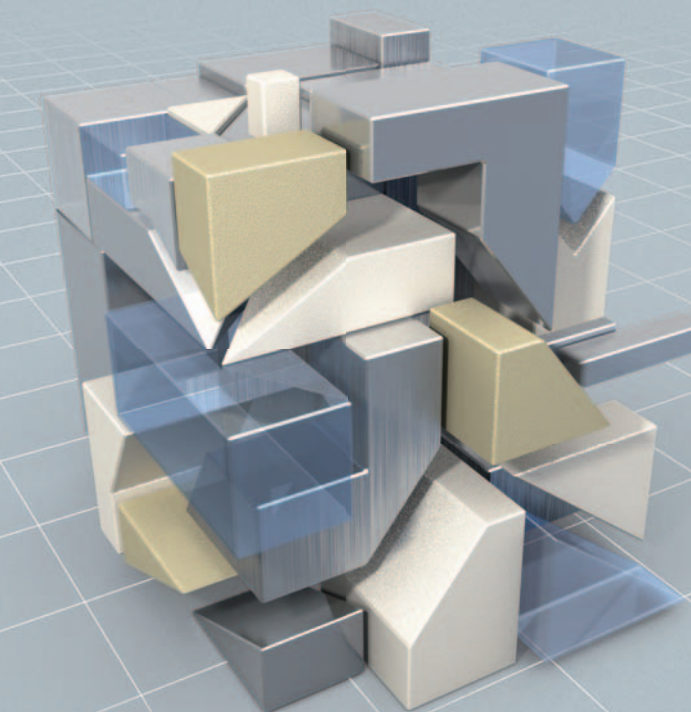
Araldite® 2000+

Strength in bonding

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bonding **metals**
to metals and dissimilar substrates



The appropriate solution for

Bonding metals to any substrates

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	2011	2010-1	2012	2013	2014	2015	2021	2022	2055
Chemical type	EP	EP	EP	EP	EP	EP	MMA	MMA	PUR
Fast curing		■	■				■	■	
Gap filling				■	■	■	■	■	■

BONDING METALS TO METALS

	2011	2010-1	2012	2013	2014	2015	2021	2022	2055
Ferrous metals	●	○	●	●	●	●	●	●	○
Stainless steel	●	●	●	●	●	●	●	●	●
Aluminum	●	●	●	●	●	●	●	●	●
Copper	●	●	●	●	●	●	●	○	●
Brass	●	●	●	●	●	●	●	●	○
Zinc / Galvanized metal	●	●	○	●	●	○	○	●	●

BONDING METALS TO PLASTICS

	2011	2010-1	2012	2013	2014	2015	2021	2022	2055
GRP	●	○	●	●	●	●	●	●	●
CFRP	●	●	●	●	●	●	●	●	○
SMC	●	○	○	●	●	●	○	○	●
ABS	●	○	○	○	○	○	○	●	●
PVC	○	○	○	○	○	○	●	●	●
PMMA	○	○	○	○	○	●	●	●	○
Polycarbonate	○	○	○	○	○	○	●	●	○
Polyamides	●	○	○	○	○	○	●	○	○

BONDING METALS TO NON-METALS

	2011	2010-1	2012	2013	2014	2015	2021	2022	2055
Rubbers	○	○	○	○	○	○	○	○	○
Glass	○	○	○	○	○	○	○	○	○
Ceramics	●	○	●	●	○	○	●	●	○
Wood	●	●	●	●	●	●	○	○	●

EP Epoxy / MMA Methyl Methacrylate / PUR Polyurethane / ● Excellent / ○ Good / ○ Moderate



Processing, performance and packaging data

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Bonding metals	Multi purpose		Rapid cure		Chemical / temperature resistance		Toughened			Rigid
	2011	2012	2010-1	2012	2013	2014	2015	2021	2022	2055
Chemical type	EP	EP	EP	EP	EP	EP	EP	MMA	MMA	PUR
Product description	<ul style="list-style-type: none"> Multi purpose Long working life Low shrinkage 	<ul style="list-style-type: none"> Fast curing Toughened Low shrinkage 	<ul style="list-style-type: none"> Fast curing General purpose Low shrinkage 	<ul style="list-style-type: none"> Metal colored paste Suitable for vertical applications Low shrinkage 	<ul style="list-style-type: none"> Gray paste High temperature and chemical resistance Low shrinkage 	<ul style="list-style-type: none"> Toughened paste Ideal for GRP, SMC and dissimilar substrates Low shrinkage 	<ul style="list-style-type: none"> Rapid curing High peel strength Multi purpose 	<ul style="list-style-type: none"> Good sanding properties Ideal for bonding thermoplastics 	<ul style="list-style-type: none"> Gap filling Long open time Resists weathering and humidity Low shrinkage 	
PROCESSING DATA	30k-45k cps		Appr. 80k cps	25k-35k cps	Thixotropic	Thixotropic	Thixotropic	Appr. 45k cps	Appr. 60k cps	Thixotropic
Viscosity (at 73°F)	30k-45k cps		Appr. 80k cps	25k-35k cps	Thixotropic	Thixotropic	Thixotropic	Appr. 45k cps	Appr. 60k cps	Thixotropic
Useable life of adhesive (at 73°F)	30k-45k cps		Appr. 80k cps	25k-35k cps	Thixotropic	Thixotropic	Thixotropic	Appr. 45k cps	Appr. 60k cps	Thixotropic
<i>In mixer nozzle</i>	1.8 hr	8 min	10 min	8 min	1.3 hr	1 hr	40 min	3 min	10 min	45 min
<i>100 g (0.22 lb) of mix</i>	1.5 hr	5 min	6 min	5 min	60 min	1 hr	40 min	-	-	60 min
Time required to reach (at 73°F)	30k-45k cps		Appr. 80k cps	25k-35k cps	Thixotropic	Thixotropic	Thixotropic	Appr. 45k cps	Appr. 60k cps	Thixotropic
<i>Light handling strength (145 psi)</i>	7 hr	20 min	30 min	20 min	4 hr	3 hr	4 hr	8 min	18 min	6 hr
<i>50% of final shear strength</i>	10 hr	1 hr	3 hr	1 hr	10 hr	5 hr	6 hr	20 min	30 min	20 hr
Time required to reach (at 140°F)	30k-45k cps		Appr. 80k cps	25k-35k cps	Thixotropic	Thixotropic	Thixotropic	Appr. 45k cps	Appr. 60k cps	Thixotropic
<i>50% of final shear strength</i>	45 min	10 min	20 min	10 min	40 min	20 min	40 min	-	-	60 min
PERFORMANCE DATA	30k-45k cps		Appr. 80k cps	25k-35k cps	Thixotropic	Thixotropic	Thixotropic	Appr. 45k cps	Appr. 60k cps	Thixotropic
Lap shear strength on Al substrate	2755 psi	2755 psi	3335 psi	2755 psi	2610 psi	2610 psi	2465 psi	3190 psi	3625 psi	1305 psi
Peel strength on Al substrate	28 pli	31 pli	34 pli	31 pli	22 pli	17 pli	23 pli	62 pli	22 pli	6 pli
Typical Tg / Max temp giving LSS of 725 psi	113°F / 194°F	104°F / 176°F	104°F / 176°F	104°F / 176°F	113°F / 158°F	185°F / 286°F	149°F / 230°F	149°F / 230°F	113°F / 212°F	140°F / 194°F
Resistance properties	30k-45k cps		Appr. 80k cps	25k-35k cps	Thixotropic	Thixotropic	Thixotropic	Appr. 45k cps	Appr. 60k cps	Thixotropic
<i>Chemical</i>	○	○	○	○	●	●	○	○	○	○
<i>Heat</i>	○	○	○	○	○	○	○	○	○	○
<i>Water</i>	○	○	○	○	○	○	○	○	○	○
<i>Impact</i>	●	○	●	○	○	○	○	●	●	○
PACKAGING	30k-45k cps		Appr. 80k cps	25k-35k cps	Thixotropic	Thixotropic	Thixotropic	Appr. 45k cps	Appr. 60k cps	Thixotropic
Cartridges	30k-45k cps		Appr. 80k cps	25k-35k cps	Thixotropic	Thixotropic	Thixotropic	Appr. 45k cps	Appr. 60k cps	Thixotropic
<i>50 ml</i>	■	■	■	■	■	■	■	■	■	■
<i>200 ml</i>	■	■	■	■	■	■	■	■	■	■
<i>400 ml</i>	■	■	■	■	■	■	■	■	■	■
<i>500 ml</i>	■	■	■	■	■	■	■	■	■	■
Working packs (1.8 kg kits) (4 lb kits)	■	■	■	■	■	■	■	■	■	■